

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-017906**Date Inspected:** 05-Nov-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:** Orthotropic Box Girders**Summary of Items Observed:**

At the start of the shift the Quality Assurance Inspector (QAI) traveled to the project site and observed the following work performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below:

- A). Field Splice E5/E6
- B). Field Splice E7/E8
- C). Field Splice E8/E9

A). Field Splice E5/E6

The welder, Xiao Jian Wan ID-9677, performed the CJP groove welding on the longitudinal stiffener field splice identified as WN: 5E-6E-A-LS4. The welder utilized the SMAW process as per the Welding Procedure Specification (WPS) identified as ABF-WPS-D15-1012-3, Rev.0 and was also utilized by the QC inspector John Pagliero as a reference. The amperage was recorded as 126 amps and the minimum preheat of 100 degrees Celsius and the maximum interpass temperature of 230 degrees Celsius was verified.

The QAI also observed the welder, Hua Qiang Hwang ID-2930, performed the CJP groove welding on the longitudinal stiffener field splice identified as WN: 5E-6E-A-LS3. The welder utilized the SMAW process as per the Welding Procedure Specification (WPS) identified as ABF-WPS-D15-1012-3, Rev.0 and was also utilized by the QC inspector John Pagliero as a reference. The amperage was recorded as 129 amps and the minimum preheat of 100 degrees Celsius and the maximum interpass temperature of 230 degrees Celsius was verified.

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The welding of the longitudinal stiffeners was performed in the vertical (3G) position with the work placed in an approximate vertical plane and the groove approximately vertical. The welders utilized a slag hammer, pneumatic air gun with an attached chisel and a wire wheel attached to a 4" high cycle grinder to remove slag after deposit of each fill pass. The electrodes were stored in electrically heated, thermostatically controlled oven after removal from sealed containers. The exposure limits of the electrodes identified as E9018-H4R and the minimum storage oven temperature of 250 degrees Celsius appeared to be in compliance with the contract documents. At the time of the observation no issues were noted by the QAI.

B). Field Splice E7/E8

The QAI observed the continued automatic Flux Cored Arc Welding (FCAW-G) of the weld joint identified as Weld Number (WN) E7-E8-E1. The Complete Joint Penetration (CJP) welding was performed by welding personnel Song Tao Huang, ID-3794 utilizing the WPS ABF-D15-3042B-1, Rev. 0. The joint designation appeared to comply with AWS single-v-groove butt joint identified as B-U2a-G. The WPS was also used by the QC inspector William Sherwood as a reference to monitor the welding and to verify the DC welding parameters which were noted and recorded by the QC as follows: 252 amps, 23.0 volts and a travel speed measured as 280 mm per minute. The welding was performed in vertical position (3G) at approximate incline of 22 degrees. The QC inspector also verified the minimum preheat temperature of 100 degrees Celsius and the maximum interpass temperature of 230 degrees Celsius. Later during the shift the QAI observed, at random intervals, the QC inspector monitoring the in process welding, the surface temperatures and verifying the welding parameters. The welding of the side plate field splice, face "A" was not completed during this scheduled shift.

C). Field Splice E8/E9

The QAI observed the QC inspector William Sherwood perform an assembly fit-up of the bottom plate field splice identified as WN: E8-E9-D1 and D2. At the conclusion of the fit-up inspection no fit-up or planar misalignment issues were noted. At this time the QAI, at the request of Mr. Sherwood, verified the fit-up and planar alignment dimensions and the QAI concurs with the QC inspector's assessment. The welding of the fit-up gear and the assembly fit-up were performed by Rick Clayborn ID-2773 utilizing the SMAW process during the welding as per the WPS ABF-WPS-D15-F1200A Rev. 1. The WPS was also used by the QC inspector Mr. Sherwood as a reference to verify the welding parameters and were noted as follows: 141 amps. The QAI also observed the QC inspector verify the surface temperatures which appeared to comply with the contract documents and were noted as follows: 20 degrees Celsius (preheat temperature) and the maximum interpass temperature of 230 degrees Celsius.

QA Observation and Verification Summary

The QA inspector observed the QC activities and the welding of the field splices utilizing the WPS as noted above, which appeared to be posted at the weld station. The welding parameters and surface temperatures were verified by the QC inspector and utilizing a Fluke 337 clamp meter for the electrical welding parameters and a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. The ESAB consumables utilized for the SMAW welding process appeared to comply with the AWS Specification and AWS Classification. The QC inspection, testing and welding performed on this shift appeared to be in general compliance with the contract documents. At random intervals, the QAI verified the QC inspection, testing, welding parameters and the surface

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temperatures utilizing various inspection equipment and gages which included a Fluke 337 Clamp Meter and Tempilstik Temperature indicators.

The digital photographs below illustrate the work observed during this scheduled shift.



Summary of Conversations:

There were general conversations with Quality Control Inspector Bonifacio Daquinag, Jr. at the start of the shift regarding the location of American Bridge/Fluor welding, inspection and N.D.E. testing personnel scheduled for this shift.

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:	Reyes, Danny	Quality Assurance Inspector
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Reviewed By:	Levell, Bill	QA Reviewer
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