

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-015547**Date Inspected:** 09-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 1W/2W Weld ID: D1 & D2, Face B
- 2). OBG Field Splice 2W/3W Weld ID: D1 & D2, Face B
- 3). OBG Field Splice 3E/4E Weld ID: D1 & D2, Face B
- 4). OBG Field Splice 5W/6W Weld ID: A1, A2, A3, A4 and A5, Face A
- 5). OBG Field Splice 5W/6W Weld ID: D 1& D2, Face A

- 1). OBG Field Splice 1W/2W Welds D2, Face B

The QAI periodically observed the in process welding of OBG Field Splice 1W/2W weld ID: D2, Face B per the Flux Cored Welding (FCAW-G) process in the 4G (overhead) position by ABF welding personnel Rory Hogan (ID 3186). QC Inspector Tony Sherwood 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-D1.5-3040A-4. The QAI observed that the welding parameters obtained by Mr. Sherwood appeared to be in general compliance with the contract documents. Welding was completed on this shift.

- 2). OBG Field Splice 2W/3W Weld ID: D1 & D2, Face B

The QAI periodically observed AB/F personnel performing grinding to prepare the outside groove for back welding. The work at this location was completed during this shift.

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3). OBG Field Splice 3E/4E Weld ID: D1 & D2 Face B

The QAI periodically observed AB/F approved welder Fred Kaddu (2188) performing repair welding of multiple UT repairs on the B face of OBG Field Splice 3E/4E Weld ID: D1 & D2. The repair welding was per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position. QC Inspector Tony Sherwood 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-D1.5-1001-repair. Welding at this location was in process for the remainder of this shift and appeared to be in general compliance with contract documents.

4). OBG Field Splice 5W/6W Weld ID: A1, A2, A3, A4 and A5, Face A

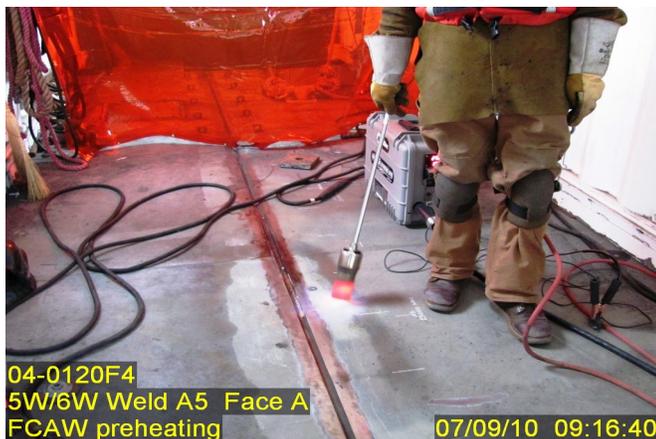
The QAI periodically observed the in process welding of the full length tack welds to seal the bevel face to the steel backing in the OBG Field Splice 5W/6W weld ID: A1, A2, A4 and A5, Face A per the Flux Cored Welding (FCAW-G) process in the 2F (horizontal) position by AB/F approved welding personnel James Zhen (ID 6001) and Hua Quiang Hwang (ID 2930). QC Inspector Steve McConnel 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-F3200-2. The welding per the FCAW-G process continued until 11:30 at which time AB/F welding superintendent Dan Ieraci entered the welding shelter and informed the welders that the remainder of the OBG Splice would need to be welded utilizing the Shielded Metal Arc Welding (SMAW) process. At that time welder (6001) had welded continuous tack welds at A4 from Y= 20000mm to Y= 22000mm and A5 from Y= 22000mm to Y= 27280mm. Welder (2930) had welded continuous tack welds at A1 from Y= 0mm to Y=5500mm and A2 from Y= 5500mm to Y= 6740mm. The welding resumed after the lunch break per the SMAW process. QC Inspector Steve McConnel 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-F1200A. The SMAW welder was James Zhen (ID 6001) The SMAW welding of the remainder of the full length tack welds in welds A4 was completed on this shift and tack welds in weld A3 were in process. The QAI observed that the welding parameters and the completed tack welds appeared to be in general compliance with contract documents. See photo below.

5). OBG Field Splice 5W/6W Weld ID: D1, Face A

The QAI periodically observed the in process welding of the full length tack welds to seal the bevel face to the steel backing in the OBG Field Splice 5W/6W weld ID: D1 & D2 Face A per the Flux Cored Welding (FCAW-G) process in the 2F (horizontal) position by AB/F approved welding personnel Xiao Jian Wan (ID 9677). The 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-F3200-2. Welding at this location was in process at the end of the shift. See photo below.

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Summary of Conversations:

As noted in the body of this report and below:

In a conversation with QC Inspector Bonafacio Daquinag, Mr Daquinag stated to the QAI that he had spoken with AB/F welding superintendent Mr. Dan Ierace regarding installing induction heaters on the OBG Field Splice 5W/6W welds D1 & D2 face B side, since heaters were going to need to be installed for the SAW welding to follow. The QC inspector stated that Mr. Ierace replied that the welder's helper would use a weed burner torch to maintain the preheat for the welder.

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