

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-014307**Date Inspected:** 20-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Listed Below.		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A
Component:	Orthotropic Box Girders		

Bridge No: 34-0006**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) OBG Lifts 1W/2W - plate F field splice welding
- 2) OBG Lifts 5W & 6W - prep at Pier 7

1) The QAI observed ABF personnel welding the root pass on plate F at OBG lifts 1W/2W field splice. The QAI noted that the Quality Control (QC) Inspector William Sherwood is monitoring this welding. The QAI observed ABF worker Mitch Sittinger, ID 0315, making the weld with shielded metal arc welding (SMAW). The QAI was informed that welding procedure specification (WPS) ABF-WPS-D15-1040B is being used for this welding. The QAI randomly measured the preheat, interpass temperature and welding parameters and noted that they appeared to be conforming to the WPS requirements. The QAI was informed by the QAI Rick Bettencourt that the fit-up had been previously verified and the QAI noted that as the welding progressed upwards, the root was cleaned and fitting aids (temporary attachments) were removed. See the attached photo.

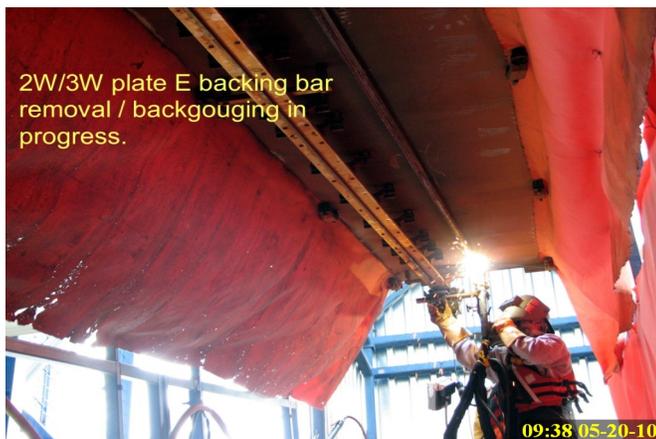
The QAI noted that back welding has been completed on 1W/2W segments C1 and C2. The ABF workers informed the QAI that they will be removing the equipment and preparing to weld at the next available location. The QAI noted that there are no immediate locations ready for back welding and back gouging is being performed on 2w/3W segments E1 and E2. See the attached photo.

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The QAI also observed ABF QC Inspector Steve McConnell conducting Ultrasonic Testing (UT) on 1W/2W segments E1 and E2. The QAI inquired about the condition of the weld and was informed that there were rejectable indications that have been found.

2) The QAI observed ABF activities at the Pier 7 location. The QAI did not observe any Quality Control (QC) Inspectors present. The QAI did not observe ABF personnel around OBG lifts 5W or 6W. The QAI noted that ABF personnel are welding on barges and job related equipment. The QAI also noted that the contractor is assembling parts of the temporary trestle on the barges at Pier 7. The QAI did not observe any personnel welding on bridge components. The QAI also wrote a non-conforming incident report documenting that the contractor is 64 days behind on submitting the contract required documentation of welding. Reference the incident report #44 and the Contract Special Provisions for additional information.



Summary of Conversations:

The QAI relayed the observations of OBG splice welding to the QAI Danny Reyes. The QAI also generated a shift turn-over report with this information. The QAI relayed the observations at Pier 7 and the general status of work observed to the Lead QAI Bill Levell. There were no other notable observations or conversations during this shift.

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:	Croff,Scott	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
