

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-020905**Date Inspected:** 18-Feb-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, 9E/10E-E18E/9E-E1/E2, 8E/9E-C1/C2, 9E/10E-F1 the following items were observed:

9E/10E-E1

The QA Inspector randomly observed the ABF welder Song Tao Hunag had previously started the induction heating blankets on the inside of OBG to ensure the minimum required preheat of 150°F was achieved prior to welding. The QA Inspector randomly verified utilizing a 150°F temperature indicating marker and noted the minimum required preheat had been achieved. The QA Inspector observed the ABF welder to be utilizing the semi automated flux cored arc welding (FCAW) for the above identified weld joint. The QA Inspector randomly observed the Smith Emery (SE) QC Inspector identified as Steve Jensen set the FCAW machine to the parameters of the approved WPS identified as ABF-WPS-D1.5-3042-B-1 The QA Inspector randomly observed the FCAW parameters were 276 Amps, 23 Volts and a travel speed of 295mm/min. The QA Inspector noted the ABF welder continued welding the FCAW cover passes for the remainder of the shift. The QA Inspector noted the fit up in the areas being welded were in compliance with the contract requirements. The QA Inspector noted the welding continued through out the duration of 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 transverse field splices 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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8E/9E-E1/E2
8E/9E-C1/C2
9E/10E-F1

The QA Inspector noted no rejectable indications were located at the time of the testing. For additional information reference TL-6027 for this date.

Summary of Conversations:

At 1300 the Lead QA Inspector was informed by the Caltrans Structures Material Representative Nina Choy that the contractor may or may not perform welding of the grillage at pier 7 on Saturday 2-19-11. Ms. Choy informed the QA Inspector the department would like METS QA presence at the job site starting at 0800 if any welding is performed. In addition Ms. Choy informed the QA Lead Inspector the METS QA presence is approved for 4 hours of overtime on 2.19.11 and if welding is performed throughout the shift an additional 4 hours will be approved at that time. The QA Lead Inspector Informed Ms. Choy the QA Inspector Joselito Lizardo will be at the job site at 0800 to provide METS QA support.

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
