

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-020953**Date Inspected:** 23-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Mike Johnson		
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

Bridge No: 34-0006**Component:** S.A.S. components**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 QAI traveled to Anamet Inc, Hayward, CA, to witness testing of weld specimens for Procedure Qualification Records (PQR). The QAI noted that the observed weld tests appeared to be within conformance of the contract requirements and issued lot numbers B212-001-11 and B212-002-11 for the witnessed tests. The QAI wrote accompanying TL-6032 reports for the respective tests. Reference the TL-6032 reports for additional information.

The QAI was asked to sample Geomet fastener assemblies that have been shipped to the job site from LeJeune Bolt Supplier. The QAI met with Caltrans Transportation Engineer Bob Brignano and picked check samples from the shipment. The QAI issued lot number B212-003-11 and wrote a TL-102 report for the check samples. The QAI noted that the samples will be taken to TransLab at a later time.

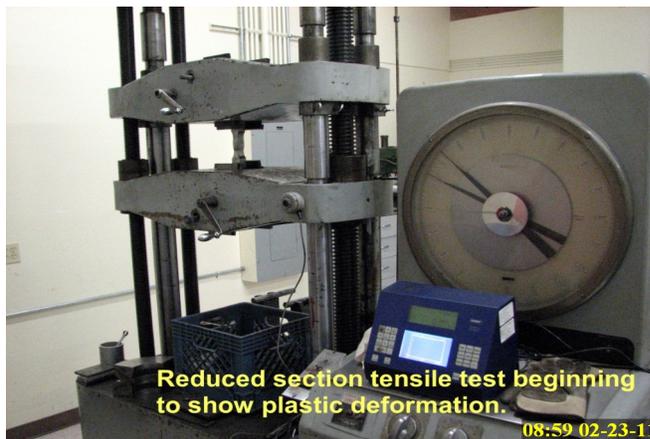
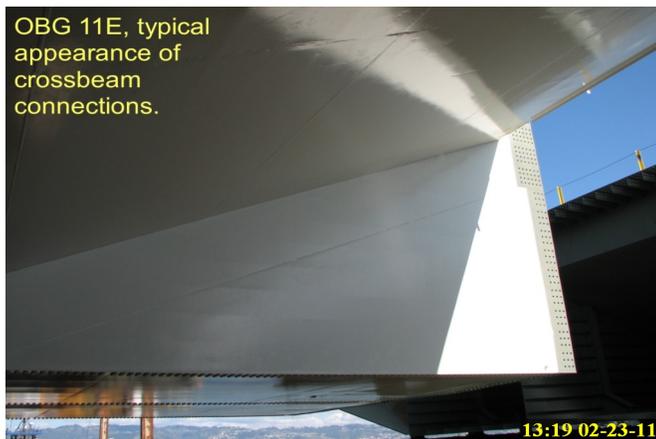
The QAI accompanied Caltrans representatives Jason Wilcox, Saman Soheilifard, Philip He, Sanny Khow, ABF representatives Chuck Kanapicki and William Norris in conducting the post arrival inspection of voyage 7 components. During the inspection, the QAI noted that painted surfaces have been marred from general shipping and handling. The QAI noted that minor rusting is visible through the primer coating on the edges of the upper splice connection of the South Tower Shaft. The QAI noted there does not appear to be other shipping related damage. The QAI noted there are other components that have not been examined for post arrival at this time. The QAI was informed that additional post arrival inspections of voyage 7 components will be scheduled when ready.

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See the attached photos.

The QAI observed ABF personnel fitting and tack welding cover plates into the Tower Grillage at Pier 7. The QAI noted that the 4 tower shaft sections have 10 plates that will be installed and welded into the grillage. The QAI measured the cover plates at 25mm thick and noted that all the materials to be welded are grade 485W. The QAI was informed that only tack welding is approved at this time and that the welding procedures are still being developed. The QAI noted that the Quality Control (QC) Inspector Mike Johnson is monitoring the tack welding. The QAI noted that Rick Clayborn, ID 2773, and Eric Sparks, ID 3040, are using shielded metal arc welding (SMAW) to make the overhead tack welds. The QAI noted that 3.2mm diameter, E9018-H4R electrodes are being used for the tack welding. The QAI noted that tack welding is not completed and will continue tomorrow, 2.24. 2010.



Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift, as noted above. The QAI relayed the status of weld testing and tower grillage welding to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations.

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.

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