

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-019456**Date Inspected:** 21-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 2400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1200**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name: Mike Johnson
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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;

Quality assurance inspector (QAI) arrived on site at 2400 hours and noted that stress relief of cable jacking-saddle field fillet weld was in progress. Four heating units were being utilized. QAI noted that stress relief was being performed by Mr. John Callahan, Mr. Jim Bowers and Mr. Levi Gatsos of ABF joint venture and witnessed by QC Mr. Mike Johnson.

Mr. Bowers reported that the soak time was completed at 2223 hours and the four heating units were set to cool at a rate of 450° F. At 2400 hours the temperature registered for each heating unit was as follows. # 1 - 673° F, # 2 - 678° F, # 3 - 642° F and 616° F. The cable jacking-saddle field fillet weld was allowed to cool at the current rate until all four heating units registered 600° F or less, which occurred at 0050 hours and the units were shut off and cooling in still air continued.

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 Sang Le, (916) 764-5650, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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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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