

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-018179**Date Inspected:** 16-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**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 Welding of Lifting Rod Access Penetration Inserts (SMAW)
- 2). OBG East Line Access Penetration Insert Welds (SMAW R-1 Repairs)
- 3). OBG Field Splice 7W/8W Weld ID: A1, Face A – (SMAW repair)

- 1). OBG Field Welding of Lifting Rod Access Penetration Insert (SMAW R-1 Repairs)

Interior: OBG 4E-PP27-E4 – weld 2

The QAI periodically observed AB/F approved welder Earl Espinoza (ID 5824) performing back welding per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position of E4-weld 2. See photo below. QC Inspector John Pagliero was periodically 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-D1.5-1110 B rev-1. Welding was completed at this location and the QAI observed that the work appeared to be in general compliance with contract documents.

Interior: OBG 2E-PP17-E4 - weld 2

The QAI periodically observed AB/F approved welder Salvador Sandoval (ID 2202) performing R-1 repair welding per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position. While welding at this location the QAI observed that Mr. Sandoval blew through to the exterior side. Welding was completed from the interior and exterior repairs will be required. QC Inspector John Pagliero was periodically present to monitor

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the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1001 Repair. The QAI also observed that OBG 2E-PP17-E4 - weld 1 contained (1) repair excavation and weld 3 contained (2) repair excavation yet to be welded on this date.

Interior: OBG 3E-PP22-E3-weld 2

The QAI periodically observed AB/F approved welder Darcell Jackson (ID 9967) performing back welding per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position of E3-weld 2. QC Inspector John Pagliero was periodically 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-D1.5-1110B rev. 1. Welding was completed from the interior at E3-weld 2 and the QAI observed that the work at this location appeared to be in general compliance with contract documents.

2). OBG East Line Access Penetration Insert Weld (SMAW R-1 Repairs)

The QAI periodically observed AB/F approved welder Mick Chan (ID 9265) performing R-1 repair welding per the Shielded Metal Arc Welding (SMAW) process in the 1G (flat) position of (3) repair locations in OBG East Line Access Penetration Insert Weld at 3E PP23.5 E5 NE from the exterior. See photo below. The QAI periodically observed QC inspector Steve McConnell was periodically 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-D1.5-1000 Repair. The QAI observed that Mr. Chan completed the repair welding at this location and the work appeared to be in general compliance with contract documents.

3). OBG Field Splice 7W/8W Weld ID: A1, Face A – (SMAW repair)

The QAI periodically observed AB/F approved welder Fred Kaddu (ID 2188) performing repair welding per the Shielded Metal Arc Welding (SMAW) process in the 1G (flat) position. The QAI observed that Mr. Kaddu performed repair welding of a base metal gouge observed by the QAI on 11-15-10 located at Y = 2835mm. The QAI periodically observed QC inspector Steve McConnell was periodically 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-D1.5-1000 Repair. The QAI observed Mr. Kaddu also removed by grinding a weld remnant (weld scab) at Y = approximately 2350mm. The work at this location was completed and appeared to be in general compliance with contract documents.



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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 Materials for your project.

Inspected By:	Madison,Bert	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
