

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-014388**Date Inspected:** 25-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 (Inside) VT review
2. OBG Field Splice 3E/4E Face E (Inside) VT review
3. OBG Field Splice 4E/5E Face D (Inside)
4. OBG Field Splice 5E/6E Face A (Outside)
5. OBG Field Splice 2W/3W Face E (Outside)

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

The QA inspector periodically observed ABF welding personnel Jordan Hazalaar performing minor grinding and blending of areas identified by QC inspector Bonafacio Daquinag. The QC inspector relayed to the QA inspector he was performing a final visual review for weld face C for the inside of the OBG. Upon completion of the areas identified by the QC inspector, the QA inspector performed a random visual review and marked three additional locations for minor grinding due to excessive reinforcement and start/stops. The QC inspector relayed this to the welder and the areas were removed by grinding and the QC and QA inspectors placed a distinguishing mark adjacent to the area for tracking purposes.

Field Splice 3E/4E Face E (Inside)

The QA inspector periodically observed ABF welding personnel Jordan Hazalaar performing minor grinding and

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blending of areas identified by QC inspector Bonafacio Daquinag. The QC inspector relayed to the QA inspector he was performing a final visual review for weld face E for the inside of the OBG. Upon completion of the areas identified by the QC inspector, the QA inspector performed a random visual review and the QC and QA inspectors placed a distinguishing mark adjacent to the area for tracking purposes.

Field Splice 4E/5E Face D (Inside)

The QA inspector periodically observed ABF welding personnel Jordan Hazalaar performing shielded metal arc welding (SMAW) for the balance of the weld face designated D1. This area was held off from the submerged arc welding (SAW) process due to limited access issues and the contractor has elected to complete this area by manual welding in lieu of semi automatic. QC inspector Bonafacio Daquinag was noted to be present in order to monitor the progression and adherence to the WPS identified as ABF-WPS-D15-1040C. The pre heat and interpass temperature was verified to be within the established guidelines and the welding parameters were verified to be 165 amps for Mr. Hazalaar. The welder completed the work at the North side of the weld face and proceeded to perform minor grinding and blending of areas identified by the QC inspector. The work progressed throughout the QA inspector shift, was not completed and the appeared to be in general conformance with the contract documents.

Field Splice 5E/6E Face A (Outside)

The QA inspector periodically observed ABF welding personnel Mike Maday performing SMAW on the deck plate in areas identified by QC which exhibited insufficient fill and the planar offset areas. 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-D1.5-1040. The welding parameters were verified to be 145 with the pre heat and interpass temperature noted to be within the established WPS and the work progressed throughout the QA inspectors shift, was not completed and appeared to be in general conformance with the contract documents.

Field Splice 2W/3W Face E (Outside)

The QA inspector noted and periodically observed ABF welding operators Rory Hogan and Jeremy Dolan performing the grinding/cleaning operations for face E on the second side (Outside). The welding operators continued setting the equipment up and periodically performing the operation throughout the shift with QC inspector Jim Cunningham noted to be present in order to monitor the work and review the cleaned weld joint. A digital photo is included in the body of this report for general information. The work appeared to be progressing in general conformance with the contract documents.



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Summary of Conversations:

The QA inspector spoke with QA lead personnel Bill Levell and it was relayed the Engineer provided approval for the contractor to proceed with the R3 repair located at OBG field splice designated 3E/4E C1 at 1145. Mr. Levell also relayed he had informed ABF welding quality control manager Jim Bowers of the approval just prior to informing the QA inspector. This information was relayed to QA inspectors Rick Bettencourt and Dan Reyes verbally on this date.

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
