

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-017486**Date Inspected:** 14-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1100**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Pat Swain**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:** OBG Section**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and to monitor American Bridge/Fluor (ABF) welding operations.

The following observations were made:

- 1) Access Plate 2E-PP-17.5-E2-SW, outside the OBG section: ABF welding personnel Wai Kitlai (#2953) was performing Shielded Metal Arc Welding (SMAW). QC Inspector Pat Swain was present and monitoring the work.
- 2) At weld joints E6/E7 – D-1 and 2, outside the OBG section: ABF welding personnel Rory Hogan (#3186) and Jeremy Dolan (#5042) were using a plasma torch to remove the backing bar.
- 3) At weld joints W6/W7 – D1 and D2, outside the OBG section: ABF welding personnel Bryce Howell (#5591) was setting up equipment to remove the backing bar.
- 4) At E1, inside the OBG section: ABF welding personnel Danny Ieraci (#3232), Xiao Jian Wan (#9677) and Hua Qiang Hwang (#2930) were setting up preheating equipment in preparation to begin welding on the longitudinal stiffeners located at the Access Hole penetrations.
- 5) The QA Inspector performed a walk through OBG sections E1, E2, E3 and E4 performing a verification

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regarding the dates welds A thru F were performed.

At Access Plate 2E-PP-17.5-E2-SW, outside the OBG section this QA Inspector observed ABF welding personnel Wai Kitlai (#2953) performing SMAW. This QA Inspector observed as QC Inspector Pat Swain verified the following welding parameters: 185 amperes using a 4 mm diameter E7018H4R electrode. The production welding observed appeared to comply with ABF-WPS-D15-1070 Rev-1.

At weld joints E6/E7 – D-1 and 2, outside the OBG section this QA Inspector observed ABF welding personnel Rory Hogan (#3186) and Jeremy Dolan (#5042) were using a plasma torch to remove the backing bar.

At weld joints W6/W7 – D1 and D2, outside the OBG section this QA Inspector observed ABF welding personnel Bryce Howell (#5591) was setting up equipment in preparation to remove the backing bar.

At E1, inside the OBG section this QA Inspector observed ABF welding personnel Danny Ieraci (#3232), Xiao Jian Wan (#9677) and Hua Qiang Hwang (#2930) were setting up preheating equipment in preparation to begin welding on the following longitudinal stiffeners: 1E-PP-10.5-E2-S and 2E-PP-13.5-E2-SW. Note these stiffeners are part of the Access Hole penetration welds. This QA Inspector spoke with ABF welding personnel Danny Ieraci (#3232) and was informed the preheating pads were 4-foot in length and that the power supply units had not been set up prior to arrival on site and that additional time would be required to set them up. This QA Inspector observed that at approximately 1000 hours this date the preheating power supply units had been turned on but not in use, welding was not observed during this QA Inspector's shift. A turnover was provided to QA Inspector Jojo Lizardo this date regarding the status of the work at this and other locations.

This QA Inspector performed a walk through OBG sections E1, E2, E3 and E4 performing a verification regarding the dates welds A thru F were performed.

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:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
