

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-016707**Date Inspected:** 11-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 Welding of Lower Lug Restoration between PP12 - PP13 - (SMAW)
- 2). OBG Field Splice 4W/5W Welds D1 & D2, Face B (FCAW-G)
- 3). OBG Field Welding of East Line Lifting Lug Access Hole Restoration - (SMAW)
- 4). OBG Field Welding of East Line Access Hole Restoration – (Fit-up)

- 1). OBG Field Welding of Lower Lug Restoration between PP12 - PP13 - (SMAW)

The QAI periodically observed AB/F approved welder Darcell Jackson (ID 9967) performing CJP welding per the Shielded Metal Arc Welding (SMAW) process in the 2G (horizontal) and 4G (overhead) positions to restore a portion of the counter weight assembly lower lug at the edge plate at W1. QC Inspector Mike Johnson 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-D1.5-1000. The QAI observed that the work appeared to be in general compliance with contract documents.

- 2). OBG Field Splice 4W/5W Weld ID: D1, Face B (FCAW-G)

The QAI periodically observed the in process welding of OBG Field Splice 4W/5W weld ID: D1 Face B per the Flux Cored Welding (FCAW-G) process in the 4G (overhead) position by ABF welding personnel Rory Hogan (ID 3186). QC Inspector Jim Cunningham 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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

as ABF-WPS-D1.5-3040A-4. The QAI observed that the work at this location appeared to be in general compliance with contract documents. Welding was in process for the remainder of this shift.

3). OBG Field Welding of East Line Lifting Lug Access Hole Restoration - (SMAW)

The QAI periodically observed the fit-up and welding per the SMAW process to restore the Lifting Lug Access holes in the A deck at PP15. The QAI observed that AB/F approved welder Yao Xin Liang (ID 7238) was working at weld E3-3 and that AB/F approved welder Wai Kitlai (ID 2953) was working at weld E4-3. See photos below. QC Inspector Mike Johnson 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-D1.5-1050B. Welding from the exterior was completed at these locations on this date. The QAI observed that the work appeared to be in general compliance with contract documents.

4). OBG Field Welding of East Line Access Hole Restoration - (Fit-up)

The QAI periodically observed AB/F approved welder Fred Kaddu (ID 2188) performing the edge preparation and fit-up of the access hole restoration in the A deck between PP10 & PP11 on the Bike Path side and Crossbeam side of OBG 1E.

5). The QAI performed a job site walk through and noted the current welding and NDE status of the OBG at the job site. After the information was gathered in the field the QA Inspector updated the Caltrans QA Production/NDT tracking log and transferred the information to the chart in the Caltrans SAS office at the job site. The QAI also reviewed contract documents.



Summary of Conversations:

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Madison,Bert

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer