

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-014783**Date Inspected:** 14-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**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, Jesse Cayabyab			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 4W/5W-A/D, 3W/4W-C, and the following observations were made:

4W/5W-A

The QA Inspector noted the above identified weld joint was completed upon the arrival of the QA Inspector. The QA Inspector randomly observed the ABF welder identified as Kenneth Chappell operate the grinding machine and begin removing the weld reinforcement from the weld joint identified above. The QA Inspector randomly observed the ABF welder complete most of the grinding with the semi-automated grinding machine and begin performing the remainder of the grinding by hand with a hand held grinder and flapper wheel. The QA Inspector noted no welding was performed on this date.

4W/5W-D

The QA Inspector randomly observed the ABF welding personnel Mike Maday and Bryce Howell using the SAW process for production welding. This QA Inspector randomly observed QC Inspector Bernard Docena monitoring the welding and verify the following welding parameters; 550 amperes and 30.8 volts with a 432 mm per minute travel speed. The welding observed appeared to comply with WPS - ABF-WPS-D15-4042B-1. The QA Inspector noted the FCAW seal weld or full length tack weld was completed previously last week. The QA Inspector noted some minor grinding was performed prior to the SAW root pass being performed. After the grinding was completed the SAW root/fill pass was being performed for the remainder of the shift.

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3W/4W-C1

Upon the arrival of the QA Inspector at the above identified weld joint it was observed and noted, the above identified weld joint appeared to be approximately 75% completed. The QA Inspector observed the approximately 900mm at the top of the weld joint which could not be reached by with the semi-automated bug-o track system. The QA Inspector randomly observed the American Bridge/Fluor (ABF) welder Song Tao Hunag setting up to perform shielded metal arc welding (SMAW) of the 900mm of weld joint identified above. The QA Inspector randomly observed the Smith Emery (SE) Quality Control (QC) Inspector Bernard Docena set the SMAW parameters prior to the ABF welder performing welding of the 900mm of the weld joint. The QA Inspector noted the ABF welder was utilizing 1/8" E7018 low hydrogen electrodes with 132 Amps. The QA Inspector noted the SMAW parameters appeared to be in general compliance with the contract documents. The QA Inspector randomly observed the ABF welder perform the SMAW root/fill pass for the remainder of the QA Inspectors shift.

The QA Inspector spent the remainder of the shift updating the Caltrans QA tracking log and production chart.

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.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
