

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013990**Date Inspected:** 14-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See Below**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:** Orthotropic Box Girders (OBG)**Summary of Items Observed:**

Quality Assurance inspector (QA) Michael Foerder was at the American Bridge/Flour (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. OBG Field Splice 3E/4E Face C (Outside)
2. OBG Field Splice 5E/6E Face D (Inside)
3. Project Files

Field Splice 3E/4E Face C (Outside)

The QA inspector periodically observed ABF welding personnel Mitch Sittinger performing grinding operations in order to excavate and remove the rejectable indications previously identified by QC utilizing Ultrasonic Testing (UT). QC inspector Tony Sherwood was noted to be present in order to monitor the progress and adherence to the welding procedure specification designated as ABF-WPS-D1.5-1001 Repair. The excavations were reviewed by the QC inspector and the welder performed the repair utilizing the shielded metal arc welding (SMAW) process and the amps were verified to be 135. The welder completed the repairs at these locations and the work appeared to be in general conformance with the contract documents.

Field Splice 5E/6E Face D (Inside)

The QA inspector periodically observed ABF welding personnel Jordan Hazalaar performing submerged arc welding (SAW) for the intermediate weld passes for Face D from the inside of the OBG. QC inspector Jim Cunningham was noted to be present in order to review the progress and adherence to the WPS designated as

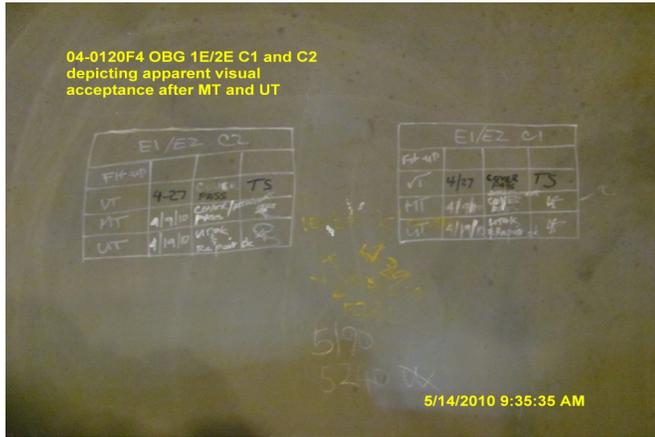
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ABF-WPS-D15-4042B-1. The welding parameters were verified to be 560 amps, 30.5 volts and a measured travel speed of 390mm/min and the pre heat and interpass temperature was noted to be greater than 65° C. The work progressed throughout the shift, was not completed and appeared to be in general conformance with the contract documents.

Project Tracking

The QA inspector performed a random review for a portion of the shift assessing the progress and QC acceptance of the welds which are in various stages of completion. During the review the QA inspector focused on the East bound, South side of the OBG sections. The review was limited to the inside of the box where it was previously agreed upon that the QC department would date and initial when each weld was completed along with the final acceptance for visual and NDT reviews. It was also noted no transverse field joint has been fully completed or accepted as of this date as the Face D welds have pending repairs due to rejectable indications discovered during ultrasonic testing. The welds for the side and edge plates were not reviewed from the outside for the first two splices as access is not possible at this time. The results of the review will be forwarded to the SMR and QA lead upon comparison between the results from the QA inspector and QA inspector Rick Bettencourt.



Summary of Conversations:

As noted above in items observed.

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: Foerder, Mike

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer