DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-016048
Date Inspected: 04-Aug-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 1000
OSM Departure Time: 1830
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: Orthotropic Box Girders

Summary of Items Observed:
At the start of the shift the Quality Assurance Inspector (QAI) traveled to the project site and observed the following work performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below:

A). T1-Tower
B). Field Splice E1/E2

A). T1-Tower

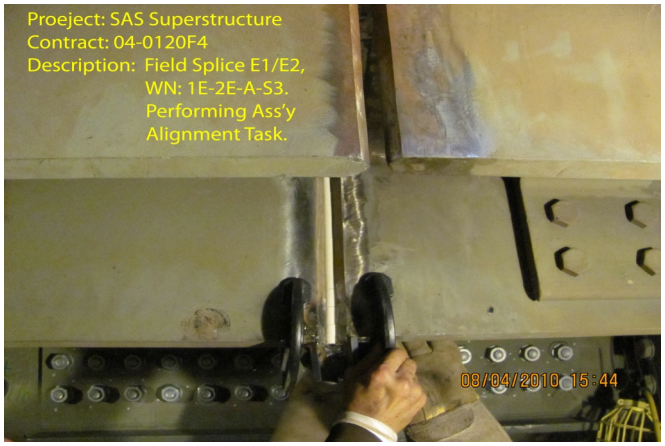
The QAI observed the erection and placement of the North Shaft identified as TL-4.

B). Field Splice E1/E2

The QAI inspector observed the planar alignment of the longitudinal stiffener identified as E1-E2-A-S3. The alignment of the field splice appeared to comply with the contract drawings. The QAI reviewed the documents associated with the welding task in regards to the 30mm and 35mm 485W HPS stiffener plates. Later in the shift and at the conclusion of the review, the QAI and QC inspector discussed the requirements regarding the Welding Procedure Specification identified as ABF-WPS-D15-1012-3, Rev.0, the Special Provision Specifications and the requirements for the E9018-H4R electrode to be utilized. The QC inspector appeared to understand the requirements in regards to the Complete Joint Penetration welding of the field splice. The QC inspector informed the QAI that ABF has elected to utilize propane in lieu of electric resistance heating bands. At the conclusion of the QAI review of the joint fit-up and planar alignment of the weld joint, 1E-2E-A-S3, appears to comply with the

contract documents but the average dimensions of the root opening is equal to 15 mm and appears to be excessive and will require welding to correct the root opening. The contractor will utilize ceramic tape to facilitate the correction of the root opening by welding. For additional information see Summary of Conversations.

The digital photographs below illustrate the work observed during this scheduled shift.



Summary of Conversations:

There were general conversations with Quality Control Inspector Mike Johnson at the start of the shift regarding the location of American Bridge/Fluor welding personnel and inspection/ N.D.E. testing scheduled for this shift.

Upon a discussion with Mike Johnson regarding the preheating of the base material, 485W HPS, Mr. Johnson informed the QAI that ABF has elected not to utilize the electric resistance heating bands. Later in the shift in a conversation with the Welding Supervisor, Dan Ieraci confirmed that ABF in regards to preheating will utilize propane.

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:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer