

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-019280**Date Inspected:** 11-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 LS-1 thru 6, inside the OBG section: ABF welding personnel Hua Qiang Hwang (#2930) and Xiao Jian Wan (#9677) were observed performing production welding on Longitudinal Stiffeners with QC Inspector Fred Von Hoff monitoring the work.

2) At weld joint 3WPP19.5W5, inside the OBG section: QC Inspector Tony Sherwood was performing Magnetic Particle Testing (MT) of production welding.

At weld joint 9E/10E LS-3, inside the OBG section this QA Inspector observed ABF welding personnel Hua Qiang Hwang (#2930) performing production welding using the Shielded Metal Arc Welding (SMAW) process. QC Inspector Fred Von Hoff was present when this QA Inspector arrived at this work location. This QA Inspector randomly observed as QC Inspector Fred Von Hoff verified the preheat temperature and electrode size and type prior to production welding. This QA Inspector observed as QC Inspector Fred Von Hoff verified the following welding parameters; 130 amperes using a 3.2 mm diameter E9018H4R electrode. This QA Inspector observed the preheat was provided by electronic blankets controlled with multiple thermocouples. Production welding proceeded with this QA Inspector periodically monitoring and/or verify the work observed. The work observed

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this date appeared to comply with ABF-WPS-D15-1012-3 and the contract requirements.

At weld joint 9E/10E LS-4, inside the OBG section this QA Inspector observed ABF welding personnel Xiao Jian Wan (#9677) performing production welding using the SMAW process. QC Inspector Fred Von Hoff was present when this QA Inspector arrived at this work location. This QA Inspector randomly observed as QC Inspector Fred Von Hoff verified the preheat temperature and electrode size and type prior to production welding. This QA Inspector observed as QC Inspector Fred Von Hoff verified the following welding parameters; 128 amperes using a 3.2 mm diameter E9018H4R electrode. This QA Inspector observed the welding was almost complete and was soon informed by ABF welding personnel Xiao Jian Wan (#9677) that he had finished welding. This QA Inspector observed as QC Inspector Fred Von Hoff performed a preliminary visual inspection for verification and then informed this QA Inspector the weld post heat would be started at this time. The work observed this date appeared to comply with ABF-WPS-D15-1012-3 and the contract requirements.

At weld joint 3WPP19.5W5, inside the OBG section this QA Inspector observed QC Inspector Tony Sherwood was performing Magnetic Particle Testing (MT) on the bottom (inside) weld of the access plate and on both sides of the transverse stiffener weld. This QA Inspector randomly observed as QC Inspector Tony Sherwood performed the MT inspection observing the following: the yoke leg spacing appeared to provide adequate inspection coverage, powder application appeared to be adequate and the magnetic field was induced at opposing angles. In general the technique and application of the MT inspection observed appeared to comply with the contract requirements. QC Inspector Tony Sherwood informed this QA Inspector he had completed and accepted the visual and MT inspection of the welds noted above. This QA Inspector performed a visual verification and the welding observed appeared to comply with the contract requirements.

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
