

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-016547**Date Inspected:** 27-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 Fillet Welding 3W Weld ID: - (Drip Edge)
- 2). OBG Field Splice 5W/6W Weld ID: C1 & C2, Face B - (Grinding)
- 3). OBG Field Splice 5W/6W Weld ID: E1 & E2, Face A - (FCAW-G in process)
- 4). OBG Field Splice 2E/3E Weld ID: A LS1 - (QC NDE)
- 5). OBG Field Splice 2E/3E Weld ID: A LS1 - (QAI Verification)

- 1). OBG Fillet Welding 3W Weld ID: Drip Edge

The QAI periodically observed AB/F approved welder Rick Clayborn (ID 2773) performing fillet welding and partial penetration welding per the Shielded Metal Arc Welding (SMAW) process in the 4F (overhead) and 3F (vertical) positions to install drip edge pieces. QC Inspector Tony Sherwood was periodically 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-F1202 & ABF-WPS-D1.5-1030. The QAI observed that the work appeared to be in general compliance with contract documents.

- 2). OBG Field Splice 5W/6W Weld ID: C1 & C2, Face B

The QAI periodically observed ABF personnel performing grinding at temporary attachment removal areas. When grinding was completed the QAI periodically observed the same AB/F personnel setting up to perform plasma cutting to remove the backing bar at this location. The work at this location was in process for the

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remainder of the QA Inspectors shift.

3). OBG Field Splice 5W/6W Weld ID: E2, Face A

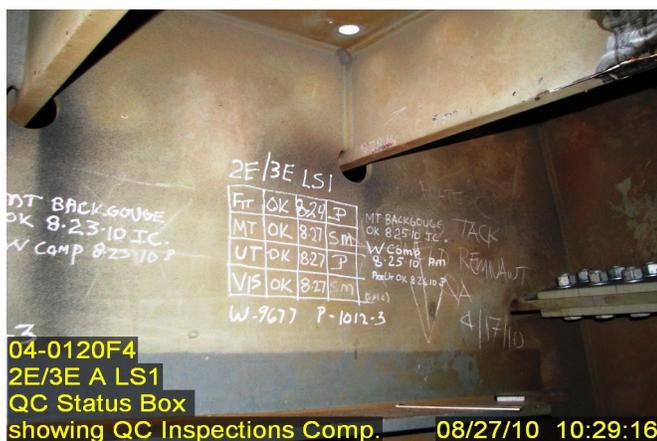
The QAI periodically observed AB/F approved welder Jin Quan Huang (ID 9340) performing welding per the SMAW process in the 3G (vertical) position of root passes on weld ID: E2. The QAI observed QC Inspector Tony Sherwood was present to monitor the progress and verify that the welding parameters were within the limits established by the approved Welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1040A. The QAI observed that the work at this location was in process for the duration of the shift and appeared to be in general compliance with contract documents.

4). OBG Field Splice 2E/3E Weld ID: A LS1 - (QC NDE)

The QAI observed QC Inspector Salvador Merino performing Magnetic Particle Testing (MT) of both faces of OBG Field Splice 2E/3E Weld ID: A LS1. The QAI observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. After the QC MT was completed the QC Mr. Merino signed off the QC box on the steel. Later in the shift the QAI periodically observed QC Inspector John Pagliero performing UT from both faces of OBG Field Splice 2E/3E Weld ID: A LS1. See photo below. The QAI observed that Mr. Pagliero utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4 during the examination of the splice weld. The QC technician performed the required longitudinal wave testing utilizing a 1" diameter transducer for base metal soundness and performed the required shear wave testing during the testing for weld soundness utilizing a .63 x .75 rectangular transducer. The UT examination was completed and the QC Mr. Pagliero signed off the QC box on the steel. See photo below. The work at this location appeared to be in general compliance with contract documents. See Summary of Conversations below.

5). OBG Field Splice 2E/3E Weld ID: A LS1 - (QAI Verification)

The QAI performed verification Magnetic Particle Testing (MT) of 25% and Ultrasonic Testing (UT) of 100% of the length of OBG Field Splice 2E/3E Weld ID: A LS1. The weld verified by the QAI appeared to be in general compliance with contract documents. See Ultrasonic Testing Report Form TL-6027 and Magnetic Particle Testing Report Form TL-6028 generated by the QAI on this date. See Summary of Conversations below.



Summary of Conversations:

From Item 4).

The QAI in a conversation with QC John Pagliero was told that OBG Field Splice 2E/3E Weld ID: A LS1 was found to be acceptable by QC and that the QAI could perform the QA Verification testing. The QAI asked Mr.

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Pagliero to please report his testing results to the Lead QC Inspector Bonafacio Daquinag Jr. Later in the shift the QAI approached Mr. Daquinag and asked if the OBG Field Splice 2E/3E Weld ID: A LS1 was ready for QAI verification. Mr. Daquinag asked QC Steve McConnell if the weld in question was ready for QAI verification. Mr. McConnell asked Mr. Paglieri and was told that it was ready.

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
Reviewed By:	Levell,Bill	QA Reviewer
