

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-015170**Date Inspected:** 24-Jun-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:** Jobsite**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:** SAS OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Splice 4E/5E welds D1 & D2, Face B
- 2). OBG Field Splice 4W/5W weld A1 Face A

- 1). Field Splice 4E/5E welds D1 & D2, Face B.

The QAI periodically observed the in process welding per the Flux Cored Welding (FCAW-G) Process in the 4G (overhead) position by ABF welding personnel Mitch Sittinger (ID 0315). QC Inspector Jim Cunningham was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-3130-4. The QAI observed that the welding parameters appeared to be in general compliance with the contract documents. The welding at this location was in progress for the remainder of the QA Inspectors shift.

- 2). OBG Field Splice 4W/5W weld A1 Face A

The QAI periodically observed the in process welding per the Flux Cored Welding (FCAW-G) Process in the 1G (flat) position by ABF welding personnel (ID 0315). QC Inspector Bonifacio Daquinag was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-3000-1 repair. The QAI observed that the welding parameters appeared to be in general compliance with the contract documents. The QAI measured the excavation

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and noted the following dimensions: Length = 210mm, Width = 42mm and the depth = 20mm (see photo below). The fit-up line at the backing bar was visible. Mr. Daquinag stated to the QAI that this excavation incorporated two separate UT repair locations. The welding at this location was completed during the QA Inspectors shift.

Summary of Conversations:

As noted in the body of this report.

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 Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

Inspected By:	Madison,Bert	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
