

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-013992**Date Inspected:** 13-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 welder Song Tao Huang and Jin Quan Huang performing grinding tasks of the previously completed areas of the weld joint. The QA Inspector randomly observed the SE QC Inspector Bernard Docena had indicated areas which required grinding for excessive weld reinforcement. The QA Inspector randomly observed the ABF welder spend the remainder of the QA Inspectors shift performing the grinding of the areas previously indicated by the QC Inspector. The QA Inspector noted the ABF welder and helper were performing the grinding tasks due to the fact the splice plates near the bottom of the weld joint were still in place. The QA Inspector randomly observed the ABF erection and bolting representative removing the drift pins and temporary bolting for the remainder of the QA Inspectors shift. The QA Inspector noted no production welding was performed on the QA Inspectors shift.

1W/2W-C1/C2

The QA Inspector randomly observed the ABF welders Rory Hogan and Jeremy Doleman performing plasma arc gouging of the above identified weld joint. The QA Inspector noted the weld joint was previously completed from the inside and the ABF welder was 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. The

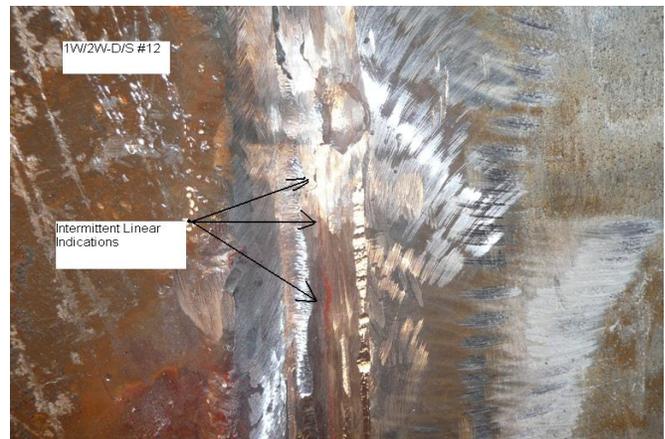
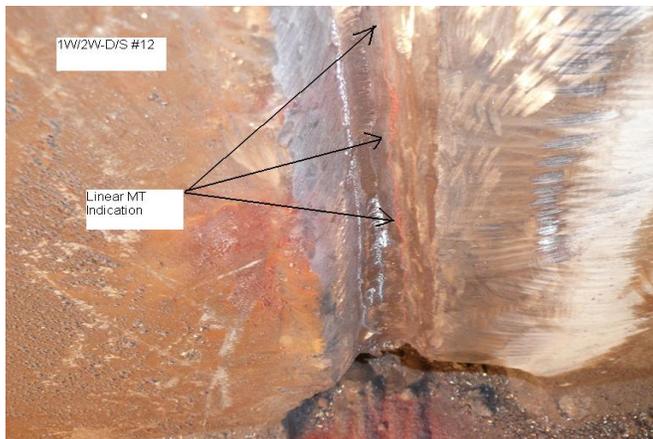
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QA Inspector noted back gouged area was nearly completed. The ABF welder Rory Hogan informed the QA Inspector; during the back gouging process he located and saw many weld defects. Mr. Hogan went on to inform the QA Inspector he dug deeper and deeper in an attempt to remove all of the defects. Mr. Hogan said he would have to remove some of the remaining weld defects seen visibly with a grinder and make some SMAW repairs prior to performing the back weld.

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 backed 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 the SE QC Inspector Tom Pasqualone discovered and indicated intermittent linear indications in the back gouged joint of stiffener #12. The QA Inspector randomly observed the linear indications and noted the indications appeared to be indicative of lack of fusion between weld passes. The QA Inspector was informed by the QC Inspector Tom Pasqualone he did not believe the linear indications to be cracks rather lack of fusion. The QA Inspector randomly observed the QC Inspector and the ABF welder James Zhen spend the remainder of the QA Inspectors shift excavating and removing the linear MT indications. The QA Inspector noted after several attempts of grinding and MT it was observed by the QA Inspector the indications appeared to had been removed by grinding. The QA Inspector noted the SE QC Inspector Jesse Cayabayab was present and performed MT of longitudinal stiffeners #2 and #3 back gouged joint and noted no relevant indications were located at the time of the testing.



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.

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Inspected By: Bettencourt,Rick

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer