

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-018513**Date Inspected:** 07-Dec-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 Splice 7E/8E Weld ID: E, Face B – (Plasma Cutting)
- 2). OBG East Line Access Penetration Insert Longitudinal Stiff. (LSW) Splice at 5E PP29.5 E2 S
- 3). OBG East Line Access Penetration Insert Longitudinal Stiff. (LSW) Splice at 6E PP46.5 E2 S
- 4). OBG East Line Access Penetration Insert Weld at 7E PP61.5 E2 SW (Exterior)
- 5). OBG Field Welding of East Line Lifting Rod Access Penetration Inserts (SMAW)
- 6). OBG Field Splice 6W/7W Weld ID: C1 & C2, Face A – (QAI Verification)

- 1). OBG Field Splice 7E/8E Weld ID: D, Face B – (Plasma Cutting)

The QAI periodically observed AB/F approved welder Rory Hogan (ID 3186) assisted by AB/F approved welder Jeremy Dolman (ID 5042) performing Plasma cutting and grinding to remove the backing bar and prepare a groove for back welding.

- 2). OBG East Line Access Penetration Insert Longitudinal Stiff. (LSW) Splice at 5E PP29.5 E2 S

The QAI periodically observed AB/F approved welder Xiao Jian Wan (ID 9677) performing welding of fill and cover passes per the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position of OBG Field Splice 5E PP29.5 E2 S A-LSW. See photo below. QC Inspector John Pagliero was present periodically 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-D1.5-1012-3. The welding was completed on the South face of A-LSW and the QAI periodically observed welder 9677 back grinding and welding root, fill and cover

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

passes on the North face. The welding was completed and the QAI observed that the work at this location appeared to be in general compliance with contract documents.

3). OBG East Line Access Penetration Insert Longitudinal Stiff. (LSW) Splice at 6E PP46.5 E2 S

The QAI periodically observed AB/F approved welder Hua Qiang Hwang (ID 2930) performing welding per the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position on the OBG East Line Access Penetration Insert LSW Splice at 6E PP46.5 E2 S. See photo below. QC Inspector John Pagliero was 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-D1.5-1012-3. The welding was completed on the North face of A-LSW and the QAI periodically observed welder 2930 back grinding and welding root, fill and cover passes on the South face. The welding was in process and the QAI observed that the work at this location appeared to be in general compliance with contract documents.

4). OBG East Line Access Penetration Insert Weld at 7E PP61.5 E2 SW (Exterior)

The QAI periodically observed AB/F approved welder Wai Kitlai (ID 2953) performing root and fill pass welding per the Shielded Metal Arc Welding (SMAW) process in the 1G (flat) position on the exterior of OBG East Line Access Penetration Insert Weld 8E PP61.5 E2 SW. QC Inspector Tony Sherwood was 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-D1.5-1010 rev 1. Fill pass welding was in process and welder 2953 moved to the interior to perform back grinding. The QAI observed the work at this location appeared to be in general compliance with contract documents.

5). OBG Field Welding of East Line Lifting Rod Access Penetration Inserts (SMAW)

Exterior: OBG 5E PP27 E4 welds 2 & 4 (R-2 repairs)

The QAI periodically observed AB/F approved welder Earl Espinoza (ID 5824) performing air carbon arc gouging and grinding of R-2 repair excavated areas at OBG 5E PP27 E4 welds 2, 3 & 4. The QAI subsequently periodically observed welding of fill and cover passes per the Shielded Metal Arc Welding (SMAW) process in the 1G (flat) position. QC Inspector Mike Johnson 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-D1.5-1001 Repair. Welding and flush grinding was completed and the QAI observed that the work at this location appeared to be in general compliance with contract documents. The QAI observed that there was the following number of excavations at the following weld locations: E4 Weld #2 – 2 excavations, and E4 Weld #4 – 1 excavation on the exterior (and two indications to be excavated on the interior.)

6). OBG Field Splice 6W/7W Weld ID: C1 & C2, Face A – (QAI Verification)

The QAI performed verification Ultrasonic Testing (UT) of 10% of the lengths of OBG Field Splice 6W/7W Weld ID: C1 and C2. The OBG Field Splice verified by the QAI appeared to be in general compliance with contract documents. See Ultrasonic Testing Report Form TL-6027 generated by the QAI on this date.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Conversations on this date with Quality Control Inspectors were general in nature and pertained to locations of welding and QC activities and locations of welds released to the QAI for verification testing.

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