

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-015376**Date Inspected:** 17-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:** Job Site**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:** Orthotropic Box Girders (OBG)**Summary of Items Observed:**

Quality Assurance inspector (QA) Michael Foerder was at the American Bridge/Flour (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. OBG Field Splice 3E/4E Face D (Outside) FCAW
2. OBG Field Splice 5E/6E Face B (Outside) FCAW
3. OBG Field Splice 5E/6E Face C (Inside) FCAW
4. OBG Field Splice 2W/3W Face E (Outside) VT Review

Field Splice 3E/4E Face D (Outside) FCAW

The QA inspector periodically observed the in process Flux Cored Arc Welding (FCAW-G) being performed in the 4G overhead position by ABF welding personnel Mitch Sittinger for the North ½ of face D. QC inspector Jim Cunningham was noted to be present in order to monitor the progress and ensure the welding parameters were within the established Welding Procedure Specification (WPS) noted as ABF-WPS-D1.5-3040B-4. The preheat and interpass temperature was verified by the QC and QA inspector to be greater than 65° Celsius (C) and the parameters were verified to be 233 amps, 23.4 volts and a measured travel speed of 153mm/min. The welder completed the cover pass for the location and proceeded to re-locate and set up the equipment for the balance of the weld joint for the balance of the QA inspector's shift. The work was not completed on this date and appeared to be progressing in general conformance with the contract documents.

Field Splice 5E/6E Face B (Outside)

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The QA inspector periodically observed ABF welding personnel Xiao Jin Wan performing flux cored arc welding (FCAW) at this location. QC inspector Bonafacio Daquinag was noted to be present in order to monitor the progress and ensure the welding was within the established Welding Procedure Specification (WPS) noted as ABF-WPS-D1.5-3040A-3. The preheat and interpass temperature was verified by the QC and QA inspector to be greater than 93° Celsius (C) and the parameters were verified to be 226 amps, 21.3 volts and a measured travel speed of 160mm/min. The work continued throughout the balance of the QA inspector shift, was not completed and appeared to be progressing in general conformance with the contract documents.

Field Splice 5E/6E Face C (Inside)

The QA inspector noted ABF welding personnel Song Tao Huang and QC inspector Bernard Docena was present at this location, however no production welding was performed for the QA inspector's shift. It appeared the welder was performing maintenance and re-location of the welding equipment for this location.

Field Splice 2W/3W Face E (Outside)

The QA inspector was present with QC inspector Bonafacio Daquinag in order to perform a tandem visual review for the completed weld face at this location for the temporary attachments located adjacent to the weld face. ABF welding personnel Rick Clayborn was present in order to grind/blend several locations previously identified by inspector personnel. After the areas were blended the QC inspector accepted the areas in question and the QA inspector concurred and the QC inspector placed a distinguishing mark adjacent to the weld. The QA inspector relayed this information to QA inspectors Rick Bettencourt and Dan Reyes for tracking purposes. The items observed appeared to be in general conformance with the contract documents.

Summary of Conversations:

No significant conversations held on this date for this contract.

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:	Foerder, Mike	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
