

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-014502**Date Inspected:** 26-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**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) Repair
2. OBG Field Splice 1W/2W Face B (Outside)
3. OBG Field Splice 1W/2W Face E (Outside)
4. OBG Field Splice 2W/3W Face E (Outside)

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

The QA inspector periodically observed ABF welding personnel Jordan Hazalaar repairs utilizing shielded metal arc welding (SMAW) after excavating and removing rejectable indications previously identified by QA and QC utilizing Ultrasonic Testing (UT). QC inspector Steve McConnell 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. Mr. Hazalaar was noted to be performing the excavation at approximate Y location designated Y-195mm. After the completion of the cleaning and shaping of the excavation the welder proceeded to perform the shielded metal arc welding (SMAW) and the welding parameters were verified to be 130 with the pre heat and interpass temperature noted to be within the established WPS. This location was completed a short time later in the shift and appeared to be in general conformance with the contract documents.

Field Splice 1W/2W Face B (Outside)

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The QA inspector observed ABF welding personnel Rory Hogan performing the set up and preparation work for flux cored arc welding (FCAW) at this location. It was relayed by QC inspector Tony Sherwood the welder was assisting in the set up for this location as ABF welding personnel Xiao Jin Wan would be performing the welding at this location. No welding was noted to be performed at this location during the QA inspectors review.

Field Splice 1W/2W Face E (Outside)

The QA inspector reviewed the status of the ultrasonic testing (UT) for the completed weld seam at this location. At this time there 5 locations identified by the QC department for repairs due to rejectable indications discovered during the UT. A digital photo is included in the body of this report for general information. No remedial work was performed at this location during the QA inspectors shift.

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

The QA inspector periodically observed ABF welding operators Rory Hogan and Jermey Dolan performing Flux Cored Arc Welding (FCAW) at the side plate utilizing the semi automatic welding equipment (“bug-o”). QC inspector Jim Cunningham was noted to be present in order to monitor the progress and ensure the welding was within the established Welding Procedure Specification (WPS) noted as ABF-WPS-D1.5-3040A-4 (Overhead). The preheat and interpass temperature was verified by the QC and QA inspector to be within the WPS and the parameters were verified to be 230 amps, 24 volts and a measured travel speed of 220mm/min. The work progressed throughout the balance of the QA inspector’s shift, was not completed and appeared to be in general conformance with the contract documents.



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

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Reviewed By: Levell,Bill

QA Reviewer