

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-016858**Date Inspected:** 20-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 4W/5W Weld ID: C1 & C2, Face A (SMAW Repairs)
- 2). OBG Field Splice 4W/5W Weld E1 & E2, Face A (QAI Verification)
- 3). OBG Field Splice 5W/6W Weld E2, Face B (FCAW-G)
- 4). OBG Field Splice 6E/7E weld ID: B1, Face B (SMAW)
- 5). OBG Field Splice 6E/7E weld ID: E1, Face A (SMAW)

- 1). OBG Field Splice 4W/5W Weld ID: C1 & C2 - Face A (SMAW Repairs)

The QAI periodically observed AB/F approved welder Fred Kaddu (ID 2188) performing welding per the Shielded Metal Arc Welding (SMAW) process in the 3G position. Mr. Kaddu was welding (3) three excavated UT rejected areas on the A face (interior) of the OBG Field Splice 4W/5W Weld ID: C1. QC Inspector Steve McConnell 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-D1.5-1000 Repair. The welding of the 3 excavated areas was complete and the QAI periodically observed that Mr. Kaddu excavated other areas in weld C2 where UT rejects were found by QC on 09-18-10. Work was in process at this location and appeared to be in general compliance with contract documents.

- 2). OBG Field Splice 4W/5W Weld E1 & E2, Face B (QAI Verification)

The QAI performed verification Ultrasonic Testing (UT) of 10% of the lengths of OBG Field Splice 4W/5W Weld

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

ID: E1 & E2. The 4W/5W Weld ID: E1 & E2 verified by the QAI appeared to be in general compliance with contract documents. See Ultrasonic Testing Report Form TL-6027 generated by the QAI on this date.

3). OBG Field Splice 5W/6W Weld E2, Face B (FCAW-G)

The QAI periodically observed the in process welding of OBG Field Splice 5W/6W Weld ID: E2, Face B (exterior) per the Flux Cored Arc Welding (FCAW-G) process in the 4G (overhead) position by AB/F approved welder 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-D1.5-3042A-1. The QAI observed that the work was in process at this location and appeared to be in general compliance with the contract documents.

4). OBG Field Splice 6E/7E weld ID: B1, Face B (SMAW)

The QAI periodically observed the in process welding of OBG Field Splice 6E/7E weld ID: B1, on the B Face (interior) per the SMAW process in the 3G (vertical) position by ABF welding personnel James Zhen (ID 6001). See photo below. QC Inspector John 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-D1.5-1110-A. The work at this location was in process during this shift. The QAI observed that work at this location appeared to be in general compliance with the contract documents.

5). OBG Field Splice 6E/7E weld ID: E1, Face A (SMAW)

The QAI periodically observed the in process welding of OBG Field Splice 6E/7E weld ID: E1, on the A Face (interior) per the SMAW process in the 3G (vertical) position by ABF welding personnel Xiao Jian Wan (ID 9677). See photo below. QC Inspector John 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-D1.5-1110-A. The work at this location was in process during this shift. The QAI observed that work at this location appeared to be in general compliance with the 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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
