

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-015591**Date Inspected:** 13-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: F1 Face B
- 2). OBG Field Splice 2W/3W Weld ID: D1 Face B
- 3). OBG Field Splice 4W/5W Weld ID: F1 Face B
- 4). OBG Field Splice 5W/6W Weld ID: D1, Face A

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

The QAI periodically observed the in process welding of the OBG Field Splice 2W/3W weld ID: F1 Face B per the Flux Cored Welding (FCAW-G) process in the 3G (vertical) position by approved AB/F welding personnel Jin Pei Wang (ID 7299). The SE QC Inspector Tom Pasqualone 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-D1.5-3110-3. Welding of the fill passes was in process for the remainder of the QA Inspectors shift and work at this location appeared to be in general compliance with contract documents. See photo below.

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

The QAI periodically observed the in process welding of OBG Field Splice 2W/3W Weld ID: D1, Face B per the FCAW-G process in the 4G (overhead) position by approved AB/F welding personnel Rory Hogan (ID 3186). QC Inspector Steve McConnel was present to monitor the progress and verify that the welding parameters were within

WELDING INSPECTION REPORT

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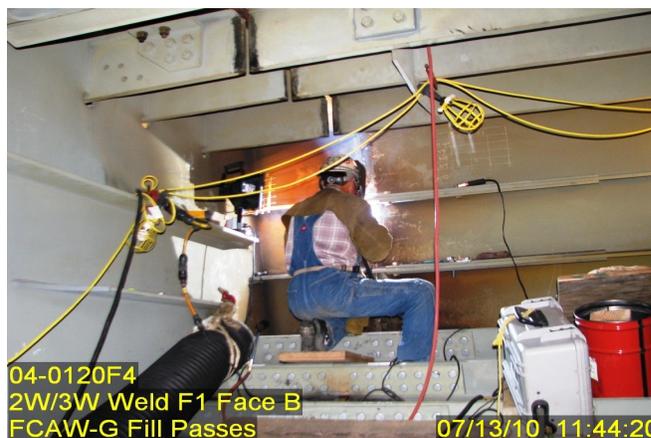
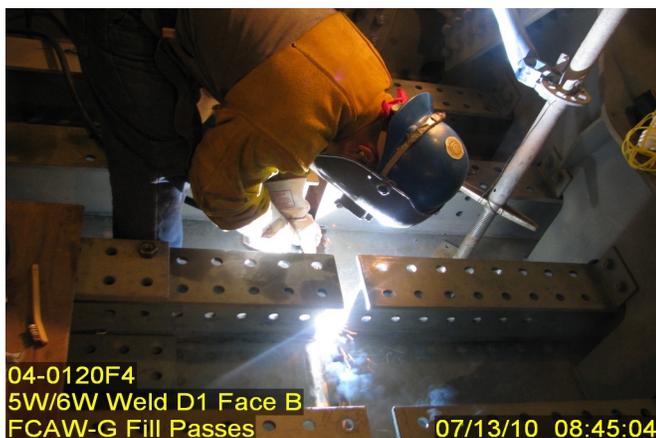
the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-3110-4. The QAI observed that the welding parameters obtained by Mr. McConnell appeared to be in general compliance with the contract documents. Welding was in process for the remainder of this shift.

3). OBG Field Splice 4W/5W Weld F1, Face B

The QAI periodically observed AB/F personnel performing air carbon arc gouging of the B face of OBG Field Splice 4W/5W Weld F1.

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

The QAI periodically observed the in process welding of the fill passes in the first 1270mm (from Y=0mm to Y=1270mm) of the OBG Field Splice 5W/6W weld ID: D1, Face A per the FCAW-G process in the 1G (flat) position by AB/F approved welding personnel Xiao Jian Wan (ID 9677). See photo below. 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 fill passes was completed on this date and in process work at this location appeared to be in general compliance with contract documents.



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