

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-016703**Date Inspected:** 09-Sep-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 hole restoration and 6E/7E-A the following observations were made:

1E-pp9.5-E3-2

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. The QA Inspector randomly observed the SE QC Inspector perform magnetic particle testing (MT) of the back gouged weld joint and noted no relevant indications were located at the time of the testing. After the grinding was completed the QA Inspector randomly observed the ABF welder begin performing the SMAW back weld for the above identified weld joint. The QA Inspector noted the base metal and the weld joint were preheated to approximately 150°F and back welding was commenced. The QA Inspector randomly observed the ABF welder to be utilizing 1/8" E7208 low hydrogen electrodes with 130 Amps. The QA Inspector noted the SMAW back weld was not completed on the QA Inspectors shift.

6E/7E-A1-A5

Upon the arrival of the QA Inspector in the am it was observed the above identified weld joint was previously jointed by welding. The QA Inspector noted the full length tack weld was completed. The QA Inspector randomly observed the ABF welders identified as Song Tao Huang and James Zhen continued performing the FCAW fill/cover passes at the ends of the weld joint. The QA Inspector was informed by the American Bridge/Fluor (ABF) welding Superintendent Dan Ieraci no runoff tabs would be utilized on this transverse weld splice (see

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summary of conversation). The QA Inspector randomly observed the Smith Emery (SE) Quality Control (QC) Inspector Tony Sherwood was on site monitoring the in process FCAW. The QA Inspector randomly observed and noted the FCAW parameters for both of the above identified ABF welders and they were; 280 Amps, 24.2 Volts and a travel speed of 350mm/min. The QA Inspector randomly observed the ABF welders continued welding the ends of the weld joint. The QA Inspector randomly observed the ABF welder Song Tao Huang was welding fill/cover of the last 300mm of the weld segment A5 and the ABF welder James Zhen was welding the first 550mm of weld segment A1. The QA Inspector randomly observed and performed dimensional measurements of the areas where planar misalignment was previously located and indicated. The QA Inspector randomly observed the material was approximately 350°F at the time of the measurements. The QA Inspector randomly observed the previous measurements taken and recorded on the planar misalignment map had changed by approximately 1mm in weld segment A1. The QA Inspector noted the off set was approximately 1mm greater than previously measured at ambient temperature. The QA Inspector performed the same dimensional measurements in weld segment A5 and noted no change in dimensional measurements and previously observed.

Summary of Conversations:

No pertinent conversation noted on this date.

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
