

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016643**Date Inspected:** 07-Sep-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: ALS3, ALS4, ALS5 and A LS6 - (SMAW)
- 2). OBG Field Splice 4W/5W Weld ID: E1 & E2, Face B - (FCAW-G)
- 3). OBG Field Splice 4W/5W Weld ID: B1, Face B - (QAI Verification)

- 1). OBG Field Splice 1W/2W Weld ID: A LS1 and A LS5 - (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. Mr. Wai Kitlai was welding fill passes on face A at A LS3 with ceramic backing and later grinding and back welding on face B. Mr. Yao Xin Liang was welding fill passes from face B at A LS4. QC Inspector Tom Pasqualone 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-D1.5-1012-3. The QAI also observed QC Mr. Pasqualone performing Magnetic Particle Testing (MT) of the face B sides of ALS3, ALS4, ALS5 and ALS6 prior to back welding at these locations. 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 any 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: E1 & E2 – (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 and cover passes in the prepared groove on the exterior (face B) 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 4W/5W Weld ID: B1, Face A - (QAI Verification)

The QAI performed verification Magnetic Particle Testing (MT) of 20% of the length of OBG Field Splice 4W/5W Weld ID: B1 from face A (exterior). The 4W/5W Weld ID: B1 verified by the QAI from face A (exterior) from Y = 100mm to Y = 400mm appeared 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:

At the beginning of the shift the QAI observed the QC NDE status board in the QC Conex office and later spoke with QC Inspector Bonafacio Daquinag Jr. The QAI observed that the latest entry on the board stated that OBG Field Splice 5W/6W welds C1 & C2 were ready for QAI verification testing but the date was stated as 9/8/10. The QAI asked Mr. Daquinag if the entry was ready or would not be ready until 9/8/10. Mr. Daquinag stated that he wasn't sure but that QC Mr. Jesse Cayabyab would know however he was not present on this date.

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.

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