

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-015379**Date Inspected:** 02-Jul-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 2W/3W Weld ID: C1 & C2, Face B
- 2). OBG Field Splice 3W/4W Weld ID: C1 & C2, Face B
- 3). OBG Field Splice 5W/6W Weld ID: D1 & D2, Face B

- 1). OBG Field Splice 2W/3W Welds C1 & C2, Face B

The QAI periodically observed the in process welding of repairs at temporary attachment removal areas with associated with OBG Field Splice OBG Field Splice 2W/3W Welds C1 & C2, Face B per the Shielded Metal Arc Welding (SMAW) process in the 3G/4G position by ABF welding personnel Rory Hogan (ID 3186). See photo below. SE QC Inspector Jim Cunningham was present to monitor the progress and verify that the preheat & welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1000-Repair. The work at this location was completed during this shift. The QAI observed that the welding parameters and the final weld repairs appeared to be in general compliance with the contract documents.

- 2). OBG Field Splice 3W/4W Weld ID: C1 & C2, Face B

The QAI periodically observed AB/F personnel performing flush grinding of the completed OBG Field Splice welds C1 & C2. The work at this location was not completed during this shift.

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3). OBG Field Splice 5W/6W Weld ID: D1 & D2, Face B

The QAI periodically observed AB/F personnel installing fit-up gear on the OBG Field Splice 5W/6W Weld ID: D1 & D2, Face B. The Blank Nuts were welded to Face B per the SMAW process in the 4G position by approved welders Kenneth Chappell (ID 3833) and Mike Maday (ID 3391). QC Inspector Bonafacio 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-F1200-A. Joint alignment was in process at this location for the remainder of the QA Inspector's shift. See photo below of fit-up gear in place.



Summary of Conversations:

None of relevance.

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
