

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-015198**Date Inspected:** 28-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:** Listed 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**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) OBG Lifts 3E/4E - plate D grinding
- 2) OBG Lifts 4E/5E - plate C field splice welding
- 3) Pier 7 activities

1) The QAI observed an ABF worker grinding on the inside cover of plate D at OBG lifts 3E/4E field splice. The QAI noted that the Quality Control (QC) Inspector James Cunningham is present at this location. The QAI was informed that the weld surface is being ground flush prior to final inspection. The QAI was informed that the ultrasonic testing (UT) of this weld, from the opposite (outside) of the weld was producing indications that may be rejectable. The QAI was informed that UT will be conducted again, when the weld is ground down. See the attached photo.

2) The QAI observed ABF personnel welding the inside of plate C at OBG lifts 4E/5E field splice. The QAI noted that this vertical (3G) CJP weld is being made in segment C2. The QAI noted that the QC Inspector Bernie Docena is monitoring this welding. The QAI observed ABF workers Jin Quan Huang, ID 9340, and Song Tao Huang, ID 3794, making the welds with gas shielded flux cored arc welding (FCAW-G). The QAI was informed that welding procedure specification (WPS) ABF-WPS-D15-3040A-1 is being used for this welding. The QAI randomly measured the preheat, interpass temperature and welding parameters and noted that they appeared to be

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conforming to the WPS requirements. The QAI was informed that, with the exception of the plate C to D corner area, the weld C2 should be completed during this shift. See the attached photo.

3) The QAI observed ABF activities at the Pier 7 location. The QAI did not observe any Quality Control (QC) Inspectors present. The QAI noted that ABF personnel are welding on barges and other job related equipment. The QAI also noted that the contractor is assembling parts of the temporary trestle and Favco crane on the barges at Pier 7. The QAI noted that OBG 6W is being moved from the pier by tug boats. The QAI did not observe any ABF personnel performing welding related activities on the OBG or crossbeam.

The QAI reviewed contract related documents including the submitted and approved Welding Quality Control Plan (WQCP) and approved revisions to the WQCP and newly issued ABFJV non-conformance reports. The QAI completed reviewing the contractor's welding reports, submittal # 1536 Revision 8, for conformance to the contract special provisions, see the appropriate TL-20 report for additional information. The QAI continued reviewing the contractor's welding reports, submittal # 1536 Revision 9 and Revision 10, for conformance to the contract special provisions. The review was in progress at the end of this shift



Summary of Conversations:

The QAI relayed the observations of OBG splice welding to the QAI Danny Reyes. The QAI generated a shift turn-over report with this information. The QAI relayed the observations at Pier 7 and the general status of work observed to the QAI Lead Bill Levell. Except as described above, there were no other notable observations or conversations during this shift.

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: Croff, Scott

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer