

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-019161**Date Inspected:** 03-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:** Tony Sherwood**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 had previously completed the continuous tack welding of the backing bar and were in the process of setting up equipment to later performed Submerged Arc Welding (SAW).

2) At weld joint 7E/8E-B, inside the OBG section: ABF welding personnel Fred Kaddu (#2188) was performing repair welding using the Shielded Metal Arc Welding (SMAW) process. QC Inspector John Pagliero was monitoring the work.

3) At weld joint 9E/10E A-1 thru A-5, outside the OBG section: ABF welding personnel Xiao Jian Wan (#9677), Hua Qiang Hwang (#2930) and Wai Kitlai (#2953) were performing SMAW production welding. QC Inspector Tony Sherwood was monitoring the work.

At weld joint 9E/10E-D-1 and D2, inside the OBG section this QA Inspector observed ABF welding personnel had previously completed the internal continuous tack welding on each side of the backing bar. This QA Inspector observed various ABF personnel in the process of setting up ventilation, preheating and welding equipment in

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preparation to start SAW production welding later this date.

At weld joint 7E/8E-B, inside the OBG section this QA Inspector observed ABF welding personnel Fred Kaddu (#2188) performing repair welding using the SMAW process. This QA Inspector observed QC Inspector John Pagliero monitoring the work. This QA Inspector observed the repair excavation was located at Y-200 and that QC personnel had marked a length of 350 mm, width of 45 mm and was 18 mm deep of the excavation next to the work area. This QA Inspector observed the root and approximately half of the fill passes had been welded prior to this date. This QA Inspector the start of the work this date and observed the rest of the fill and cover passes welded. This QA Inspector observed as QC Inspector John Pagliero verified the following welding parameters; 128 amperes using a 3.2 mm diameter E7018H4R electrode. The welding observed appeared to comply with Welding Procedure Specification (WPS) ABF-WPS-D15-1002-Repair.

At weld joint 9E/10E A-1 thru A-5, outside the OBG section this QA Inspector observed ABF welding personnel Xiao Jian Wan (#9677), Hua Qiang Hwang (#2930) and Wai Kitlai (#2953) performing SMAW production welding. The welding consisted of placing a continuous tack weld on each internal side of the weld joint. QC Inspector Tony Sherwood was monitoring the work and informed this QA Inspector of the following welding parameters; Xiao Jian Wan (#9677) at 171 amperes, Hua Qiang Hwang (#2930) at 165 amperes and Wai Kitlai (#2953) at 163 amperes. This QA Inspector observed all three welding personnel were using 3.2 mm diameter E7018H4R electrodes. The welding observed appeared to comply with ABF-WPS-D15-F1200A Rev-2.

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
