

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-015831**Date Inspected:** 22-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**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:**

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above. The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified 4W/5W, 5W/6W, and the following observations were made:

4W/5W-C1/C2

Upon the arrival of the QA Inspector at the above identified weld joint it was observed and noted, the above identified weld joint had not yet been welded. The QA Inspector observed approximately 600mm at the bottom and the top of the weld joint which could not be reached by with the semi-automated bug-o track system was being completed prior to the FCAW production welding. The QA Inspector randomly observed the American Bridge/Fluor (ABF) welder Song Tao Hunag and Jin Quan Huang setting up to perform shielded metal arc welding (SMAW) of the 600mm of weld joint identified above. The QA Inspector randomly observed the Smith Emery (SE) Quality Control (QC) Inspector Bonifacio Daquinag set the SMAW parameters prior of the ABF welders performing welding of the 600mm at the top and bottom weld joint. The QA Inspector noted the ABF welder was utilizing 1/8" E7018 low hydrogen electrodes with 133Amps. The QA Inspector noted the SMAW parameters appeared to be in general compliance with the contract documents. The QA Inspector randomly observed the ABF welder perform the SMAW root/fill and cover pass. The QA Inspector noted the ABF welder did complete the above identified welds on the QA Inspectors shift.

5W/6W-A1-5

Upon the arrival of the QA Inspector at the above identified location, it was observed and noted the weld reinforcement had been ground flush with the base material of the top deck plates. The QA Inspector randomly

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observed and noted the SE QC Steve McConnell performing Ultrasonic Testing (UT) of above identified weld joint. The QA Inspector randomly observed the above identified QC Inspector perform UT of 100% of the total weld length of the above identified weld joint. It is noted the UT was started on the previous day shift. The QA Inspector randomly observed the UT was approximately 75% complete upon arrival. After the QC Inspector had completed the UT, the QA Inspector noted 12 UT rejections were indicated and recorded by the QC Inspector. The QA Inspector randomly observed the locations, lengths and depths were indicated with a distinguishing marking directly on the weld. The QA Inspector randomly observed the ABF welder identified as James Zhen gathering and setting up the SMAW equipment to begin excavating and repairing the indicated repairs. The QA Inspector noted no excavating or welding was performed on the QA Inspectors shift.

5W/6W-F

The QA Inspector randomly observed the ABF Xiao Jian Wan setting up the FCAW machines and scaffold to begin welding at the above identified weld joint. The QA Inspector randomly observed the SE QC Inspector Tony Sherwood was on site at the above identified location preparing to perform VT of the fit up. The QA Inspector randomly observed no such inspection or welding was completed on the QA Inspectors shift.

The QA Inspector spend the remainder of the shift walking the job site and updating the Caltrans QA Production/NDT tracking log. The QA Inspector noted, after the information was gathered in the field, the QA Inspector transferred the information to the chart in the Caltrans SAS office on the job site.

Summary of Conversations:

No pertinent conversation noted.

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 Mohammad Fatemi (916)-813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
