

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016540**Date Inspected:** 31-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 as "A" stiffeners, hole restoration, and the following observations were made:

1E-pp8.5-E3-4

The QA Inspector randomly observed the ABF welder identified as Jin Pei Wang performing grinding tasks on the above identified back gouged weld joint. The QA Inspector randomly observed the Smith Emery (SE) Quality Control (QC) Inspector John Pagliero perform visual testing several times in an attempt to clear or accept the back gouged weld joint. The QA Inspector randomly observed the back gouged weld joint and noted visible slag inclusions were present and additional grinding would be required. The QA Inspector noted the ABF welder spent the remainder of the QA Inspectors shift performing grinding tasks of the above identified weld joint.

3E/4E-A-LS-5

Upon the arrival of the QA Inspector at the above identified location, the QA Inspector randomly observed the ABF welder Xiao Jian Wan had completed the SMAW cover pass from one side of the weld joint. The QA Inspector randomly observed the ABF helper was performing grinding of the weld reinforcement from one side of the weld joint as well as performing grinding of the back gouge. 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 above identified stiffener plate and noted the production welding appeared to be approximately 50% from one side only.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

The QA Inspector randomly observed the ABF welder remove the E9018 1/8" electrodes from the rod container at 0830. 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 passes 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 ABF welder completed the above identified weld joint from one side and continued to perform welding from the back side of the weld joint or back weld.

3E/4E-A-LS-1

The QA Inspector randomly observed the ABF welder identified as Hua Qiang Huang was preparing to fit up the above identified weld joint. The QA Inspector randomly observed the two member to be fit up appeared to have planar misalignment which exceeded the maximum allowable for the given thickness. The QA Inspector noted the above identified weld joint did have approximately 6.5mm of unacceptable planar misalignment of the two member being joined. The QA Inspector noted the contractor was given a verbal notification per Structure Material Representative Patrick Lowry to proceed with welding. The QA Inspector noted per the SMR the contract is to correct the planar misalignment by welding and transitioning the weld with a 2.5:1 ratio. The QA Inspector performed visual testing of the root opening and noted it appeared to be with the general requirements of the contract documents. The QA Inspector noted the root opening was 6mm at the top, 5mm in the middle and 4.5mm at the bottom of the weld joint. 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.

Summary of Conversations:

No pertinent conversation noted.

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
Reviewed By:	Levell,Bill	QA Reviewer
