

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-019818**Date Inspected:** 20-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:** Jobsite**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:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Splice 9W/10W Weld ID: A1, A2 & A3, Face A (SAW)
- 2). OBG Field Welding of Lifting Lug Hole Inserts (SMAW)
- 3). OBG Field Splice 8W/9W Weld ID: A4, Face A – (SMAW R-2 Repair)

- 1). OBG Field Splice 9W/10W Weld ID: A1, A2 & A3, Face A (SAW)

The QAI observed QC Inspector Tony Sherwood performing visual inspection of the OBG Field Splice 9W/10W Weld ID: A. Mr. Sherwood spoke with welding supervisor Dan Ieraci and Mr. Ieraci directed the welding operators to add weld passes at selected locations. The QAI periodically observed AB/F approved welder James Zhen (ID 6001) performing welding of cover passes on weld ID: A3 (see photo below) and AB/F approved welder Kenneth Chappelle (ID 3833) performing welding of cover passes on weld ID: A1 & A2 per the Submerged Arc Welding (SAW) process in the 1G (flat) position. See photo below. The QAI observed QC Inspector Tony Sherwood was present to monitor the progress and verify that the welding parameters were within the limits established by the approved Welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-4042B-1. The QAI observed that the work at this location was completed and appeared to be in general compliance with contract documents.

- 2). OBG Field Welding of Lifting Lug Hole Inserts (SMAW)

Interior: OBG 3W PP22 W3 welds 2 and 4

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The QAI periodically observed AB/F approved welder Darcel Jackson (ID 9967) performing back welding per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position and flush grinding of OBG 3W PP22 W3 welds 2 and 4. QC Inspector Gary Ehram was periodically present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1110B rev. 1. The QAI observed that the work at this location was completed and appeared to be in general compliance with contract documents.

Interior: OBG 3W PP20 W4 welds 1 and 3

The QAI periodically observed AB/F approved welder Mike Jimenez (ID 4671) performing back welding per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position of OBG 3W PP20 W4 welds 1 and 3. QC Inspector Gary Ehram was periodically present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1110B rev. 1. The QAI observed that the work at this location was in process and appeared to be in general compliance with contract documents.

Exterior: OBG 6E PP40 E3 weld 4

The QAI periodically observed AB/F approved welder Salvador Sandoval (ID 2202) performing welding per the Shielded Metal Arc Welding (SMAW) process in the 1G (flat) position. QC Inspector Steve McConnell was periodically present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1070. Welding and flush grinding was completed and the QAI observed that the work at this location appeared to be in general compliance with contract documents.

3). OBG Field Splice 8W/9W Weld ID: A4, Face A – (SMAW R-2 Repair)

The QAI randomly observed QC Inspector Pat Swain performing Magnetic Particle Testing (MT) of an excavated area prior to repair welding. The QAI randomly observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. The QAI periodically observed AB/F approved welder Wai Kitlai (ID 2953) performing repair welding per the Shielded Metal Arc Welding (SMAW) process in the 1G (flat) position of OBG Field Splice 8W/9W Weld ID: A4. QC Inspector Pat Swain was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1001 Repair. The QAI observed that welder (2953) completed fill and cover pass welding of the R-2 repair area on this date and work at this location appeared to be in general compliance with contract documents. The QAI observed that the excavated area in weld A4 had the following dimensions and the following Y location:

A4 (R-2) Repair --Y = 820mm, Length = 180mm, Depth = 14mm and Width = 22mm.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Conversations on this date with Quality Control Inspectors were general in nature and pertained to locations of welding and QC activities and locations of welds released to the QAI for verification testing.

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: Madison, Bert

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer