

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-014309**Date Inspected:** 20-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 4E/5E Face A (Outside) Repairs
2. OBG Field Splice 4E/5E Face A (Outside) UT Review

Field Splice 4E/5E Face A (Outside) Repairs

The QA inspector periodically observed ABF welding personnel Rick Clayborn performing excavations and repairs at the following approximate Y locations utilizing a grinder and shielded metal arc welding (SMAW): 0mm, 100mm, 2000mm, 3000mm, 3600mm and 4500mm. QC inspector Tom pascaulone was noted to be present in order to monitor the progress, approve the excavation prior to welding and ensure the welding is in the established parameters of welding procedure specification designated as ABF-WPS-D1.5-1001 Repair. The welding amperage was measured to be 175 and the welder was noted to be utilizing a hand held torch for obtaining the proper pre heat and interpass temperature and was observed performing proper interpass cleaning. The QC inspector was observed verifying and approving the excavations prior to initiating the weld repair and performed informational magnetic particle testing (MT) for assistance in ensuring the indications were removed. The work progressed throughout the QA inspectors shift, was not fully completed and appeared to be progressing within general conformance of the contract documents.

Field Splice 4E/5E Face A (Outside) UT Review

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

The QA inspector performed an ultrasonic testing (UT) review of a representative portion for face A from the outside surface between approximate Y locations designated 24,000mm-26,200mm and 19,800mm-21,200. The QA inspector performed this review prior to the total completion of the pending repairs previously identified by the QC department for this weld joint and it is noted the contractor is in the process of performing these repairs in a different location from where the QA inspector was stationed. The QA inspector performed the review utilizing a zero degree transducer in order to check for laminar reflectors and a 70 degree transducer and wedge combination for the shear wave examination. No rejectable indications were noted at the time of review and a TL-6027 will be generated for this item for this date.

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
