

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013988**Date Inspected:** 12-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Bernard Docena, Bnifacio Daquina			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:	SAS OBG		

Summary of Items Observed:

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above. The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified as 2W/3W-E, 1W/2W-C/D and the following observations were made:

2W/3W-E2

The QA Inspector randomly observed the ABF welders had previously started the induction heating blankets to ensure the minimum required preheat of 150°F was achieved prior to welding. The QA Inspector randomly verified utilizing a 150°F temperature indicating marker and noted the minimum required preheat had been achieved. The SE QC Inspector Bernard Docena and the QA Inspector performed visual testing of the fit up of the above identified weld joint. It was observed by both Inspectors the fit up of the above identified weld joint appeared to be in general compliance with the contract requirements. The QA Inspector randomly observed the SE QC Inspector identified as Bernard Docena set the FCAW machine to the parameters of the approved WPS. The QA Inspector randomly observed the FCAW parameters were 252Amps 22.8Volts and a travel speed of 195mm/min. The QA Inspector randomly observed the ABF welder Song Toa Huang continues the FCAW fill/cover pass. The QA Inspector noted the ABF welder was performing the FCAW fill passes for the remainder of the QA Inspectors shift. The QA Inspector noted the ABF welder will completed the accessible area of the weld segment E2 by the end of the ABF day shift on this date. The QA Inspector noted the approximately 1000mm of weld joint remains to be completed due to the splice plates and drift pins still in place.

1W/2W-C1/C2

The QA Inspector randomly observed the ABF welders Rory Hogan and Jeremy Doleman performing plasma arc

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gouging of the above identified weld joint. The QA Inspector noted the weld joint was previously completed from the inside and the ABF welder were actively performing the back gouge. The QA Inspector noted the steel backing bar was still partially in place in weld segment C2. The QA Inspector randomly observed the ABF welder Jeremy Doleman performing grinding tasks in weld segment C1 cleaning and blending the back gouged weld joint.

1W/2W-D/S

The QA Inspector randomly observed the ABF welders Chun Fai Tsui and James performing grinding tasks of the longitudinal stiffeners. The QA Inspector noted approximately 10 of the 18 stiffener plates had been previously back gouged and the round bar stock removed. The QA Inspector noted the ABF welders spent the majority of the QA Inspectors shift performing grinding tasks grinding and blending the back gouged weld joint to bright metal in preparation of back welding. The QA Inspector noted no production welding was performed on the QA Inspectors shift.

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:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
