

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-017449**Date Inspected:** 15-Oct-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 6W/7W Weld ID: C1 & C2, Face A - (FCAW-G & SMAW)
- 2). OBG Field Splice 7W/8W Weld ID: B1, Face A - (SMAW)
- 3). OBG Field Splice 7W/8W Weld ID: F1, Face A - (SMAW)

- 1). OBG Field Splice 6W/7W Weld ID: C1 & C2, Face A - (FCAW-G)

The QAI periodically observed AB/F approved welder Song Tao Huang (ID 3794) assisted by AB/F approved welder Jin Quang Huang (ID 9340) performing semi automatic welding per the Flux Cored Arc Welding (FCAW-G) process in the 3G (vertical) position of cover passes on weld ID: C1 & C2. The QAI observed QC Inspector Tony Sherwood 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-D1.5-3042B-1. Later in the shift the QAI periodically observed AB/F approved welder Song Tao Huang (ID 3794) performing welding per the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position of the root pass on weld ID: C1. The QAI observed QC Inspector Tony Sherwood 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-D1.5-1040B. The QAI observed that the work at this location was in process for the duration of the shift and appeared to be in general compliance with contract documents.

- 2). OBG Field Splice 7W/8W Weld ID: B1, Face A - (SMAW)

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The QAI periodically observed the in process welding root and fill passes at OBG Field Splice 7W/8W weld ID: B1, from the A face per the SMAW process in the 3G (vertical) position by AB/F approved welder Jin Pei Wang (ID 7299). QC Inspector Tony Sherwood 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-D1.5-1040B. The work at this location was in process for the duration of the QA Inspector's shift and appeared to be in general compliance with the contract documents. See photo below.

3). OBG Field Splice 7W/8W Weld ID: F1, Face A – (SMAW)

The QAI periodically observed the in process welding fill passes at OBG Field Splice 7W/8W weld ID: F1, from the A face per the SMAW process in the 3G (vertical) position by AB/F approved welder James Zhen (ID 6001). QC Inspector Tony Sherwood 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-D1.5-1040B. The work at this location was in process for the duration of the QA Inspector's shift and appeared to be in general compliance with the contract documents. See photo below.

The QAI performed the required Equipment Qualification Procedures for the USN 60 s/n 01X2BB and the USN58 s/n 01X0V2. The QAI performed the Horizontal Linearity Procedure per AWS D1.5 section 6.22.1 and the Decibel dB Accuracy Procedure per AWS D1.5 section 6.22.2.



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.

Inspected By: Madison, Bert

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer
