

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-017244**Date Inspected:** 05-Oct-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 2E-pp13.5-E2-SW Access Hole Restoration and the following observations were made:

2E-pp13.5-E2-SW Access Hole Restoration

The QA Inspector randomly observed the American Bridge/Fluor (ABF) welder Wai Kit Lai setting up to continue performing the shielded metal arc welding (SMAW) back weld. The QA Inspector previously performed random visual testing and dimensional verification of the bevel angle and root opening of the above identified fit up. The QA Inspector randomly observed the fit up appeared to be in general compliance with ABF-WPS-D1.5-1030. Upon the arrival of the QA inspector, it was noted the SMAW 4G back weld appeared to be approximately 50% complete. The QA Inspector randomly observed the SE QC Inspector John Pagliero was on site monitoring the in process welding. The QA Inspector randomly observed the SMAW parameter were 125 Amps while utilizing 1/8" E7018 low hydrogen electrodes. The QA Inspector noted the SMAW parameters appeared to be in general compliance with the contract requirements. The QA Inspector randomly observed the ABF welder completed the 4G back weld at approximately 1300.

The QA Inspector spent the remainder of the shift walking the East and West Bound bridge deck mapping and recording the identifications for the access holes. After the identifying marks were recorded the QA Inspector generated a NDT tracking log as well as UT reject tracking for Caltrans METS QA records. The tracking logs are on site for review.

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The QA Task Lead Bill Levell informed the QA Inspector the contractor has approval as of 1430 to make weld repairs at the following locations:

5E/6E-D1-to excavate and repair a 4th time weld defect, Per Mohammad Fatemi

6E/7E-A1-to excavate and repair a transverse crack at the steel backing, Per Patrick Lowry

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
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