

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 #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018726**Date Inspected:** 17-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:****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:** PQR**Summary of Items Observed:**

This Quality Assurance (QA) inspector, Fred Edmondson was on site at the job site between the times noted above.

This QA Inspector was on site to randomly observe and witness the welding of the Procedure Qualification Record (PQR No. ABF-PQR-038-3) test plate and to monitor the Quality Control (QC) functions.

This QA inspector met with QC inspector Mike Johnson and was informed that the PQR plate was in the process of being fit-up. The fit-up of the test plate was completed and this QA inspector observed QC inspector Johnson visually perform visual inspection of the fit-up. The PQR joint configuration (B-U2a) appeared to be in conformance the AWS D1.1, Fig.5.1.

This QA inspector observed welder Clayton Johnson welding the plate while QC inspector Johnson observed the average Amps, Volts, Travel Speed and Heat Input for each pass.

Ten (10) weld passes had been completed when this QA Inspector met with QA inspector Joe Lizardo and conducted a turnover with QA inspector Lizardo. The test weld was not completed at that time and required additional welding.

Summary of Conversations:

This QA inspector requested and received copies of CMTR's for the base metal, filler metal, RFI No. ABF-RFI-002282R00 and a working copy of the PQR which indicated that Postweld Heat Treatment (PWHT) of the completed test plate weld would be conducted. This QA inspector requested a copy of the PWHT (stress relieving) written procedure and was told by QC inspector Johnson that the PWHT (stress relieving) would be

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accomplished by working off of verbal instructions. This QA inspector discussed the requirements in Section 4.4 - Stress Relief Heat Treatment and Table 5.3 - Essential Variable No. 24 of AWS D1.5-02 with QC inspector Johnson. At the time of turnover a stress relief heat treatment written procedure had not been received.

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- 385-5901, who represents the Office of Structural Materials for your project.

Inspected By:	Edmondson,Fred	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
