

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-019168**Date Inspected:** 04-Jan-2011**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:** Job Site**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:**

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above. The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified as 9E/10E-A1-A5 and the following observations were made:

9E/10E-A1-A5

Upon the arrival of the QA Inspector in the am it was observed the ABF welder were setting up to continue performing the shielded metal arc welding (SMAW). The QA Inspector randomly observed the ABF welders identified as Wai Kitlai, Hua Qiang Hwang and Xiao Jian Wan continue performing the SMAW full length tack weld. IT was noted ABF welder Wai Kitlai was welding in weld segment A4, Hua Qiang Hwang was welding in weld segment A2 and Xiao Jian Wan was welding in weld segment A1. The QA Inspector noted the full length tack weld appeared to be approximately 60% upon arrival. The QA Inspector noted no runoff tabs would be utilized on this transverse weld splice, rather the ends of the weld joint are welded to completion prior to performing the SAW. It was noted by the QA Inspector, 600mm of the weld joint at both ends were welded out to completion with SMAW. The QA Inspector randomly observed the SE QC Inspector Tony Sherwood was on site monitoring the in process SMAW tack welding. The QA Inspector randomly observed and noted the SMAW parameters for all three of the above identified ABF welders and they were 160-170 Amps while utilizing 5/32" E7018 low hydrogen electrodes. The QA Inspector noted the SMAW parameters did appear to be in general compliance with ABF-WPS-D1.5_F1200A. The QA Inspector randomly observed the full length tack weld was completed at the end of the shift.

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Summary of Conversations:

The QA Inspector performed a job site walk through to update production welding status spreadsheet and tracking logs for the remainder of the shift. It was observed by the QA Inspector, it did not appear the Smith Emery QC department had been utilizing the NDT charts written on the steel next to the weld joint. In many cases it no charts had even been written on the steel. The QA Inspector asked the SE Lead QC Inspector Bonifacio Daquinag why the charts are not being utilized. The QA Inspector reiterated, it was agreed upon in the beginning of the fabrication boxes containing dates and initials would be utilized by SE QC and Caltrans QA for tracking and traceability. The QC Inspector informed the QA Inspector he would instruct the SE QC Inspector to create the charts and go back to update all completed areas of the lifting lug holes where the NDT had been completed.

In addition the Caltrans QA Inspector Bert Madison informed the QA Inspector, the SE QC Inspectors were turning over weld joints for QA verifications and no initials or dates were signed of f for the required NDT. Mr. Madison said the chart will be in place next to the access hole, QC will verbally inform QA the weld is acceptable but no information will be written in the chart. The QA Inspector spoke with Mr. Bonifacio again and informed him of the issue. The QA Inspector informed the QC Inspector the information needs to be completed in the charts prior to turning the weld joint over to Caltrans QA for verifications. The QC Inspector informed the QA Inspector he would correct the issue along with ensuring the QA Inspector the charts would be utilized.

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:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
