

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-016712**Date Inspected:** 08-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1100**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** John Pagliero**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:** OBG Section**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and to monitor American Bridge/Fluor (ABF) welding operations.

The following observations were made:

- 1) At weld joints E6/E7 – D1 and D2, inside the OBG section: ABF welding personnel Xiao Jian Wan (#9677) was using the Flux Cored Arc Welding (FCAW) process to produce a continuous tack weld on both sides of the weld joint for the full length. QC Inspector John Pagliero was present.
- 2) At weld joints E4/E5 - LS-4, 5 and 6: ABF welding personnel Todd Jackson (#4639) was performing Shielded Metal Arc Welding (SMAW) to fill various low areas marked by QC Inspector John Pagliero.
- 3) At weld joints E5/E6 – D1 and D2, outside the OBG section: ABF welding personnel Fred Kaddu (#2188) was setting up a grinding various excavations for repairs.
- 4) At weld joints E4/E5 - LS-1, 2 and 3: ABF welding personnel Hua Qiang Hwang (#2930) was performing grinding on LS-2 to prepare the back gouged area for QC inspections. QC Inspector John Pagliero was present.

At weld joints E6/E7 – D1 and D2, inside the OBG section this QA Inspector observed ABF welding personnel Xiao Jian Wan (#9677) was using the Flux Cored Arc Welding (FCAW) process to produce a continuous tack

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weld on both sides of the weld joint for the full length of the weld. This QA Inspector randomly observed QC Inspector John Pagliero verify the following FCAW welding parameters: 235 amperes and 22.8 volts at a travel speed of 284 mm per minute. The welding observed appeared to comply with ABF-WPS-D15-F3200-2.

At weld joints E4/E5 - LS-4, 5 and 6 this QA Inspector observed ABF welding personnel Todd Jackson (#4639) was performing Shielded Metal Arc Welding (SMAW) to fill various low areas previously marked by QC Inspector John Pagliero. This QA Inspector performed a verification of the SMAW welding parameters and observed the following: 130 amperes using a 3.2 mm diameter E9018H4R electrode. This QA Inspector verified the surrounding base metal was preheated to a temperature greater than 100° C. The welding observed appeared to comply with ABF-WPS-D15-1012-3. This QA Inspector observed QC Inspector John Pagliero was present at various times and monitoring the welding being performed.

At weld joints E5/E6 – D1 and D2, outside the OBG section this QA Inspector observed ABF welding personnel Fred Kaddu (#2188) was setting up to start excavations by grinding for various repairs. Later in the shift this QA Inspector observed ABF welding personnel Fred Kaddu (#2188) had started grinding two excavations but did not witness welding being performed during the shift.

At weld joints E4/E5 - LS-1, 2 and 3 this QA Inspector observed ABF welding personnel Hua Qiang Hwang (#2930) was performing grinding on LS-2 to prepare the back gouged area for QC inspections. QC Inspector John Pagliero was present.

Summary of Conversations:

As noted above.

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:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
