

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-020230**Date Inspected:** 28-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1100**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Fred Von Hoff**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:** OBG Section**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and to monitor American Bridge/Fluor (ABF) welding operations.

The following observations were made:

- 1) At weld joint 9E/10E –C1 and C2, inside the OBG section: ABF welding personnel Sang Tao Huang (#3794) was performing production welding using the Flux Cored Arc Welding (FCAW) process. QC Inspector Fred Von Hoff was monitoring the work.
- 2) At weld joint 9E/10E – LS-1 thru 6, inside the OBG section this QA Inspector randomly observed QC Inspector Pat Swain performing Ultrasonic Testing (UT).
- 3) At weld joint 6EPP44E3 #1 lifting hole, outside the OBG section: ABF welding personnel Salvador Sandoval (#2202) was performing production welding using the SMAW process. QC Inspector Steve McConnell was monitoring the work.
- 4) This QA Inspector was informed by various ABF welding personnel that from approximately 0945 hours until 1030 hours this date all 220 volt power was lost in the East OBG sections. This QA Inspector did not observe any welding during this time frame.

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At weld joint 9E/10E –C1 and C2, inside the OBG section this QA Inspector observed ABF welding personnel Sang Tao Huang (#3794) performing production welding using the FCAW process. This QA Inspector randomly observed QC Inspector Fred Von Hoff verify the following welding parameters; 265 amperes and 24.4 volts at a travel speed of 300 mm per minute. The work observed at this location appeared to comply with Welding Procedure Specification (WPS) ABF-WPS-D15-3040A-3 and the contract requirements.

At weld joint 9E/10E – LS-1 thru 6, inside the OBG section this QA Inspector randomly observed QC Inspector Pat Swain performing Ultrasonic Testing (UT). This QA Inspector observed the scanning technique, transducer frequency and shearwave angle (70°) appeared to comply with the contract requirements.

At weld joint 6EPP44E3 #1 lifting hole, outside the OBG section this QA Inspector observed ABF welding personnel Salvador Sandoval (#2202) performing production welding using the SMAW process. This QA Inspector performed a random verification of welding parameters observing the following; 119 amperes using a 3.2 mm diameter E7018H4R electrode. This QA Inspector observed QC Inspector Steve McConnell periodically monitoring the work. The work at this location appeared to comply with ABF-WPS-D15-1050A-CU and the contract requirements.

This QA Inspector was informed by various ABF welding personnel that from approximately 0945 hours until 1030 hours this date all 220 volt power was lost in the East OBG sections. This QA Inspector did not observe any welding during this time frame.

Summary of Conversations:

As noted above.

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:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
