

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013958**Date Inspected:** 07-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1130**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Tony Sherwood**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Sections**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and to monitor American Bridge/Fluor (ABF) welding operations.

The following observations were made:

- 1) Repair welding was being performed at E3/E4 – F –inside; ABF welding personnel Mitch Sittinger (#0315) and QC Inspector Tony Sherwood.
- 2) Weld E4/E5-A1 thru A5 fit up was in progress.

At E3/E4 – F -inside this QA Inspector randomly observed QC Inspector Tony Sherwood monitoring repair welding using the Shielded Manual Arc Welding (SMAW) process by ABF welding personnel Mitch Sittinger (#0315). This QA Inspector randomly observed QC Inspector Tony Sherwood perform a visual and MT inspection of an excavation prior to welding. QC Inspector Tony Sherwood informed this QA Inspector the excavation was accepted; this QA Inspector performed a visual verification of the excavation and the work appeared to comply with the contract requirements. This excavation was approximately 85 mm long, 15 mm wide, 11 mm deep and 95 mm from the side plate (E). This QA Inspector observed QC Inspector Tony Sherwood verify the following welding parameters prior to the start of repair welding: 127 amperes using a 3.2 mm diameter E7018 electrode. The welding observed appeared to comply with WPS - ABF-WPS-D15-1001-Repair. Welding was still being performed at this location at the end of this QA Inspector's shift.

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At weld joint E4/E5-A1 thru A5 this QA Inspector observed various ABF personnel in the process of adjusting the wedges of fit up clamps (dogs) in an effort to align the two deck plates, welding was not observed at this location during this QA Inspector's shift. This QA Inspector randomly observed QC Inspector Bonifacio Daquinag Jr. monitoring and checking the offset between the two deck plates as work progressed.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
