

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-018568**Date Inspected:** 08-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:	Jesse Cayabyab		
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

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 Field Splice QA Verification Testing
- 2) Document review at Pier 7

The QAI performed visual testing (VT) and ultrasonic testing (UT) of complete joint penetration (CJP) welds at OBG field splice 6W/7W. The QAI was informed by the Quality Control (QC) Inspector Jesse Cayabyab that weld segments B and F were acceptable and ready for QA Verification. The QAI conducted visual examination of the welds and noted that they appeared to be generally conforming to the contract requirements. The QAI noted that the weld cap is ground smooth. The QAI then conducted 10% verification UT of the weld segments. The QAI identified a rejectable indication in 6W/7W-B. The QAI informed the QC Inspector of this finding and the QC Inspector was shown the readings observed. The QC Inspector re-examined the location using his equipment and agreed that the weld was rejectable. The QAI was informed that there would be repairs performed at a later time. The QAI then conducted verification testing of the remaining weld. See the appropriate TL-6027 report for additional information.

The QAI reviewed contract related documents including the submitted and approved Welding Quality Control Plan (WQCP) and approved revisions to the WQCP. The QAI completed the formal review of the contractor's submittal #1536 Rev. 33. See the appropriate TL-20 report for additional information. The QAI continued

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reviewing the 2 remaining submittals and 2 informal weld report packages. The QAI continued consolidating the information from welding report submittals to identify missing reports of inspections. The QAI continued generating a weld specific tracking list from the contractor's welding reports.

Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI had conversations with the QC Inspector Jesse Cayabyab regarding the UT of 6W/7W segments B and F. The QAI relayed the status of submittal and document reviews to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations.

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
