

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-016074**Date Inspected:** 30-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:** Jesus Cayabyab**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 – B, inside the OBG section: ABF welding personnel Jin Quan Huang (# 9340) was grinding the back gouged area in preparation for welding. QC Inspector Jesus Cayabyab was present.
- 2) At weld joint E5/E6 – F, inside the OBG section: ABF personnel Jin Quan Huang (# 9340) was grinding the back gouged area in preparation for welding. QC Inspector Jesus Cayabyab was present.
- 3) At E5/E6-C, outside the OBG section: ABF personnel were observed removing temporary welds by grinding.
- 4) At E4/E5 welds C1, C2 and E1, E2 it was observed the welds had been back gouged, ground and waiting for QC inspection.

At weld joint E5/E6 – B, inside the OBG section this QA Inspector observed ABF welding personnel Jin Quan Huang (# 9340) grinding the back gouged area of the weld in preparation to weld. This QA Inspector randomly observed QC Inspector Jesus Cayabyab perform a visual and Magnetic Particle Testing (MT) on the back gouged areas and mark several areas for additional grinding. The process of performing the visual and MT inspection was

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repeated several times before the back gouged weld was accepted by QC Inspector Jesus Cayabyab. This QA Inspector observed at the top section, adjacent to weld "A" the back gouge excavation was approximately 16 mm deep for a length of 40 mm. Upon completion of grinding this back gouged weld ABF welding personnel Jin Quan Huang (# 9340) relocated to weld joint E5/E6 – F, inside the OBG section and started grinding the back gouged section of this weld. The grinding was not completed by the end of this QA Inspector's shift.

At 5E/6E-C, outside the OBG section this QA Inspector randomly observed ABF personnel removing the temporary welds used during the fitting process by grinding. This QA Inspector performed a random visual verification of several of the areas during the morning break and the work observed appeared to comply with the contract requirements.

At 4E/5E welds C1, C2 and E1, E2 it was observed the welds had been back gouged and ground. ABF welding personnel Jeremy Dolman (#5042) was staging equipment at the area and stated he was waiting for a QC Inspector to perform the visual and MT inspection on both of the back gouged areas prior to welding. This QA Inspector did not observe the inspections during the shift.

In general the work observed 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
