

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-018566**Date Inspected:** 06-Dec-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.		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A
Component:	S.A.S. Components		

Bridge No: 34-0006**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 these patches are being placed and welded into the deck access / ventilation holes and lifting lug holes. The QAI observed Earl Espinoza, ID 5824, welding lifting lug patch at PP31 E3 #4. The QAI noted that the Quality Control (QC) Inspector Fred Von Hoff is monitoring the fitting and welding. The QAI noted that ABF-WPS-D15-1050A 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. This work was in progress at the end of the shift.

The QAI observed ABF personnel back grinding lifting lug patch welds at PP8.5-W4 #2 and #4. The QAI noted that these areas will be back welded after the grinding is completed. The QAI noted that the QC Inspector Mike Johnson is monitoring this work. The QAI did not observe any welding at this location. The QAI also observed the QC Inspector Mike Johnson performing magnetic particle testing (MT) of the back-gouged root on deck access hole patch at PP10.5-W5-S. The QAI was informed that the contract does not require testing of the back-gouge, however, the contractor has directed the QC to conduct the MT. The QAI made observations of the ground areas and noted that they appeared to be visually conforming to the contract requirements.

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Summary of Conversations:

The QAI had general conversations with ABF, QC and Caltrans personnel during this shift. The QAI relayed the observations of OBG splice welding to the QAI Danny Reyes. The QAI relayed the status of work observed to the Lead QAI Bill Levell. Except as described above, there were no other notable 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
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Reviewed By:	Levell,Bill	QA Reviewer
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