

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-019614**Date Inspected:** 25-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Listed below.		
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:** 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 following observations were made:

- 1) OBG field splice welding at 9E/10E
- 2) OBG deck hole patch welding
- 3) Document review at Pier 7

1) The QAI observed ABF personnel welding plate B and plate A at OBG lifts 9E/10E field splice. The QAI noted that the Quality Control (QC) Inspector Fred Von Hoff is monitoring this welding. At weld B, the QAI observed ABF worker Xiao Jian Wan, ID 9677, making the vertical (3G) complete joint penetration (CJP) weld using shielded metal arc welding (SMAW) with E7018-H4R electrodes. The QAI was informed that welding procedure specification ABF-WPS-D15-1040A is being used at this location. At weld A4, the QAI observed ABF worker Wai Kitlai, ID 2853, making flat (1G) CJP weld repairs using SMAW with E7018-H4R electrodes. The QAI was informed that ABF-WPS-D15-1001-Repair is being used for this welding. The QAI randomly measured the preheat, interpass temperature and welding parameters and noted that they appeared to be conforming to the WPS requirements. See the attached photos.

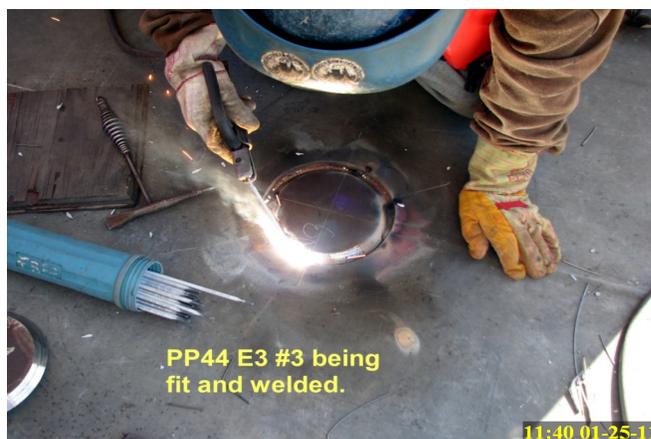
2) The QAI made observations of welding of the OBG deck hole patches on the East line of the S.A.S. OBG structure. The QAI noted that these patches are being placed and welded into the deck access / ventilation holes and lifting lug holes. The QAI observed Salvador Sandoval, ID 2202, fitting and welding lifting lug patch at PP44

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E3 #3. The QAI noted that the QC Inspector Steve McConnell is monitoring the fitting and welding. The QAI noted that ABF-WPS-D15-1050A is being used for this welding. The QAI randomly measured the welding parameters and noted that they appeared to be conforming to the WPS requirements. The QAI also observed Wen Han Yu, ID 6317, excavating and preparing to weld repairs in deck access hole at PP37.5 line E2. The QAI was informed that these repairs are partially excavated / welded from the top and then excavated and repaired again from the bottom. This work was in progress at the end of the shift. See the attached photos.

3) 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 reviewing the informal weekly welding report packages #43 and #44. The QAI continued consolidating the information from previous welding report submittals to identify missing reports of inspections. The QAI continued generating a weld specific tracking list from the contractor's welding reports.



Summary of Conversations:

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

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

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project.

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