

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-018910**Date Inspected:** 28-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:** 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 West Line Deck Access Hole Insert at 3W PP19.5 W2 NW (SMAW back welding)
- 2). OBG West Line Deck Access Hole Insert at 3W PP23.5 W2 NE (SMAW back welding)
- 3). OBG West Line Deck Access Hole Insert at 8W PP61.5 W5 (SMAW back welding)
- 4). OBG Lifting Lug Removal – (Air Carbon Arc gouging & grinding)

- 1). OBG West Line Deck Access Hole Insert at 3W PP19.5 W2 NW (SMAW back welding)

The QAI periodically observed AB/F approved welder Mick Chan (ID 9265) performing back welding the per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position on the interior of the OBG West Line Deck Access Hole Insert 3W PP19.5 W2. 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. Welding was in process and the QAI observed the work at this location appeared to be in general compliance with contract documents.

- 2). OBG West Line Deck Access Hole Insert at 3W PP23.5 W2 NE (SMAW back welding)

The QAI periodically observed AB/F approved welder Jin Pei Wang (ID 7299) performing back welding the per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position on the interior of the OBG West Line Deck Access Hole Insert 3W PP23.5 W2. 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

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Specification (WPS) identified as ABF-WPS-D1.5-1010 rev 1. Welding was in process and the QAI observed the work at this location appeared to be in general compliance with contract documents.

3). OBG West Line Deck Access Hole Insert at 8W PP61.5 W5 (SMAW back welding)

The QAI periodically observed AB/F approved welder Jorge Lopez (ID 6149) performing back welding the per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position on the interior of the OBG West Line Deck Access Hole Insert 8W PP61.5 W5. See photo below. QC Inspector Gary Ehram 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-D1.5-1010 rev 1. Welding was in process and the QAI observed the work at this location appeared to be in general compliance with contract documents.

4). OBG Lifting Lug Removal – (Air Carbon Arc gouging & grinding)

The QAI periodically observed AB/F apprentice Ian Murphy performing Air Carbon Arc gouging to remove the lifting lug at 1W PP9.5 W3 Lifting Lug #3 and AB/F personnel performing grinding and sanding of removal areas at 1W PP8.5 W4 Lifting Lug #2 & W3 Lifting Lug #3. See photo below. The work at this location was per ABF-RFI-001151R01.



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: Mertz,Robert

QA Reviewer