

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-018429**Date Inspected:** 30-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:** Listed 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:** 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) OBG Deck Hole Welding

The QAI made observations of welding of the OBG deck hole patches on the East and West lines 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 Salvador Sandoval, ID 2202, and Mike Jininez, ID 4671, using shielded metal arc welding (SMAW) to make repairs to lifting lug patch welds. The QAI noted that repairs are being made at Panel Point (PP) 27-E4 and PP27-E3. The QAI also noted that the repairs include in-process work and repairs of deficient welds. The QAI noted that the repair welding is 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 randomly measured the welding parameters and noted that they appeared to be conforming to the WPS requirements. The QAI noted that as the repairs were completed, the welds were being ground smooth and flush with the deck surface. This work was in progress at the end of the shift. See the attached photo.

The QAI made observations of welding on deck access hole patch at PP37.5-E2SW. The QAI observed Wen Han Yu, ID 6317, using SMAW to make the fill passes. The QAI noted that the welding is being monitored by the QC Inspector Steve McConnell. The QAI was informed that ABF-WPS-D15-1010 rev.1 is being used for this welding.

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The QAI randomly measured the welding parameters and noted that they appeared to be conforming to the WPS requirements. This work was in progress at the end of the shift. See the attached photo.



Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed the observations of OBG splice welding to the QAI Danny Reyes. The QAI also generated a shift turn-over report with this information. The QAI relayed the status of work observed to the Lead QAI Bill Levell. The QAI was informed that Nina Choy will be the reporting Structural Materials Representative (SMR). Except as described above, there were no other notable observations or conversations during 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 Nina Choy (510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Croff,Scott	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
