

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-017911**Date Inspected:** 09-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:** SAS OBG**Summary of Items Observed:**

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above. The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified as 8E/9E-A1-A5, 3E-23.5-E5-NE, 3E-pp20-E4-1 & 3, and the following observations were made:

8E/9E-A1-A5

Upon the arrival of the QA Inspector in the am it was observed the above identified weld joint was fit up with the approved temporary attachments or fit up gear in place. The QA Inspector randomly observed the ends of the above identified weld joint had been previously welded to completion. The QA Inspector randomly observed the first 600mm of A1 and the last 600mm of A5 had been welded root/fill/cover, locking the top deck plate in place. The QA Inspector randomly observed the ABF welders identified as Fred Kaddu and George Lopez performing shielded metal arc welding (SMAW) of the gaps between the steel backing and the bottom of the bevel. The QA Inspector randomly observed and noted the QA Inspector randomly observed the Smith Emery (SE) Quality Control (QC) Inspector Tony Sherwood was on site monitoring the in process SMAW tack welding. The QA Inspector randomly observed and noted the SMAW parameters for both of the above identified ABF welders and they were; 138 Amps while utilizing 1/8" E7018 low hydrogen electrodes. The QA Inspector randomly observed the full length tack weld was approximately 90% at 0900. The QA Inspector randomly observed the ABF welder Fred Kaddu begin performing SMAW of the areas where the gaps exceeded 2mm. The QA Inspector noted the full length tack weld was nearly completed at the end of the QA Inspectors shift. The ABF welding Superintendent Dan Ieraci informed the QA Inspector the SAW root pass would be performed in the morning of the next day shift. The QA Inspector noted the SMAW seal weld or full length tack weld was completed on this date.

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3E-23.5-E5-NE

Upon the arrival of the QA Inspector it was randomly observed the ABF welder identified as Mick Chan was performing grinding tasks. The QA Inspector randomly observed the SMAW 4G back weld had been previously completed. The QA Inspector randomly observed and noted no welding was performed on this date. The QA Inspector noted the ABF welder spend the QA Inspectors shift performing grinding tasks of the in process back gouge.

3E-pp20-E4-1 & 3

The QA Inspector randomly observed the ABF welder identified as Eric Sharp performing grinding tasks on the above identified back gouged weld joints. The QA Inspector randomly observed the Smith Emery (SE) Quality Control (QC) Inspector John Pagliero perform magnetic particle testing several times in an attempt to clear or accept the back gouged weld joint. The QA Inspector randomly observed the back gouged weld joint an noted several MT indications were present and additional grinding would be required. After the grinding was completed, and the weld was re-tested the QA Inspector noted the MT indications had been removed and the back gouged weld joint appeared to be acceptable. The QA Inspector randomly observed the ABF welder begin performing the SMAW back weld for both of the above identified weld joints. The QA Inspector noted the base metal and the weld joint were preheated to approximately 100°F and back welding was commenced. The QA Inspector randomly observed the ABF welder to be utilizing 1/8" E7018 low hydrogen electrodes with 132 Amps. The QA Inspector noted the SMAW back welds were continued from the previous day shift completed on the QA Inspectors shift on this date. The QA Inspector randomly observed the ABF welder begin performing grinding tasks in an attempt to remove and grind the weld reinforcement flush with the base material.

Summary of Conversations:

No pertinent conversation noted.

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:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
