

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016295**Date Inspected:** 18-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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 2W/3W Weld ID: D1, Face A
- 2). OBG Field Splice 3W/4W Weld ID: B1, Face B
- 3). OBG Field Splice 5W/6W Weld ID: C1, Face A
- 4). OBG Field Splice 1E/2E Weld ID: A, LS4, LS5 & LS6.

- 1). OBG Field Splice 2W/3W Weld ID: D1, Face A

The QAI visited the QC Inspector office (conex) and spoke with the QC Inspector Mr. Jesse Cayabyab. See Summary of Conversations below. The QAI performed verification Ultrasonic Testing (UT) of one (1) repair location in OBG Field Splice 2W/3W weld D1 from Face A. The QAI inspected 55mm of Weld D1 from Y = 240mm to Y = 295mm. Weld D1 was verified by the QAI and found to be in general compliance with contract documents. See Ultrasonic Testing Report Form TL-6027 generated by the QAI on this date. Prior to performing UT, the QAI observed of the B face (exterior) at the location rejected by the QAI on 8-17-10 that it appeared to have been ground.

- 2). OBG Field Splice 3W/4W Weld ID: B1, Face B

The QAI performed verification Magnetic Particle Testing (MT) of 10% of the length of OBG Field Splice 3W/4W Weld ID: B1 from Face B. Weld B1 was verified by the QAI and found to be in general compliance with contract documents. See Magnetic Particle Testing Report Form TL-6028 generated by the QAI on this date.

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3). OBG Field Splice 5W/6W Weld ID: C1, Face A

The QAI periodically observed AB/F approved welder Song Tao Huang (ID 3794) performing welding per the Flux Cored Arc Welding (FCAW-G) process in the 3G (vertical) position of fill and cover passes on weld ID: C1. See photo below. The QAI observed 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-D1.5-3042B-1. The QAI observed the QC Inspector monitoring and recording the welding parameters and observed the following: 24.3 welding volts, 243 welding amps and travel speed of 290mm/min. The QAI observed that the work at this location appeared to be in general compliance with contract documents.

4). OBG Field Splice 1E/2E Weld ID: A, LS4, LS5 & LS6.

The QAI performed verification Magnetic Particle Testing (MT) of 10% of the lengths of OBG Field Splice 1E/2E weld ID: A, LS4, LS5 & LS6. The welds verified by the QAI were found to be in general compliance with contract documents. See Magnetic Particle Testing Report Form TL-6028 generated by the QAI on this date.



Summary of Conversations:

From Item 1).

The QAI asked QC Mr. Cayabyab what the final outcome was from the QC confirmation testing of the area located by the QAI on 8-17-10. Mr. Cayabyab stated that the area had been ground on the outside at the indication location. He stated that the indication is gone now and the QAI could retest it. Later after performing the UT verification testing the QAI was approached by QC Inspector Mike Johnson who asked the QAI what the outcome of the QAI UT was. The QAI stated that the UT results were acceptable.

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 Materials for your project.

Inspected By: Madison, Bert

Quality Assurance Inspector

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Reviewed By: Levell,Bill

QA Reviewer