

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 #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015952**Date Inspected:** 26-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1100**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** John Pagliero**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:** OBG Section**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and to monitor American Bridge/Fluor (ABF) welding operations.

The following observations were made:

1) At weld joint E5/E6 – C1, inside the OBG section: ABF welding personnel Songtao Huang (# 3794) was performing Flux Cored Arc Welding (FCAW). QC Inspectors John Pagliero and Tom Pasqualone were present.

At weld joint E5/E6 – C1, inside the OBG section this QA Inspector observed ABF welding personnel Songtao Huang (# 3794) performing FCAW at the upper section of weld joint C1, which is not accessible using the track system. This QA Inspector observed QC Inspector John Pagliero verify the FCAW parameters as follows: 235 amperes and 23.4 volts at a travel speed of 270 mm per minute. The welding observed appeared to comply with Welding Procedure Specification (WPS) ABF-WPS-D15- 3040A-3 for the FCAW process. This QA Inspector observed the weld was not completed with the FCAW process and ABF welding personnel Songtao Huang (# 3794) switched to the Shielded Metal Arc Welding (SMAW) process. This QA Inspector observed QC Inspector John Pagliero verify the SMAW parameters as follows: 135 amperes using a 3.2 mm E7018H4R electrode. The welding observed appeared to comply with ABF-WPS-D15-1020A Rev-1 for the SMAW process.

At weld joint E5/E6-C2 this QA Inspector observed welding had not been performed but that the fit up of the weld joint had been marked acceptable by QC personnel, 7/19/19, adjacent to the weld joint. This QA Inspector

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performed a random visual verification of the fit up and observed a 7 mm gap between the base metal and the backing material for approximately 750 mm in length, starting at the 2500mm mark. See photo of gap below. This QA Inspector informed QC Inspector John Pagliero of this discovery. This QA Inspector was informed by ABF welding personnel Songtao Huang (# 3794) a wedge from the fitting dogs on the outside had fallen out. QC Inspector John Pagliero stated the fit up would be re-inspected prior to any welding.

Summary of Conversations:

As noted above.



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:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
