

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 #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015377**Date Inspected:** 01-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1100**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernard Docena**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:** OBG Section**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above.

This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and to monitor American Bridge/Fluor (ABF) welding operations.

The following observations were made:

1) At weld joint E4/E5 – E2, inside the Orthotropic Box Girder (OBG) section: ABF welding personnel Hung Jin Quan (#9340) and Songtao Huang (# 3794) were performing Flux Cored Arc Welding (FCAW) with QC Inspector Bernard Docena present.

At weld joint E4/E5 – E2, inside the OBG section this QA Inspector observed ABF welding personnel Songtao Huang (# 3794) and Hung Jin Quan (#9340) performing FCAW using the Bug-O track system. This QA Inspector observed QC Inspector Bernard Docena was present. This QA Inspector performed a verification of the welding parameters and observed the following: 250 amperes and 23.6 volts with a travel speed of 240 mm minute.

The welding observed appeared to comply with the Welding Procedure Specification (WPS) ABF-WPS-D15-3042-A-1. This QA Inspector observed QC Inspector Bernard Docena had a copy of the WPS at the location of welding. The welding pass observed was the final cover pass for the E2 section of weld that can be welded using the Bug-O system. This QA Inspector randomly observed ABF welding personnel Hung Jin Quan (#9340) and Songtao Huang (# 3794) using power wire brushes and grinders to clean and contour the weld in preparation of QC inspection. This QA Inspector also observed various ABF personnel removing the bolts and pins from the splice plates at the E-1 section of the weld joint to allow access for the Bug-O system to be set up.

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QC Inspector Bernard Docena informed this QA Inspector the fit up of E2 would be checked to verify the alignment of the plates were within the allowed tolerance after all the bolt /pins had been removed and prior to any additional production welding.

In general the work observed appeared to comply with the contract requirements.

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:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
