

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-019469**Date Inspected:** 19-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:** 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:** 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 8E/9E –A5, outside the OBG section: ABF welding personnel Wai Kitlai (#2953) was observed performing repair welding using the Shielded Metal Arc Welding (SMAW) process. QC Inspector Bonifacio Daquinag Jr. was monitoring the work.
- 2) At weld joint 6EPP40E3-#4, outside the OBG section: ABF welding personnel Salvador Sandoval (#2202) was observed performing SMAW production welding. QC Inspector Steve McConnell was monitoring the work.
- 3) At weld joint 9E/10E –A1, outside the OBG section this QA Inspector observed QC Inspector Jesus Cayabyab performing Ultrasonic Testing (UT).
- 4) At weld joint 8EPP61.5E2-SW, inside the OBG section: ABF welding personnel Wen Han Yu (#6317) was performing repair welding using the SMAW process. QC Inspector Steve McConnell was monitoring the work.
- 5) At weld joint 8E/9E – E1 and E2, outside the OBG section: ABF welding personnel Rory Hogan (#3186) and Jeremy Dolman (#5042) were observed performing Flux Cored Arc Welding (FCAW) production welding. QC

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Inspector Tony Sherwood was monitoring the work.

6) At weld joint 8E/9E –B, outside the OBG section: ABF welding personnel Fred Kaddu (#2188) was observed grinding multiple repair welds flush.

7) At weld joint 8W/9W –B, inside the OBG section: ABF welding personnel Jorge Lopez (#6149) was observed performing SMAW production welding. QC Inspector Fred Von Hoff was monitoring the work.

At weld joint 8E/9E –A5, outside the OBG section this QA Inspector observed ABF welding personnel Wai Kitlai (#2953) performing repair welding using the SMAW process. This QA Inspector observed the location of the excavation was Y-4130 (200 mm in length and 20 mm deep). Prior to the start of welding this QA Inspector observed QC Inspector Bonifacio Daquinag Jr. verify the preheat was greater than 150°F using an electric temperature gauge and that the welding parameters were 127 amperes using a 3.2 mm diameter E7018H4R electrode. This QA Inspector was informed by QC Inspector Bonifacio Daquinag Jr. this was the first cycle of repair (R-1) at this location. The work observed at this location appeared to comply with Welding Procedure Specification (WPS) ABF-WPS-D15-1001-Repair and the contract requirements.

At weld joint 6EPP40E3-#4 (lifting access hole), outside the OBG section this QA Inspector observed ABF welding personnel Salvador Sandoval (#2202) performing SMAW production welding. This QA Inspector randomly observed QC Inspector Steve McConnell verify the following welding parameters; 135 amperes using a 3.2 diameter E7018H4R electrode. The welding observed at this location appeared to comply with ABF-WPS-D15-1050A-CU and the contract requirements.

At weld joint 9E/10E –A1, outside the OBG section this QA Inspector observed QC Inspector Jesus Cayabyab performing Ultrasonic Testing (UT). The work was in progress and multiple areas appeared to have been marked as defects.

At weld joint 8EPP61.5E2-SW, inside the OBG section this QA Inspector observed ABF welding personnel Wen Han Yu (#6317) performing repair welding using the SMAW process. This QA Inspector performed a random verification of the welding parameters observing the following; 130 amperes using a 3.2 diameter E7018H4R electrode. This QA Inspector observed QC Inspector Steve McConnell periodically monitoring the work. The work observed at this location appeared to comply with ABF-WPS-D15-1001-Repair and the contract requirements.

At weld joint 8E/9E – E1 and E2, outside the OBG section this QA Inspector observed ABF welding personnel Rory Hogan (#3186) and Jeremy Dolman (#5042) performing FCAW production welding using the track system. This QA Inspector randomly observed QC Inspector Tony Sherwood verify the following welding parameters; 240 amperes and 23 volts at a travel speed of 172 mm per minute. The work observed at this location appeared to comply with ABF-WPS-D15-3040A-3 and the contract requirements.

At weld joint 8E/9E –B, outside the OBG section this QA Inspector observed ABF welding personnel Fred Kaddu (#2188) grinding multiple repair welds flush.

At weld joint 8W/9W –B, inside the OBG section this QA Inspector observed ABF welding personnel Jorge

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Lopez (#6149) performing SMAW production welding at the bottom transition area of the weld. This QA Inspector performed a random verification of the welding parameters observing the following; 125 amperes using a 3.2 diameter E7018H4R electrode. This QA Inspector periodically observed QC Inspector Fred Von Hoff monitoring the work. The work observed by this QA Inspector appeared to comply with ABF-WPS-D15-1040B-Rev-1 and 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
