

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-016995**Date Inspected:** 23-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 the following observations were made:

1E-pp9.5-E4-2

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 several times in an attempt to clear or accept the back gouged weld joint. The QA Inspector randomly observed the back gouged weld joint and noted visible slag inclusions were present and additional grinding would be required. 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 125 Amps. The QA Inspector noted the weld joint was not completed on this

6W/7W-A1-A5

Upon the arrival of the QA Inspector in the am it was observed the above identified weld joint was fit up with the approved temporary attachments or fit up gear in place. The QA Inspector randomly observed the ABF welders identified as Song Tao Huang and James Zhen continued performing the FCAW full length tack weld. The QA Inspector randomly observed the Smith Emery (SE) Quality Control (QC) Inspector Tony Sherwood was on site monitoring the in process FCAW tack welding. The QA Inspector randomly observed and noted the FCAW

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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 full length tack weld was approximately 80% completed as 1000. The QA Inspector noted the ABF welders had held back in the areas where the gaps at the steel backing exceeded 2mm and required approval to weld. The QA Inspector noted the approval to weld the areas was granted on the previous day shift. The QA Inspector randomly observed the ABF welder Hua Qiang Huang begin performing SMAW of the areas where the gaps exceeded 2mm. The QA Inspector noted the full length tack weld was nearly completed at the end of the QA Inspectors shift. The ABF welding Superintendent Dan Ieraci informed the QA Inspector the SAW root pass would be performed in the morning of the next day shift.

1E-9.5/8.5-E3-1-4

The QA Inspector randomly observed two ABF representatives performing grinding tasks ultrasonic testing rejects in the above identified lifting lug deck hole restoration. The QA Inspector noted no welding was performed only excavations of previously tested welds.

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:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
