

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-015835**Date Inspected:** 23-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**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 5E/6E, and the following observations were made:

5E/6E-C1

The QA Inspector randomly observed the ABF welder Song Tao Hunag had previously started the induction heating blankets on the inside of OBG to ensure the minimum required preheat of 150°F was achieved prior to welding. The QA Inspector randomly verified utilizing a 150°F temperature indicating marker and noted the minimum required preheat had been achieved. The QA Inspector observed the ABF welder to be utilizing the semi automated flux cored arc welding (FCAW) for the above identified weld joint. The QA Inspector randomly observed the Smith Emery (SE) QC Inspector identified as Bonifacio Daquinag set the FCAW machine to the parameters of the approved WPS identified as ABF-WPS-D1.5-3042-B-1. The QA Inspector randomly observed the FCAW parameters were 236 Amps, 24.1 Volts and a travel speed of 250mm/min. The QA Inspector noted the FCAW root pass/fill passes were welded on the previously on 7/21/10. The QA Inspector performed a random visual inspection of the in process fill pass in weld segment C1 and noted it did appear to meet the general requirements of the contract documents. The QA Inspector randomly observed the ABF welder identified above continue the FCAW fill passes on C1. The QA Inspector noted the ABF welders spent the remainder of the shift performing the FCAW fill passes.

The QA Inspector performed a job site walk through and updated the Caltrans QA Production/NDT tracking log.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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. In addition the QA Inspector traveled to Anamet Testing in Hayward, Ca to witness destructive testing of reduces section tensile tests. The QA Inspector noted the destructive test were associated with ABF Procedure Qualification Record (PQR) PQR-0036-3 Rev. 0 (see TL-6032 for additional information).

Summary of Conversations:

The QA Task Lead Inspector Bill Levell informed the QA Inspector the Smith Emery Quality Control Inspector identified as John Pagliero was verbally approved to work on the project.

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
