

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-019159**Date Inspected:** 05-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1100**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Fred Von Hoff**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:** OBG Section**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and to monitor American Bridge/Fluor (ABF) welding operations.

The following observations were made:

- 1) At weld joint 9E/10E-D-1 and D2, inside the OBG section: ABF welding personnel Xiao Jian Wan (#9677) and Hua Qiang Hwang (#2930) were performing Flux Cored Arc Welding (FCAW) at each end where the Submerged Arc Welding (SAW) track system was not accessible. QC Inspector Fred Von Hoff was monitoring the work.
- 2) At weld joint 7E/8E-D1 and D2, inside the OBG section: QC Inspectors Jesus Cayabyab and John Pagliero were performing Ultrasonic Testing (UT).
- 3) At weld joint 7E/8E-A-5, inside the OBG section this QA Inspector observed a fillet weld had been placed joining the back bar and the base material and Incident Report was created and submitted to Bill Levell, Lead QA Inspector.

At weld joint 9E/10E-D-1 and D2, inside the OBG section this QA Inspector observed ABF welding personnel Xiao Jian Wan (#9677) was performing FCAW production welding at the D-1 end of the weld joint and ABF welding personnel Hua Qiang Hwang (#2930) was performing FCAW at the D-2 end of the weld joint. The welding observed was located where the SAW track system could not reach. This QA Inspector verified the

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following welding parameters; ABF welding personnel Xiao Jian Wan (#9677) at 255 amperes and 24.2 volts and ABF welding personnel Hua Qiang Hwang (#2930) at 240 amperes and 23.7 volts. This QA Inspector observed the approximate travel speed for both of the welding personnel was 150 mm per minute. The welding observed appeared to comply with ABF-WPS-D15-1040B Rev-1. This QA Inspector observed QC Inspector Fred Von Hoff was periodically monitoring the work.

At weld joint 7E/8E-D1 and D2, inside the OBG section this QA Inspector observed QC Inspectors Jesus Cayabyab and John Pagliero performing Ultrasonic Testing (UT). This QA Inspector confirmed with QC Inspectors Jesus Cayabyab this was initial scan of the weld. This QA Inspector observed the following; both inspectors were scanning with a 70° shearwave transducer, the actual scanning pattern of each inspector, the UT signals as scanning was being performed. The work observed appeared to comply with the contract requirements.

At weld joint 7E/8E-A-5, inside the OBG section this QA Inspector observed a fillet weld had been placed joining the backing bar of the weld joint and the base material. This QA Inspector observed the weld had been ground but that a clear fusion line to show separation between the two members (backing bar and base material) was not visible. This QA Inspector submitted an Incident Report to Bill Levell, Lead QA Inspector.

Summary of Conversations:

As noted above.

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:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
