

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-020577**Date Inspected:** 11-Feb-2011**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Arrival Time:****OSM Departure Time:****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 4W-pp31-W3-4, 4W-pp31-W4-2.

4W-pp31-W3-4

The QA Inspector randomly observed the ABF welder identified as Darcel Jackson and ABF helper begin fitting up the lifting lug deck insert identified above. The QA Inspector noted the direction of rolling was stamped with a low stress stamp in the center of the insert plate, so no grinding or welding would mask or deface the identifying marking. The QA Inspector randomly observed the bevel angle to be 45°. The QA Inspector noted the surface of the bevel appeared to be a machined surface with bright shiny metal. The QA Inspector noted the ABF welder was utilizing a prefabricated round copper backing plate with a channel machined in root opening where the welding will take place. The QA Inspector noted the fit up was completed on the QA Inspectors shift and appeared to be in general compliance with the contract documents. The QA Inspector randomly observed the ABF welder begin the SMAW root pass. The QA Inspector randomly observed the SMAW parameters were 5/32" E7018 low hydrogen electrodes with 176 Amps in the root pass and 3/16" E7018 fill cover with 276 Amps. The QA Inspector noted the parameters appeared to be in general compliance with ABF-WPS-1070A. The QA Inspector randomly observed the ABF welder did complete the above identified lifting lug hole on the QA Inspectors shift.

4W-pp31-W4-2

The QA Inspector randomly observed the ABF welder identified as Mike Jimenez continue welding the in process lift lug hole restoration. The QA Inspector noted the weld joint was approximately 40% complete at the time of the

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QA Inspectors arrival. The QA Inspector randomly observed the ABF welder continue the SMAW fill pass. The QA Inspector randomly observed the SMAW parameters were 3/16" E7018 low hydrogen electrodes with 265 Amps. The QA Inspector noted the parameters appeared to be in general compliance with ABF-WPS-1070A. The QA Inspector randomly observed the ABF welder did complete the above identified lifting lug hole on this date. The QA Inspector randomly observed the welder did complete the welding but the weld reinforcement was not ground flush on this date.

The QA Inspector reviewed contract special provisions section 8-3 and updated on site ABF production welding and NDT tracking spreadsheets.

Summary of Conversations:

no pertinent conversation noted.

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