

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-019825**Date Inspected:** 25-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 2230**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 230**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
Component:	S.A.S. components		

Bridge No: 34-0006**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:

Jacking Saddle Post Weld Heat Treatment

The QAI arrived at the job site and relieved the QAI Joselito Lizardo, who has been monitoring the Jacking Saddle post weld heat treatment (PWHT) of the repaired fillet weld. The QAI Joselito Lizardo informed the QAI that the weld has been at its holding temperature of 1100°F since approximately 2005 hours. The QAI noted that its cool down will begin at 2305 hours at a maximum rate of 400°F per hour until 600°F is achieved.

The QAI noted that ABF engineer John Callaghan, ABF Quality Control (QC) Manager Jim Bowers and QC Inspector Mike Johnson are present and have been monitoring the PWHT. The QAI witnessed the cooling begin at 2305 hours and noted that a temperature of 600°F was not reached until 0140 hours with the steepest cooling rate of 350°F occurring between 2305 and 0005 hours. The QAI noted that the cooling was within the PWHT procedure rates. At 0140 hours, the QAI witnessed the induction heaters being turned off. The QAI noted that all heaters and insulating blankets were left on the jacking saddle and jacking frame. No visual condition of the weld could be determined at the time the heaters were turned off.

Summary of Conversations:

The QAI had general conversations with ABF personnel during this shift. The QAI relayed via email, the observations of the PWHT to the QAI Rick Bettencourt and the QAI Lead Bill Levell. Except as described above,

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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 project.

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