

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-018402**Date Inspected:** 23-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**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:** S.A.S. components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) Field Welding - General Document Control
- 2) OBG Deck Hole Welding
- 3) F.W. Spencer - Utility Piping

1) The QAI met with the QAI Rick Bettencourt and was given an overview of the current status of welding and repairs being performed by the contractor. The QAI reviewed the tracking logs that are being utilized in the field. The QAI reviewed the current procedures for documenting the daily welding being performed by the contractor. The QAI made notes regarding the current status of field splices, lifting lug holes, field splice fit-ups and deck access holes that are being welded at this time.

2) The QAI observed ABF personnel grinding and welding deck hole patches on the East bound line of the S.A.S. OBG structure. The QAI noted that the patches are being placed in the deck access / ventilation holes and lifting lug holes. The QAI observed that the lifting lug patch welds are being ground smooth on the inside and outside of the structure. The QAI observed repair welding in progress at panel point 17, line E3. The QAI noted that the shielded metal arc welding (SMAW) is being performed by Salvador Sandoval, ID 2202. The QAI observed the repair welding being monitored by the Quality Control (QC) Inspector Pat Swain. The QAI was informed that welding procedure specification (WPS) ABF-WPS-D15-1001-Repair is being used for this welding. The QAI

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randomly measured the welding parameters and noted that they appeared to be conforming to the WPS requirements.

3) The QAI observed F.W. Spencer personnel preparing to weld pipe supports onto W2 column embeds. The QAI noted that the work is being accessed from an aerial work platform. The QAI made observations of completed pipe support welds. The QAI was unable to determine if the welding has been completed or accepted by QC. The QAI noted that this work is being performed to AWS D1.1 requirements. See the attached photos.



Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI had conversations with the QAI Rick Bettencourt and the QC Inspector Pat Swain, as noted above. The QAI relayed this information to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations or observations.

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: Croff, Scott

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer