

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-019462**Date Inspected:** 19-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bonifacio Daquinag Jr.**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:** S.A.S. components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI reviewed contract related documents including the submitted and approved Welding Quality Control Plan (WQCP) and approved revisions to the WQCP. The QAI continued consolidating the information from welding report submittals to identify missing reports of inspections. The QAI continued generating a weld specific tracking list from the contractor's welding reports.

The QAI was tasked with verifying the contractor's measurements of planar misalignment (high/low) on OBG field splice 9E/10E plate E, weld segments E1 and E2. The QAI was informed that the weld joint has been fit up and there are locations where the planar misalignment does not conform to the contract requirements. The QAI was also informed that there may have been root welding performed at these locations as well. The QAI measured approximately 650mm of planar misalignment and was obstructed from measuring / observing the weld joint of approximately 1 meter from the corner (E1 to F) due to construction scaffolding. The QAI was provided with the additional measurements by the QAI Rick Bettencourt. See the list below for measured planar misalignment.

E1: Y=0mm to 60mm 10mm offset,

E1: Y=60mm to 90mm 6mm offset

E1: Y=1720mm to 2040mm 2mm – 4mm offset with 25mm of 4.5mm maximum offset

E2: Y=4150mm to 4260mm 2mm – 4mm offset

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E2: Y=4680mm to 4980mm 2mm – 4mm offset

Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed the status of document reviews and measurements of misalignment to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations.

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:	Croff,Scott	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
