

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-015202**Date Inspected:** 23-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, Tom Pasqualone, Steve McConnell	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, 3W/4W-E and the following observations were made:

4W/5W-A

Upon the arrival of the QA Inspector it was observed the ABF welders Kenneth Chappell was performing grinding tasks of the excavation previously welded. The QA Inspector noted the repair welding was previously stopped by the Welding Superintendent Dan Ieraci. Upon the arrival of the QA Inspector it was observed the ABF welder identified above had removed approximately 1/2 of the weld material previously deposited. The QA Inspector was not able to accurately determine if the weld pass which exceeded the maximum allowable width per layer in accordance with AWS-D1.5-02. The QA Inspector noted it appeared the unacceptable weld was removed by grinding. The QA Inspector asked the QC Inspector Steve McConnell if he believed the weld was removed by grinding. Mr. McConnell informed the QA inspector he did believe the weld was removed by grinding. The QA Inspector noted no additional work was performed on the QA Inspectors shift.

1W/2W-F

Upon the arrival of the QA Inspector at the above identified location the QA Inspector noted the back gouge had been previously completed. The QA Inspector noted the SE QC Inspector Tom Pasqualone was present. The QA Inspector noted the QC Inspector had previously performed magnetic particle testing (MT) of the back gouged weld joint. The QA Inspector noted after several grinding attempts previously all of the MT indications were removed by grinding.

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The QA Inspector randomly observed the ABF welder James Zhen performing FCAW in the vertical position manually. The QA Inspector noted the weld was started on the previous afternoon, the QA Inspector noted the weld joint appeared to be approximately 80% complete upon arrival. The QA Inspector noted the FCAW parameters appeared to be consistent with ABF-WPS-D1.5-02-3110-3. The QA Inspector noted the FCAW was not completed on the QA Inspectors shift.

3W/4W-E

The QA Inspector noted the above identified weld joint appeared to be complete upon arrival. The QA Inspector noted the weld reinforcement remained in place and had not yet been ground. The QA inspector randomly observed the ABF welder Rory Hogan de mobilizing the equipment to the opposite side plate identified as 3W/4W-C. to begin the back gouging.

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
