

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-017479**Date Inspected:** 19-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:** 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, Face A - (SMAW)
- 2). OBG Field Splice 7W/8W Weld ID: B1, Face B - (SMAW)
- 3). OBG Field Splice 7W/8W Weld ID: F1, Face B - (SMAW)
- 4). OBG Field Splice 7W/8W Weld ID: D2, Face A - (SMAW)

- 1). OBG Field Splice 6W/7W Weld ID: C1, Face A - (SMAW)

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 fill and cover passes on the first 1000mm of OBG Field Splice 6W/7W 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-D1.5-3042B-1. The QAI observed that the work at this location was completed and appeared to be in general compliance with contract documents.

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

The QAI periodically observed AB/F approved welder Jin Pei Wang (ID 7299) performing back grinding and subsequently the in process welding per the SMAW process in the 3G (vertical) position of fill and cover passes at OBG Field Splice 7W/8W weld ID: B1, from the B face. QC Inspector Tony Sherwood performed Magnetic Particle Testing (MT) of the interior surface after back grinding and prior to production welding. The QAI

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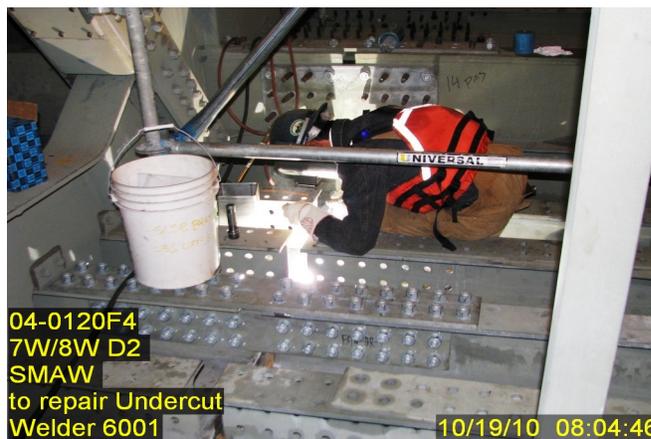
observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. The QAI observed that QC Inspector Tony Sherwood was present to monitor the progress and verify that the welding parameters were within the limits established by the 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 B – (SMAW)

The QAI periodically observed AB/F personnel performing back grinding and subsequently the QAI periodically observed the in process welding per the SMAW process in the 3G (vertical) position of fill and cover passes at OBG Field Splice 7W/8W weld ID: F1, from the B face 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 welding 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.

4). OBG Field Splice 7W/8W Weld ID: D2, Face A – (SMAW)

The QAI periodically observed AB/F approved welder James Zhen (ID 6001) welding per the SMAW process in the 1G (flat) position to repair undercut at the toes of the SAW passes at OBG Field Splice 7W/8W weld ID: D2, from the A face. The QAI observed that 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-D1.5-1040A. The welding at this location appeared to be completed during the QA Inspector's shift and appeared to be in general compliance with the contract documents. See photo below.



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

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Materials for your project.

Inspected By: Madison, Bert

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer