

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-015960**Date Inspected:** 31-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:** Jobsite**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:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Splice 1W/2W Weld ID: D1 & D2, Face A
- 2). OBG Field Splice 1W/2W Weld ID: D1 & D2, Face B
- 3). OBG Field Splice 5W/6W Weld ID: D1 & D2, Face B
- 4). OBG Field Splice 3E/4E Weld ID: D1 & D2, Face B
- 5). OBG Field Splice 4E/5E Weld ID: C1 & C2, Face B

- 1). OBG Field Splice 1W/2W Weld ID: D1 & D2, Face A

The QAI periodically observed AB/F approved welders Xiao Jian Wan (ID 9677) and Jin Pei Wang (ID 7299) grinding to excavate Ultrasonic Testing (UT) reject areas from the A face of OBG Field Splice 1W/2W Weld ID: D1 & D2. The QAI observed welder Xiao Jian Wan (ID 9677) performing Shielded Metal Arc Welding (SMAW) in the 1G (flat) position on a test piece while QC Inspector Tom Pasqualone measured and verified that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1000-Repair. See photo below. No welding was accomplished at this location during the QA Inspectors shift.

- 2). OBG Field Splice 1W/2W Weld ID: D1 & D2, Face B

The QAI periodically observed AB/F approved welders James Zhen (ID 6001) and Hua Quiang Hwang (ID 2930)

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grinding to excavate UT reject areas from the B face of OBG Field Splice 1W/2W Weld ID: D1 & D2. No welding was accomplished at this location during the QA Inspectors shift.

3). OBG Field Splice 5W/6W Weld ID: D1 & D2, Face B

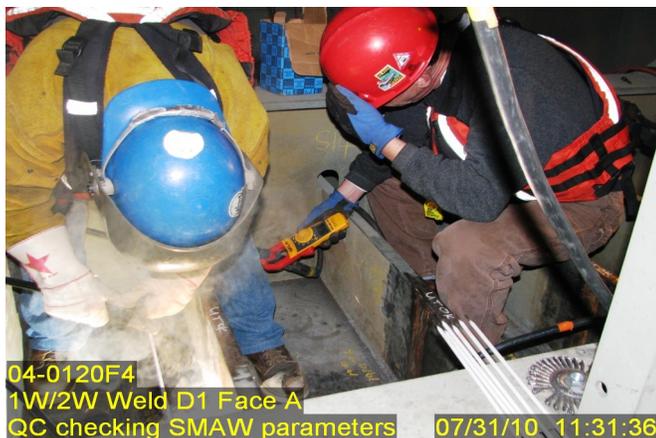
The QAI periodically observed AB/ approved welder Mike Maday (ID 3391) performing Plasma Cutting to remove the backing bar and prepare the groove for back welding. The work at this location was in process for the remainder of the QA Inspectors shift.

4). OBG Field Splice 3E/4E Weld ID: D1 & D2, Face B

The QAI periodically observed AB/F approved welder Fred Kaddu (ID 2188) performing repair welding per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position of repair cycle 2 (R-2) excavations at Ultrasonic Testing (UT) reject areas from the B face. See photo below. AB/F approved welder Kenneth Chappell was performing the excavating by grinding. AB/F QC Inspector Jesse Cayabyab (who was later replaced by QC Inspector Tony Sherwood) was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1001-Repair. The QAI periodically observed both of the QC Inspectors named above performing Magnetic Particle Testing (MT) of the repair excavations prior to Mr. Kaddu performing welding at the repair locations. The QAI observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. Work was not completed at this location during the QA Inspectors shift and the work appeared to be in general compliance with contract documents.

5). OBG Field Splice 4E/5E Weld ID: C1 & C2, Face B

The QAI periodically observed QC Inspector Jesse Cayabyab performing Magnetic Particle Testing (MT) of the prepared excavated groove prior to AB/F welding personnel performing back welding. The QAI observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. No welding was accomplished at this location during the QA Inspectors shift.



Summary of Conversations:

None of relevance.

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 Mohammed Fatemi (916) 813 3677, who represents the Office of Structural

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Materials for your project.

Inspected By: Madison,Bert

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer