

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-019471**Date Inspected:** 21-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 Jacking Frame to Saddle fillet weld (West side), and the following observations were made:

Jacking Frame to Saddle fillet weld (West side)

Upon the arrival of the QA Inspector at 0700 it was observed the weld joint had been previously completed and the post weld heat treatment (PWHT) had been completed. Upon the arrival of the QA Inspector it was noted the base material surrounding the weld joint was approximately 250°F. The QA Inspector noted the weld joint and surrounding base material was still wrapped in the induction heating blankets and this QA Inspector could not determine the heat of the actual weld itself. The temperature was taken approximately 12" from the weld joint on the external surface of the steel. Later in the QA Inspectors shift it was observed the contractor removed the blankets from the weld and the QA Inspector was able to perform a random visual inspection of the completed weld. It was noted by the QA Inspector the weld joint appeared to be in general compliance with the contract requirements.

The Lead QA Inspector spent the remainder of the shift walking down the job site and updating METS QA tracking logs including ABF production status, QA NDT Status and UT rejection excavations.

Summary of Conversations:

The QA Inspector was informed by the ABF Project Engineer John Callaghan, no additional work would be performed on the East side fillet weld until Monday 1-24-11.

WELDING INSPECTION REPORT

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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.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
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Reviewed By:	Levell,Bill	QA Reviewer
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