

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-015955**Date Inspected:** 28-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 5W/6W, 5E/6E, and the following observations were made:

Tower Erection

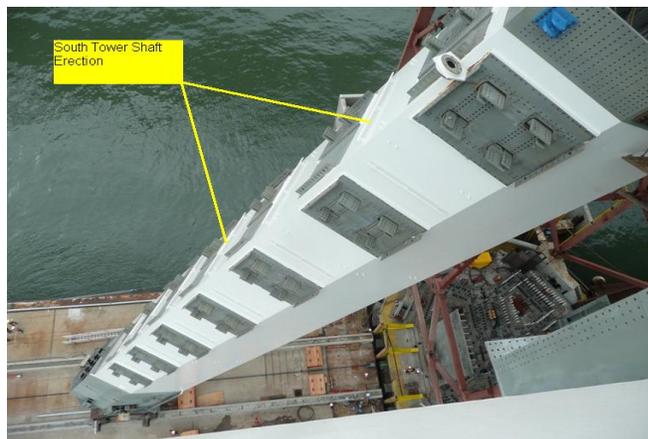
The QA Inspector randomly observed the ABF Erection personnel lift and install the South Tower Shaft on the T1 foundation. The QA Inspector noted the installation was in process for the full duration of the QA Inspectors shift.

The QA Inspector performed a job site walk through and updated 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. The QA Inspector spent the remainder of the shift performing organizational tasks of the tracking of the QA NDT on the job site.

The QA Inspector randomly observed the ABF Welding Superintendent Dan Ieraci setting up the mock ups for the welding of the lifting lug attachment holes in the top deck plate. The QA Inspector observed the mock ups consisted of the variable thickness of the top deck plates where the welding will take place. The QA Inspector randomly observe the round holes were cut at the same diameter of the holes previously used for lifting lug attachments. (see summary of conversation)

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Summary of Conversations:

Mr. Ieraci informed the QA Inspector each mock up had 4 holes cut out and ABF will attempt to weld up each hole with a different process. Mr. Ieraci went on to inform the QA Inspector, ABF will attempt the different processes to determine which process will work the best based on the ultrasonic test results.

The QA Inspector identified as Robert Mertz was on site to observe the South Tower Shaft installation. Mr. Mertz informed the QA Inspector of multiple temporary welds which were previously welded on the bottom side of the tower base plate. The QA Inspector was informed the contractor issued an NCR for the temporary welds to the base plate. The QA Inspector was informed the NCR resolution states the welds will be removed and magnetic particle testing would be performed. The QA Inspector randomly observed the tower section was vertical and the removal of the welds under the base plate must be done prior to the contractor setting the tower shaft on T1. The QA Inspector called the QC Lead Inspector Leonard Cross and asked him if the welds would be removed and inspected as per the internal ABF NCR. Mr. Cross informed the QA Inspector he would need to contact the ABF Welding Quality Control Manager (WQCM) Jim Bowers. The QA Inspector did not observe the removal and inspection of the temporary welds. The QA Task Lead Inspector Bill Levell informed the QA Inspector later in the day the welds were removed from the bottom of the base plate and inspected by SE QC. The QA Inspector was informed by Mr. Levell the contractor repaired and inspected the areas noted above but did not inform Caltrans METS at the time of the repairs.

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