

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019173**Date Inspected:** 08-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:** As noted in Summary**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:** Orthotropic Box Girder**Summary of Items Observed:**

This Quality Assurance Inspector (QAI) was present at the Self Anchored Suspension (SAS) job site. The following items were observed.

Field Splice 1W/2W

1, Longitudinal Stiffener. Ultrasonic Testing of welds in process.

Segments 2W, 3W

2. Top Plate A. Ventilation hatch Ultrasonic Testing of welds in process.

1. The Quality Assurance Inspector (QAI) observed the NDT technician Jesse Cayabyab performed ultrasonic testing of the complete joint penetration (CJP) groove welds of field splice 1W/2W –longitudinal stiffeners identified as LS1, LS2, LS3, LS4, LS5 and LS6. The welds were scanned utilizing a GE USM-35 instrument. The testing was performed in accordance with the approved procedure SE-UT-D1.5-CT-100 Rev.4 and AWS D1.5-2002 in the longitudinal and transverse direction from face A and B. Rejectable indications were marked on the A face of the welds. Mr. Cayabyab reported that the rejectable indications were at the root face and AWS D1.5-2002 Table 6.3 General note "Flaws detected at "scanning level" in the root face area of CJP double groove weld joints shall be evaluated using an indicating rating 4 dB more sensitive than described in 6.19.6.5 when such welds are designated as "tension welds" on the drawing." was applied.

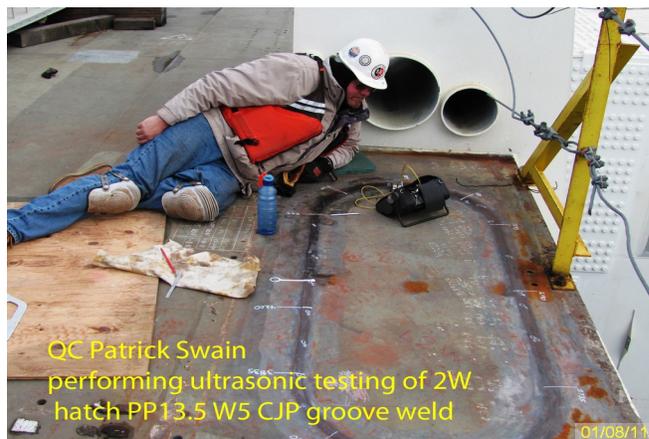
2. The Quality Assurance Inspector (QAI) observed the NDT technician Steve McConnell performed ultrasonic testing of the Segment 3W hatch PP19.5 W2NW complete joint penetration (CJP) groove weld. The weld was

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scanned utilizing a GE USM-35 instrument. The testing was performed in accordance with the approved procedure SE-UT-D1.5-CT-100 Rev.4 and AWS D1.5-2002 in the longitudinal and transverse direction from face A. Rejectable indications were marked on the A face of the weld. Mr. McConnell reported that there were multiple rejectable indications throughout the weld and testing would not be completed until Monday Jan 10.

The Quality Assurance Inspector (QAI) observed the NDT technician Patrick Swain performed ultrasonic testing of the Segment 2W hatch PP13.5 W5 complete joint penetration (CJP) groove weld. The weld was scanned utilizing a GE USM-35 instrument. The testing was performed in accordance with the approved procedure SE-UT-D1.5-CT-100 Rev.4 and AWS D1.5-2002 in the longitudinal and transverse direction from face A. Rejectable indications were marked on the A face of the weld. Mr. Swain reported that there were multiple rejectable indications in the bottom quarter of the weld and testing would not be completed until Monday Jan 10.



Summary of Conversations:

General conversations with QC personnel regarding NDT testing locations, results and schedule.

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.

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Inspected By:	Lanz, Joe	Quality Assurance Inspector
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Reviewed By:	Levell, Bill	QA Reviewer
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