

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-019336**Date Inspected:** 12-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 2W-pp15-W3-1&3, 2W-pp15-W4-1&3, 1W-pp-10.5-W2-N and the following observations were made:

2W-pp15-W3-1&3

The QA Inspector randomly observed the ABF welder Darcel Jackson performing carbon arc gouging and back grinding of the above identified weld joints. The QA inspector randomly observed the ABF welder grind the back gouged weld joints to bright metal. The QA Inspector randomly observed the back gouged weld joints and noted they appeared to be in general compliance with the contract requirements. The QA Inspector randomly observed the SE QC Inspector Mike Johnson perform magnetic particle testing of the back gouged weld joint and noted no relevant indications were present at the time of the testing. The QA Inspector randomly observed the ABF welder continue welding the in process lift lug hole restoration. The QA Inspector noted the weld joint was approximately 80% complete at the time of the SMAW 4G back weld. The QA Inspector randomly observed the ABF welder continue the SMAW fill pass. The QA Inspector randomly observed the SMAW parameters were 1/8" E7018 low hydrogen electrodes with 128 Amps. The QA Inspector noted the parameters appeared to be in general compliance with ABF-WPS-1070A R1. The QA Inspector randomly observed the ABF welder did complete the above identified lifting lug hole on this date. The QA Inspector noted the weld reinforcement was not ground flush on the QA Inspectors shift.

2W-pp15-W4-1&3

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The QA Inspector randomly observed the ABF welder Mike Jimenez performing carbon arc gouging and back grinding of the above identified weld joints. The QA inspector randomly observed the ABF welder grind the back gouged weld joints to bright metal. The QA Inspector randomly observed the back gouged weld joints and noted they appeared to be in general compliance with the contract requirements. The QA Inspector randomly observed the SE QC Inspector Mike Johnson perform magnetic particle testing of the back gouged weld joint and noted no relevant indications were present at the time of the testing. The QA Inspector randomly observed the ABF welder continue welding the in process lift lug hole restoration. The QA Inspector noted the weld joint was approximately 80% complete at the time of the SMAW 4G back weld. The QA Inspector randomly observed the ABF welder continue the SMAW fill pass. The QA Inspector randomly observed the SMAW parameters were 1/8" E7018 low hydrogen electrodes with 122 Amps. The QA Inspector noted the parameters appeared to be in general compliance with ABF-WPS-1070A R1. The QA Inspector randomly observed the ABF welder did complete the above identified lifting lug hole on this date. The QA Inspector noted the weld reinforcement was not ground flush on the QA Inspectors shift.

1W-pp-10.5-W2-N

The QA Inspector randomly observed the ABF welder identified as Jin Pei Wang performing grinding tasks in an attempt to excavate and remove a total of what appears to be 7 UT rejects. The QA Inspector noted no dimensional measurements were taken of the excavations during the QA Inspectors shift due to access to the area. The QA Inspector randomly observed and noted the ABF welder spent the entire QA Inspectors shift performing the grinding tasks due to the size and length of the repairs. The QA Inspector noted the excavated areas will be measured after the ABF welder completes the grinding.

The QA Inspector spent the remainder of the shift updating current ABF production welding on Caltrans QA spreadsheets as well as tracking QA and QC NDT status of transverse filed splices, lifting lugs restorations, access holes and longitudinal stiffener butt splices.

Summary of Conversations:

No pertinent conversation noted.

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
