

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-019822**Date Inspected:** 28-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/7E-D and the following observations were made:

6E/7E-D

7E

The QA Inspector was informed of a repair of the "T" stiffeners located on the OBG 7E. The QA Inspector noted the stiffeners were damaged during the fit up of the transverse field splice 6E/7E. The QA Inspector noted the contractor inadvertently bent and ripped the webs of the stiffeners on each end of the "D" plate. The QA Inspector noted the webs of the stiffeners appeared to tear or rip at the attachment fillet weld to the bottom flange plate of the OBG identified as plate "D". The QA Inspector noted the contractor submitted a plan to correct the issue described above in RFI-2224 R0 and R1. The QA Inspector randomly observed the contractor had combined and installed 2 shim plates to make up the width of the web to be repaired. The QA Inspector randomly observed the contractor did not grind the original attachment fillet weld smooth at the far north "T" stiffener to be repaired. The QA Inspector observed a jagged piece of the original web still in place after the installation of the new shim plates. The QA Inspector informed the ABF Superintendent Scott Smith of the issue (see summary of conversation). The QA Inspector noted the Smith Emery QC Inspector Mike Johnson argued that the broken piece of weld and web combination was acceptable and did not need to be repaired. The QA Inspector noted the ABF representative Scott Smith did agree the area needed additional grinding and elected to correct the issue by grinding. The QA Inspector observed the web shim plates were removed so the additional grinding could be performed. The QA Inspector noted the fillet weld and original web plate remnants were removed by grinding by the ABF welder Rick Clayborn.

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The QA Inspector noted no additional work was performed at the above identified location on this date.

The QA Inspector pointed out the jagged broken weld still in place at the north side of the weld joint. Mr. Smith acknowledged the issue and informed the QA Inspector he would correct the issue by grinding smooth and re-installing the web replacement shim plates. The QA Inspector informed Mr. Smith the repairs did not appear to comply with RFI 2224, Mr. Smith acknowledged and elected to repair the area described.

The Lead QC Inspector Bonifacio Daquinag and WQCM Jim Bowers informed the QA Inspector the SE QC Inspectors were planning on having a limited crew performing ultrasonic testing on Saturday 1-29-11. The QA Inspector noted at 1530 Mr. Bonifacio contacted the Lead QA Inspector Rick Bettencourt and informed him that no work or personnel will be on site on 1-29-11.

Summary of Conversations:

The QA Task Lead Bill Levell informed the QA Lead Inspector Rick Bettencourt the approval to proceed with welding at the above identified location was granted at 0720. The QA Inspector noted the approval was granted as per the Structures Material Representative Patrick Lowry.

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
Reviewed By:	Levell,Bill	QA Reviewer
