

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-018589**Date Inspected:** 13-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 8E/9E Weld ID: C1, Face A (FCAW-G)
- 2). OBG Field Splice 7E/8E Weld ID: B1, Face B – (SMAW)
- 3). OBG Field Splice 7E/8E Weld ID: D1, Face B – (FCAW-G)
- 4). West Line Lifting Rod Access Penetration Insert Welds (QA verification)
- 5). OBG Field Splice of Access Penetration Insert Longitudinal Stiffeners (QA verification)

- 1). OBG Field Splice 8E/9E Weld ID: C1, Face A (FCAW-G)

The QAI periodically observed AB/F approved welder Song Tao Huang (ID 3794) assisted by AB/F approved welder Jin Quan Huang (ID 9340) performing welding of OBG Field Splice 8E/9E Weld ID: C1 per the Flux Cored Arc Welding (FCAW-G) process in the 3G (vertical) position. See photo below. The QAI observed QC Inspector Fred Von Hoff 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-D1.5-3042B-1. The welding of fill and cover passes was completed at weld C1 (except for the 1st 1010mm at the top of C1), and the QAI observed that the work at this location appeared to be in general compliance with contract documents.

- 2). OBG Field Splice 7E/8E Weld ID: B1, Face B – (SMAW)

The QAI periodically observed AB/F approved welder Fred Kaddu (ID 2188) performing back welding per the

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Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position of the back ground groove in the B face (interior) of OBG Field Splice 7E/8E Weld ID: B1. See photo below. QC Inspector John Pagliero 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-D1.5-1040B rev. 1. The QAI observed that welding and grinding was completed and work at this location appeared to be in general compliance with contract documents.

3). OBG Field Splice 7E/8E Weld ID: D1, Face B – (FCAW-G)

The QAI periodically observed AB/F approved welder Rory Hogan (ID 3186) assisted by AB/F approved welder Jeremy Dolman (ID 5042) performing welding on the exterior of OBG Field Splice 7E/8E Weld ID: D1 per the Flux Cored Welding (FCAW-G) process in the 4G (overhead) position. The QAI observed QC Inspector Fred Von Hoff 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-D1.5-3110-4. The welding of fill and cover passes was completed at weld D1 and the QAI periodically observed that work at this location appeared to be in general compliance with contract documents.

4). West Line Lifting Rod Access Penetration Insert Welds (QA verification)

The QAI performed verification Ultrasonic Testing (UT) of 25% of the lengths of OBG Field Welds of Lifting Rod Access Penetration Insert Welds at the following locations:

3E PP22-E4-Welds 1 through 4 and 4E PP25-E4-Welds 2 through 4

The OBG Field Welds verified by the QAI at these locations appeared to be in general compliance with contract documents. See Ultrasonic Testing Report Form TL-6027 generated by the QAI on this date.

5). OBG Field Splice of Access Penetration Insert Longitudinal Stiffeners (QA verification)

The QAI performed verification Ultrasonic Testing (UT) of 100% of the lengths of OBG Field Splices of Access Penetration Insert Stiffeners; LS- East, LS-West and the Transverse Stiffeners at the following locations:

3E PP23.5 - E2 & E5 and 6E PP37.5 – E2.

The OBG Field Splices verified by the QAI at these locations appeared to be in general compliance with contract documents. See Ultrasonic Testing Report Form TL-6027 generated by the QAI on this date.



Summary of Conversations:

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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
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Reviewed By:	Levell,Bill	QA Reviewer
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