

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-015643**Date Inspected:** 14-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: D2 Face B
- 3). OBG Field Splice 3W/4W Weld ID: F1 Face B
- 4). OBG Field Splice 5W/6W Weld ID: D1, Face A
- 5). OBG Field Splice 3E/4E Weld ID: D1 and D2, Face B

- 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 and cover passes was completed on this shift. Work at this location appeared to be in general compliance with contract documents.

- 2). OBG Field Splice 2W/3W Weld D2, Face B

The QAI periodically observed the in process welding of OBG Field Splice 2W/3W Weld ID: D2, Face B per the FCAW-G process in the 4G (overhead) position by approved AB/F welding personnel Rory Hogan (ID 3186). QC Inspector Tony Sherwood was present to monitor the progress and verify that the welding parameters were within

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

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. Sherwood appeared to be in general compliance with the contract documents. Welding was in process for the remainder of this shift.

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

The QAI periodically observed repair welding of base metal adjacent to the OBG Field Splice 3W/4W weld ID: F1 Face B per the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position. The air carbon arc excavation appeared to be wider adjacent to the top stiffener and was repaired prior to proceeding with the FCAW-G welding. The repair welding was performed by AB/F approved welder James Zhen (6001). 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-D1.5-1000 Repair. The QAI observed SE QC Inspector Tom Pasqualone performing Magnetic Particle Testing (MT) of the repaired area and of the entire excavation. See photo below. Mr. Pasqualone identified several indications for removal by grinding. The indications were removed and Mr. Pasqualone verified their removal with MT. 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. 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 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 during this shift. Work at this location appeared to be in general compliance with contract documents.

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

The QAI periodically observed the in process welding of the cover passes on the first 1600mm (from Y=0mm to Y=1600mm) 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). 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 work at this location appeared to be in general compliance with contract documents.

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

The QAI periodically observed AB/F approved welder Rick Clayborn (2773) 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 completed on this shift and appeared to be in general compliance with contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

In a conversation with AB/F John Callahan, the QA inspector was told that the contractor was working only eight hours on this date due to a scheduled electrical power outage.

From item 4 above, the QAI asked QC Bonafacio Daquinag if SAW welding was to be performed at 5W/6W welds D1 & D2 on this date. Mr. Daquinag stated that welds D1 & D2 would not be welded until welds A1 through A5 are SAW complete because the SAW operator will be the same.

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
