

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-015565**Date Inspected:** 12-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: B1 Face B
- 2). OBG Field Splice 2W/3W Weld ID: F1 Face B
- 3). OBG Field Splice 3W/4W Weld ID: B1 Face B
- 4). OBG Field Splice 3W/4W Weld ID: F1 Face B
- 5). OBG Field Splice 5E/6E Weld ID: E1 & E2, Face A
- 6). OBG Field Splice 5W/6W Weld ID: D1 & D2, Face A

- 1). OBG Field Splice 2W/3W Weld ID: B1 Face B

The QAI periodically observed AB/F personnel performing air carbon arc gouging and grinding to excavate MT indications on the inside gouged groove of OBG Field Splice 2W/3W Weld ID: B1. SE QC Inspector Tom Pasqualone performed MT of the excavated areas and marked up additional areas for repairs. The performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. Several iterations of intermittent inspection and excavations were observed throughout the shift. The work at this location was not completed during this shift.

- 2). OBG Field Splice 2W/3W Weld ID: F1 Face B

The QAI periodically observed AB/F personnel performing air carbon arc gouging and grinding to repair the inside gouged groove on OBG Field Splice 2W/3W Weld ID: F1. SE QC Inspector Tom Pasqualone performed

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MT of the repaired areas and marked up additional areas for repairs. The performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. Several iterations of intermittent inspection and repair work were observed throughout the shift. See photo below. The work at this location was not completed during this shift. The work at this location was not completed during this shift.

3). OBG Field Splice 3W/4W Weld B1, Face B

The QAI periodically observed AB/F personnel performing air carbon arc gouging and grinding from the B Face of OBG Field Splice 3W/4W Weld B1, Face B. The QAI observed SE QC Inspector Tom Pasqualone performing Magnetic Particle Testing (MT) of the excavated areas and marking up additional areas for repairs. The performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4.

4). OBG Field Splice 3W/4W Weld F1, Face B

The QAI observed SE QC Inspector Tom performing MT of the excavated areas on the B Face of OBG Field Splice 3W/4W Weld F1. The performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. The QAI observed that Mr. Pasqualone marked up additional areas for repairs.

5). OBG Field Splice 5W/6W Weld ID: D1 & D2, 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 of the full length tack welds at this location was completed on this date and appeared to be in general compliance with contract documents. After the lunch break the QAI periodically observed the in process welding of the fill passes in the last 460mm (from Y=3790mm to Y=4250mm) of the OBG Field Splice 5W/6W weld ID: D2, Face A per the FCAW-G process in the 1G (flat) 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-D1.5-3040A-1. Welding of the fill passes was in process for the remainder of the QA Inspectors shift and appeared to be in general compliance with contract documents. See photo below.

6). OBG Field Splice 5E/6E Weld ID: D1 & D2, Face A

The QAI periodically observed the in process welding of the fill and cover passes in the OBG Field Splice 5E/6E weld ID: D1 & D2 Face A per the Flux Cored Welding (FCAW-G) process in the 3G (vertical) position by AB/F approved welding personnel Song Tao Huang (ID 3794). The QC Inspector Bernard Docena 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-D1.5-3042A. Welding at this location was in process at the end of the shift.

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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