

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-015642**Date Inspected:** 15-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 3W/4W Weld ID: C1 and C2, Face B
- 3). OBG Field Splice 3W/4W Weld ID: F1 Face B
- 4). OBG Field Splice 3W/4W Weld ID: D1 & D2 Face B
- 5). OBG Field Splice 5E/6E Weld ID: E2 Face A

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

The QAI periodically observed approved AB/F welding personnel Jin Pei Wang (ID 7299) performing cleaning/surface preparation for NDE. Work at this location was complete on this date.

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

The QAI periodically observed repair welding (UT repairs) of OBG Field Splice 3W/4W Weld ID: C1 & C2, Face B per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position by approved AB/F welding personnel Rick Clayborn (ID 2773). 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. The QAI observed that the welding parameters obtained by Mr. Sherwood appeared to be in general compliance with the contract documents. Repair welding was completed on Face B on this shift.

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Later in the shift the QAI periodically observed repair welding (UT repairs) of OBG Field Splice 3W/4W Weld ID: C2, Face A per the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position by approved AB/F welding personnel Rick Clayborn (ID 2773). Mr. Clayborn first excavated three indications in two separate excavations by grinding. The QAI observed QC Inspector Tony Sherwood performing Magnetic Particle Testing (MT) in the excavated areas. See photo below. The QAI noted that the excavations appeared to be free of MT indications. The QAI observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. When Mr. Clayborn commenced with repair welding 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-D1.5-1000-Repair. Welding at this location was in process for the remainder of the QA Inspectors shift. Work at this location appeared to be in general compliance with contract documents.

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

The QAI periodically observed the in process welding of the OBG Field Splice 3W/4W weld ID: F1 Face B per the FCAW-G process in the 3G (vertical) position by approved AB/F welding personnel Hua Quiang Hwang (ID 2930). The SE 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-D1.5-3110-3. Welding of the cover passes was in process during this shift. Work at this location appeared to be in general compliance with contract documents.

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

The QAI periodically observed ABF approved welding personnel Rory Hogan (3186) performing Plasma Cutting to remove the backing bar and subsequent grinding to prepare the groove for back welding. The work at this location was in process for the remainder of the QA Inspectors shift.

5). OBG Field Splice 5E/6E Weld ID: E2, Face A

The QAI periodically observed in process welding of OBG Field Splice 5E/6E Weld ID: E2, from Face A per the Semi-Automated FCAW-G process in the 3G (vertical) position. The welding was performed by AB/F approved welder Song Tao Huang (3794). The SE 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-1. Welding of the fill and cover passes was in process during this shift. See photo below. Work at this location appeared to be in general compliance with contract documents.

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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