

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-016550**Date Inspected:** 31-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 1W/2W Weld ID: A LS1, A LS2 and A LS6 - (SMAW)
- 2). OBG Field Splice 4W/5W Weld ID: E1 & E2, Face B - (FCAW-G)
- 3). OBG Field Splice 5W/6W Weld ID: C1 & C2, Face B - (Plasma Cutting)
- 4). OBG Field Splice 5W/6W Weld ID: B1 - (QAI Verification)

- 1). OBG Field Splice 1W/2W Weld ID: A LS1, A LS2 and A LS6 - (SMAW)

The QAI periodically observed AB/F approved welders Wai Kitlai (ID 2953) and Yao Xin Liang (ID 7238) performing welding per the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position to butter the bevel faces. Mr. Wai Kitlai was welding at A LS1 & A LS2 and Mr. Yao Xin Liang was welding at A LS6. QC Inspector Tom Pasqualone and later Tony Sherwood were 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-D1.5-1012-3. The QAI observed QC Mr. Tom Pasqualone checking the welding parameters while each of the welders welded on a test piece. See photos below. The QAI also periodically observed that AB/F approved welder Kenneth Chappell was present and that Mr. Chappell periodically supplied 9018 electrodes to the welders at this location and returned their unused electrodes to a drying oven located in the Eastbound line. 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.

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2). OBG Field Splice 4W/5W Weld ID: C1 and C2, Face B - (FCAW-G)

The QAI periodically observed AB/F approved welder Rory Hogan (ID 3186) performing welding per the Flux Cored Arc Welding (FCAW-G) process in the 4G (overhead) position of fill passes in the prepared groove on the exterior of the field splice. The QAI observed QC Inspector Jim Cunningham 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-D1.5-3042A. 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.

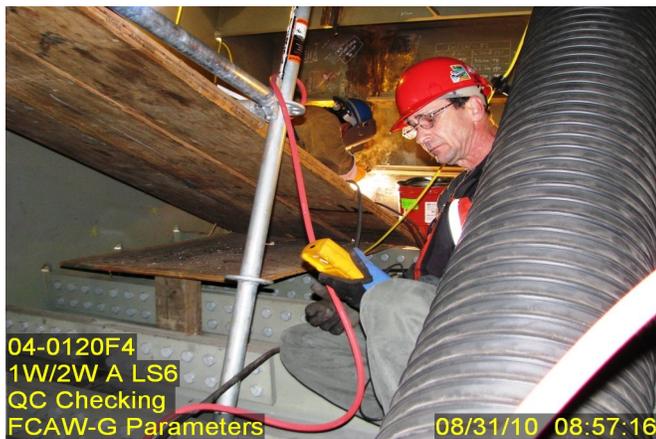
3). OBG Field Splice 5W/6W Weld ID: C1 & C2, Face B - (Plasma Cutting)

The QAI periodically observed ABF personnel performing Plasma Cutting to remove the backing bar and prepare a groove for back welding. The work at this location was in process for the remainder of the QA Inspectors shift.

4). OBG Field Splice 5W/6W Weld ID: B1 - (QAI Verification)

The QAI spoke with QC Inspector Mr. Jesse Cayabyab. See Summary of Conversations below.

The QAI performed verification Ultrasonic Testing (UT) of 20% of the length of OBG Field Splice 5W/6W Weld ID: B1. The weld verified by the QAI appeared to be in general compliance with contract documents. See Ultrasonic Testing Report Form TL-6027 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 Jesse Cayabyab was told that OBG Field Splice 5W/6W Weld ID: B1 was found to be acceptable by QC and that the QAI could perform the QA Verification testing.

Other conversations on this date with Quality Control Inspectors were general in nature and pertained to locations of welding and QC activities.

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.

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Inspected By:	Madison,Bert	Quality Assurance Inspector
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Reviewed By:	Levell,Bill	QA Reviewer
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