

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-017664**Date Inspected:** 25-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:** Steve McConnell**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) At weld joints 6E/7E – B, outside the OBG section: ABF welding personnel Fred Kaddu (#2188) was performing weld repairs using the Shielded Metal Arc Welding (SMAW) process. QC Inspector Steve McConnell was present and monitoring the work.
- 2) At weld joints 7E/8E-F, inside the OBG section: ABF welding personnel Jin Pei Wang (#7299) was back gouging the weld using a grinder.
- 3) On the top deck of various East OBG sections: ABF welding personnel Darcel Jackson (#9967) was grinding to size/shape the round deck penetration plates in preparation to begin fitting.
- 4) At weld joint 6W/7W-F, inside the OBG section: ABF welding personnel Xiao Jian Wan (#9677) was performing SMAW at the top transition area between the backing bar on the “A” weld and the “F” weld. QC Inspector Steve McConnell was present and monitoring the work.
- 5) At weld joint 7W/8W-E, outside the OBG section: ABF welding personnel Rick Clayborn (#2773) was fitting

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up the backing bar for this weld joint.

At weld joints 6E/7E – B, outside the OBG section this QA Inspector observed ABF welding personnel Fred Kaddu (#2188) performing weld repairs using the Shielded Metal Arc Welding (SMAW) process. This QA Inspector observed QC Inspector Steve McConnell was present and monitoring the work. This QA Inspector performed a verification of the welding parameters and observed the following: 120 amperes using a 3.2 mm diameter E7018H4R electrode. The welding observed appeared to comply with ABF-WPS-D15-1001 Repair.

At weld joints 7E/8E-F, inside the OBG section this QA Inspector observed ABF welding personnel Jin Pei Wang (#7299) using a power grinder to back gouge the weld. Please note copper had been used as the backing material. The backing observed appeared to be removal of weld slightly below the face of the base material. This QA Inspector did not observe welding at this location this date.

On the top deck of various East OBG sections this QA Inspector observed ABF welding personnel Darcel Jackson (#9967) marking the round deck penetration plates as needed and perform grinding as needed for the plates to fit into deck. Welding was not observed at any of these location this date.

At weld joint 6W/7W-F, inside the OBG section this QA Inspector observed ABF welding personnel Xiao Jian Wan (#9677) performing SMAW at the top transition area between the backing bar on the “A” weld and the “F” weld. This QA Inspector observed QC Inspector Steve McConnell was present and monitoring the work. This QA Inspector verified the welding parameters as follows: 125 amperes using a 3.2 mm diameter E7018H4R electrode. The welding observed appeared to comply with ABF-WPS-D1.5-fillet.

At weld joint 7W/8W-E, outside the OBG section this QA Inspector ABF welding personnel Rick Clayborn (#2773) was in the process of fitting up the backing bar for this weld joint.

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
