

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 #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015953**Date Inspected:** 28-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:** Tony Sherwood**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 – D2, inside the OBG section: ABF welding personnel Hua Qian Hwang (# 2930) was performing Flux Cored Arc Welding (FCAW). QC Inspector Tony Sherwood was present.

2) At weld joint E5/E6 – C2, inside the OBG section: ABF welding personnel Songtao Huang (# 9340) was performing Shielded Metal Arc Welding (SMAW). QC Inspector Tony Sherwood was present.

At weld joint E5/E6 – D2, inside the OBG section this QA Inspector observed ABF welding personnel Hua Qian Hwang (# 2930) performing FCAW at the area adjacent to weld joint C where use of the track system is not possible due to access. This QA Inspector observed QC Inspector Tony Sherwood verify the following FCAW parameters: 230 amperes and 23.2 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-1.

At weld joint E5/E6 – D2, inside the OBG section this QA Inspector observed ABF welding personnel Songtao Huang (# 3794) performing SMAW at the area adjacent to weld joint D-1 where use of the track system is not possible due to access. This QA Inspector observed QC Inspector Tony Sherwood verify the SMAW parameters

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

as follows: 130 amperes using a 3.2 mm diameter E7018H4R electrode. The welding observed appeared to comply with Welding Procedure Specification (WPS) ABF-WPS-D15- 1020A Rev-1.

In general the work observed this date appeared to comply with the contract requirements.

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
