

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-015021**Date Inspected:** 16-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**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 2W/3W-E, 3W/4W-E, 1W/2W-D/S and the following observations were made:

2W/3W-E1/E2

Upon the arrival of the QA Inspector at the above identified location, it was observed all of the previous weld repairs had been completed. The QA Inspector noted the contractor was awaiting the 24 hour NDT hold on the repairs to officially complete the weld. The QA Inspector took the opportunity to perform ultrasonic testing (UT), as a representative sample of 10% of the total weld length. The QA Inspector noted the UT was performed between Y locations 1750mm-2090mm, 4700mm-5150mm (E1) and 1500mm-2000mm (E2). The QA Inspector noted the above identified UT was performed for the majority of the QA Inspectors shift in the AM. The QA Inspector noted no rejectable indications were located at the time of the testing (see TL-6027 for additional information).

3W/4W-E

The QA Inspector randomly observed the ABF welders Jeremy Doleman and Rory Hogan performing plasma arc gouging while back gouging the above identified weld joint. The QA Inspector noted the back gouge was nearly complete, additional grinding would be required prior to the FCAW back welding.

Summary of Conversations:

WELDING INSPECTION REPORT

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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
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Reviewed By:	Levell,Bill	QA Reviewer
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