

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-017003**Date Inspected:** 24-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 6W/7W-A and hole restoration, and the following observations were made:

1E-pp9.5-E4-4

The QA Inspector randomly observed the ABF welder identified as Jin Pei Wang performing grinding tasks on the above identified back gouged weld joint. After the grinding was completed the QA Inspector randomly observed the ABF welder continue 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" E7018 low hydrogen electrodes with 125 Amps. The QA Inspector noted the weld joint was completed on this date.

6W/7W-A1-A5**A3-A1**

The QA Inspector randomly observed the ABF welding operator Mike Maday begin welding the SAW root pass in the center of A3 and weld to the end of section A1. The QA Inspector randomly observed the SAW parameters and they were 551 Amps, 33.2 Volts and a travel speed of 381mm/min. The QA Inspector noted the SAW parameters appeared to be in general compliance with ABF-WPS-D1.5-4042B-1. After the root pass was completed between the center of A3-A1, the SE QC Inspectors performed MT of the root pass. The QA Inspector noted no relevant indications were located at the time of the testing. After some minor grinding and blending the QA Inspector randomly observed the ABF welder continue performing the SAW fill passes. The QA Inspector

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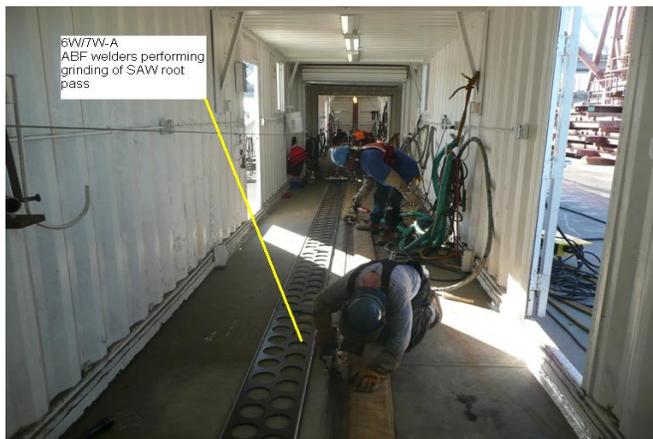
randomly observed the ABF welding operators performing the SAW fill passes for the remainder of the shift.

A3-A5

The QA Inspector randomly observed the ABF welding operator James Zhen begin welding the SAW root pass in the center of A3 and weld to the end of section A5. The QA Inspector randomly observed the SAW parameters and they were 560 Amps, 32.3 Volts and a travel speed of 394mm/min. The QA Inspector noted the SAW parameters appeared to be in general compliance with ABF-WPS-D1.5-4042B-1. After the root pass was completed between the center of A3-A5, the SE QC Inspectors performed MT of the root pass. The QA Inspector noted no relevant indications were located at the time of the testing. After some minor grinding and blending the QA Inspector randomly observed the ABF welder continue performing the SAW fill passes. The QA Inspector randomly observed the ABF welding operators performing the SAW fill passes for the remainder of the shift.

1E-8.5-E3-1-4

The QA Inspector randomly observed Jin Pei Wang performing grinding tasks of 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. The QA Inspector randomly observed the ABF welder had excavated all UT rejections in the 3 completed weld joints at 1E-9.5-E3. The QA Inspector noted the ABF welder moved to the above identified weld joint and continued excavating the weld joints. The ABF welding Superintendent Dan Ieraci informed the QA Inspector all of the excavations of the UT rejections will be done prior to any welding being performed. After the excavations are complete weld repairs will likely be started on 9-27-10.



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

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Reviewed By: Levell,Bill

QA Reviewer