

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016157**Date Inspected:** 10-Aug-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 1E/2E-A-S3/S5, 4E/5E, 5E/6E and the following observations were made:

1E/2E-A-S3

Upon the arrival of the QA Inspector at the above identified location, the QA Inspector randomly observed the ABF welder James Zhen preparing to continue the shielded metal arc welding (SMAW) cover pass. The QA Inspector noted the weld was not maintained at 200°F as per the Caltrans Special Provisions "Field Welding" note "C" through out the duration of the welding. The QA Inspector noted the weld was at ambient temperature upon the arrival of the QA Inspector in the am. The QA Inspector noted the weld joint appeared to be approximately 90% complete upon the arrival of the QA Inspector. The QA Inspector randomly observed the ABF welder preheat the material to 200°F utilizing a rosebud torch. The QA Inspector noted the Smith Emery (SE) Quality Control (QC) Inspector John Pagliero was on site monitoring the in process preheats and welding parameters of approved welding procedure identified as ABF-WPS-D1.5-1012-3. The QA Inspector performed a random visual inspection of the in process weld joint and noted it appeared to visually be in general compliance with the contract requirements. The QA Inspector randomly observed the ABF welder remove the E9018 1/8" electrodes from the rod container at 0800. The QA Inspector noted the maximum exposure time for the above identified electrodes is on hour. The QA Inspector randomly observed the ABF welder continue the SMAW fill pass on the above identified weld joint. The QA Inspector noted the SMAW parameters were 130 amps and appeared to be in general compliance with the above identified WPS. The QA Inspector noted the weld joint was completed at the end of the QA Inspectors shift.

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1E/2E-A-S4

Upon the arrival of the QA Inspector it was observed the above identified weld joint was completed. The QA Inspector noted no grinding had been completed at the time of QA Inspectors visit. The QA Inspector noted the ABF welder Xiao Jian Wan was performing the grinding tasks in the am.

1E/2E-A-S5

Upon the arrival of the QA Inspector at the above identified location, the QA Inspector randomly observed the ABF welder Xiao Jian Wan preparing to continue the SMAW cover pass. The QA Inspector noted the weld was not maintained at 200°F as per the Caltrans Special Provisions "Field Welding" note "C" through out the duration of the welding. The QA Inspector noted the weld was at ambient temperature upon the arrival of the QA Inspector in the am. The QA Inspector noted the weld joint appeared to be approximately 95% complete upon the arrival of the QA Inspector. The QA Inspector randomly observed the ABF welder preheat the material to 200°F utilizing a rosebud torch. The QA Inspector noted the SE QC Inspector John Pagliero was on site monitoring the in process preheats and welding parameters of approved welding procedure identified as ABF-WPS-D1.5-1012-3. The QA Inspector performed a random visual inspection of the in process weld joint and noted it appeared to visually be in general compliance with the contract requirements. The QA Inspector randomly observed the ABF welder remove the E9018 1/8" electrodes from the rod container at 0730. The QA Inspector noted the maximum exposure time for the above identified electrodes is on hour. The QA Inspector randomly observed the AB welder continue the SMAW fill pass on the above identified weld joint. The QA Inspector noted the SMAW parameters were 125 amps and appeared to be in general compliance with the above identified WPS. The QA Inspector noted the weld joint was completed at the end of the QA Inspectors shift. After the weld joint was completed, the QA Inspector performed a preliminary visual inspection and noted the completed weld joint needed additional grinding prior to acceptance. The QA Inspector randomly observed the ABF welder move on to the next weld joint.

1E/2E-A-S6

The QA Inspector randomly observed the QC Inspector John Pagliero perform visual testing (VT) of the fit up for the above identified weld joint. The QA Inspector randomly observed the fit up and noted it did appear to meet the general requirements of the contract requirements. The QA Inspector noted the root opening and alignment of the members to be welded were in general compliance with the contract documents. The QA Inspector randomly observed the ABF welder begin setting up to perform the SMAW root pass. The QA Inspector noted the ABF welder did not perform any welding on the QA Inspectors shift.

4E/5E-E

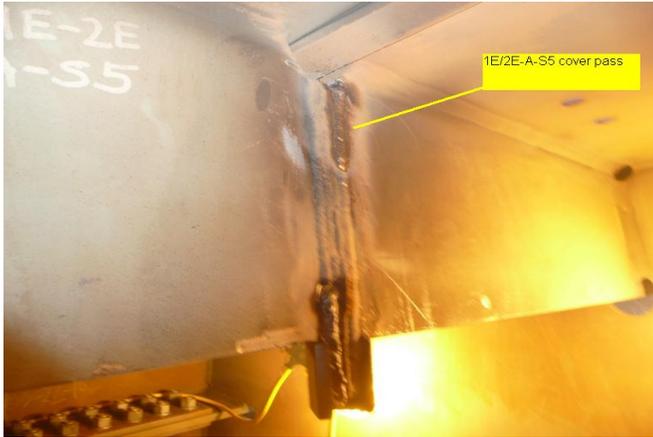
Upon the arrival of the QA Inspector it was observed the flux cored arc welding (FCAW) back weld had been previously completed. The QA Inspector randomly observed the ABF welder Jeremy Doleman performing SMAW pick up welding of areas previously indicated by the QC Inspector Jim Cunningham. The QA Inspector noted small areas of under filled weld joint were indicated with a distinguishing marking directly on the steel. The QA Inspector noted no grinding was completed on this date.

5E/6E-C

The QA Inspector noted the back gouging of the above identified weld joint was complete. The QA Inspector randomly observed the ABF welder Rory Hogan setting up the FCAW tack and equipment in preparation of performing the FCAW back weld. The QA Inspector noted no welding was performed on the QA Inspectors shift.

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Summary of Conversations:

The QA Inspector asked the QC Inspector Mike Johnson if there was any Non Destructive Testing (NDT) ready for QA verifications. Mr. Johnson informed the QA Inspector no NDT was available or ready for any QA verifications.

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
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Reviewed By:	Levell,Bill	QA Reviewer
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