

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-019821**Date Inspected:** 26-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 6E-pp44-E3-31W-pp8.5-W3-3,41W-pp8.5-W4, 3,4, 1W-pp9.5-W3-1,2,3,4, 1W-pp11-W3-1,2,3,4, 1W-pp11-W4-1,2,3,4 and the following observations were made:

6E-pp44-E3-3

The QA Inspector randomly observed the ABF welder Salvador Sandoval continue performing the SMAW cover pass at the above identified location. The QA Inspector randomly observed the SE QC Inspector Steve McConnell monitoring the in process welding parameters. The QA Inspector noted the weld joint was approximately 90% complete at the time of the QA Inspectors visit. The QA Inspector randomly observed the ABF welder continue the SMAW cover pass and complete it. The QA Inspector randomly observed the SMAW parameters were 3/16" E7018 low hydrogen electrodes with 225 Amps. The QA Inspector noted the parameters appeared to be in general compliance with ABF-WPS-1070A R1. The QA Inspector randomly observed the ABF welder did complete the above identified lifting lug hole on this date. The QA Inspector noted the weld reinforcement was not ground flush on the QA Inspectors shift. The QA Inspector randomly observed the ABF welder begin the fit up of the next lifting lug hole identified as 6E-pp44-E3-1. The QA Inspector noted no welding was performed during the QA Inspectors shift.

For the remainder of the QA Inspectors shift, the Lead QA Inspector Rick Bettencourt performed QA ultrasonic testing (UT) verification of lifting lug holes that were previously turned over by the SE QC Inspector Bonifacio Daquinag. The QA Inspector performed approximately 10% UT verification of the following weld joints:

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1W-pp8.5-W3-3,4
1W-pp8.5-W4-3,4
1W-pp9.5-W3-1,2,3,4
1W-pp11-W3-1,2,3,4
1W-pp11-W4-1,2,3,4

The QA Inspector noted no rejectable indications were located at the time of the testing. For additional information reference TL-6027 for this date. The QA Inspector noted the weld identified above as, 1W-pp8.5-W3-3,4, 1W-pp8.5-W4-3,4, 1W-pp9.5-W3-1,2,3,4 were inadvertently rejected on a TL-6027. The QA Inspector generated an additional TL6027 for 1-26-11 accepting the welds in accordance with AWS D1.5-02 table 6.3.

Summary of Conversations:

no pertinent conversation noted on this date.

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.

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