

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-016746**Date Inspected:** 13-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 and Drip Edge Restoration between PP12 - PP13
- 2). OBG Field Splice 4W/5W Welds D1 & D2, Face B (FCAW-G)
- 3). OBG Field Splice 3E/4E Weld ALS5 Face A and B (QAI Verification)
- 4). OBG Field Splice 6E/7E Welds D1 & D2, Face A (SMAW)

- 1). OBG Field Welding of Lower Lug and Drip Edge Restoration between PP12 - PP13

The QAI periodically observed AB/F approved welder Rick Clayborn (ID 2773) performing CJP welding per the Shielded Metal Arc Welding (SMAW) process in the 2G (horizontal) position 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. Later in the shift the QAI observed Mr. Clayborn performing fillet welding and partial penetration welding per the SMAW process in the 4F (overhead) and 3F (vertical) positions to restore drip edge sections. The QAI periodically observed 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 Specifications identified as ABF-WPS-D1.5-F1202 & ABF-WPS-D1.5-1030. The QAI observed that the work appeared to be in general compliance with contract documents.

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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 as ABF-WPS-D1.5-3040A-4. Welding was completed at this location and the QAI observed that the work appeared to be in general compliance with contract documents.

3). OBG Field Splice 3E/4E Weld ALS5 Face A and B (QAI Verification)

The QAI performed verification Visual Testing (VT) of 100%, Magnetic Particle Testing (MT) of 30% and Ultrasonic Testing (UT) of 100% of the lengths of OBG Field Splice 3E/4E Weld ID: ALS5. The 3E/4E Weld ID: ALS5 verified by the QAI appeared to be in general compliance with contract documents. See Ultrasonic Testing Report Form TL-6027 and Magnetic Particle Testing Report Form TL-6028 generated by the QAI on this date.

4). OBG Field Splice 6E/7E Welds D1 & D2, Face A (SMAW)

The QAI periodically observed AB/F approved welders Song Tao Huang (ID 3794) and James Zhen (ID 6001) performing welding per the SMAW process to complete the outer 300mm of welds D1 and D2. Welder 3794 was welding on D2 and welder 6001 was welding on D1. See photos below. QC Inspector John Pagliero 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-D1.5-1040C. Welding was complete at these locations on this date. The QAI observed that the work appeared to be in general compliance with 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.

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Inspected By: Madison,Bert

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer