

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-016081**Date Inspected:** 05-Aug-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:** Steve McConnell**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 Pei Wang (# 7299) was setting up to remove the backing strap on the bottom section of the weld using the carbon arc process.
- 2) At weld joint E4/E5 – E1 and E2, outside the OBG section: ABF welding personnel Jeremy Dolman (# 5042) was setting up to perform Flux Cored Arc Welding (FCAW).
- 3) At weld joint E5/E6 – C1 and C2, outside the OBG section: ABF personnel Bryce Howell and a helper had removed the backing strap and were in the process of back gouging the welds.

At weld joint E5/E6 – B, inside the OBG section this QA Inspector observed ABF welding personnel Jin Pei Wang (# 7299) setting up to remove the backing strap on the bottom section of the weld using the carbon arc process. See photo below of backing strap used on the inside of the weld joint to facilitate welding from the outside to complete the weld. QC Inspector Steve McConnell was present.

At weld joint E4/E5 – E1 and E2, outside the OBG section this QA Inspector observed ABF welding personnel

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Jeremy Dolman (# 5042) setting up equipment to perform Flux Cored Arc Welding (FCAW).

At weld joint E5/E6 – C1 and C2, outside the OBG section this QA Inspector observed ABF welding personnel Bryce Howell and a helper had removed the backing strap and were in the process of back gouging the welds. This QA Inspector performed a random visual verification of the work in progress during their morning break and observed the work 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
