

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-021020**Date Inspected:** 23-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 Items Observed**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:** Orthotropic Box Girders**Summary of Items Observed:**

At the start of the shift the Quality Assurance Inspector (QAI) traveled to the project site and observed the following work performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below:

- A). "A" Deck Stiffeners
- B). Deck Access Hole
- C). QC Inspection Request/QAI Verification
- D). Pipe Supports
- E). Miscellaneous Task

A). "A" Deck Stiffeners

The QAI observed the Complete Joint Penetration (CJP) welding of the longitudinal stiffener plate at the deck access hole located at Panel Point 24.5 and identified as WN: 4W-PP24.5-W5-LSE. The welding was performed by Xiao Jian Wan ID-9677, utilizing the SMAW process as per the Welding Procedure Specification (WPS) identified as ABF-WPS-D15-1012-3, Rev.0. The WPS was also utilized by the QC inspector Gary Erhsom as a reference to verify the amperage which was recorded as 124 amps and to monitor the welding. The welding was performed in the vertical (3G) position with the work placed in an approximate vertical plane and the groove approximately vertical. The minimum preheat temperature of 100 degrees Celsius and the interpass temperature of 230 degrees Celsius appeared to comply with the contract documents. The welder utilized a slag hammer and a wire wheel attached to a 4" high cycle grinder to remove slag after the deposit of each fill pass. The electrodes were stored in electrically heated, thermostatically controlled oven after removal from the sealed containers. The

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

exposure limits of the electrodes identified as E9018-H4R and the minimum storage oven temperature of 250 degrees Celsius appeared to be in compliance with the contract documents. At the time of the observation no issues were noted by the QAI.

The QAI also observed the Complete Joint Penetration (CJP) welding of the longitudinal stiffener field splice identified as WN: 3W-4W-A-LS3. The welding was performed by Hua Qiang Hwang ID-2930 utilizing the Shielded Metal Arc Welding (SMAW) process as per the Welding Procedure Specification (WPS) identified as ABF-WPS-D15-1012-3, Rev.0. The WPS was also utilized by the QC inspector Mr. Erhsom as a reference to monitor the welding operation and verify the welding parameters. The amperage was observed by the QAI and recorded by the QC inspector as 122 amps. The welding was performed by the welder in the vertical (3G) position with the work placed in an approximate vertical plane and the groove approximately vertical. The minimum preheat temperature of 100 degrees Celsius and the interpass temperature of 230 degrees Celsius appeared to comply with the contract documents. The welder utilized a slag hammer and a wire wheel attached to a 4" high cycle grinder to remove slag after deposit of each fill pass. The electrodes were stored in electrically heated, thermostatically controlled oven after removal from the sealed containers. The exposure limits of the electrodes identified as E9018-H4R and the minimum storage oven temperature of 250 degrees Celsius appeared to be in compliance with the contract documents. At the time of the observation no issues were noted by the QAI.

B). DAH at PP61.5

The QAI observed the welder Jorge Lopez ID-6149 performed the repair welding of the area marked as a UT reject on the deck access hole Complete Joint Penetration (CJP) groove weld located at Panel Point 61.5 and identified as WN: 8W-PP61.5-W5-SW, R2 cycle repair. The discontinuity was discovered by the QC technician John Pagliero. The repair welding was performed utilizing the Shielded Metal Arc Welding (SMAW) process and the 3.2mm electrode as per the Welding Procedure Specification (WPS) identified as ABF-WPS-1001 Repair Rev. 0. The WPS was also used by the QC inspector, William Sherwood, as a reference to monitor and verify the Direct Current welding parameters which were noted as 134 amps. The welding was performed in the flat (1G) position with the work placed in an approximate horizontal plane and the weld metal deposited from above. The dimensions of the excavation was measured by Mr. Sherwood and were noted as follows; Y=2590 mm, L=50 mm and d=14 mm.

C).QC Inspection Request

At the request of Quality Control Field Supervisor, Bonifacio Daquinag, the QAI randomly verified the QC visual inspection of the Complete Joint Penetration (CJP) welding of the following; WN: 6W-PP46.5-W5-SE, 3W-PP19.5-E5, R1, 3W-PP19.5-W2-NW and the overhead welding at 4W-PP27-W4, Weld numbers 2 and 4. The QAI verification was performed to verify that the welding and the visual weld inspection performed by the QC inspector meet the requirements of the contract documents. The QAI verification was performed on the overhead portion of the CJP's as requested by Mr. Daquinag. At the conclusion of the QAI verification it appeared that the welds and the QC inspection complies with the contract documents.

Later in the shift, the QAI performed a random Ultrasonic Test (UT) and Magnetic Particle Test (MPT) of the Complete Joint Penetration (CJP) groove welds, mentioned in the above paragraph. A total area of approximately 10% was tested to verify the weld and the testing performed by QC meet the requirements of the contract

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

documents. An ultrasonic test report TL-6027 and a magnetic particle test report TL-6028 was generated on this date.

D). Pipe Supports

The QAI observed the welder, Rick Kiikvee-ID-5319, perform the fillet welding of the PS-4 pipe supports at the bent cap located at grid line W2E1. The welding was performed utilizing the Weld Procedure Specification (WPS) identified as Fillet Murex and the Request for Information (RFI) RFI 2313, PS4 Alternative which was also utilized by the QC inspector, Steve Jensen, to monitor the welding and to verify the welding parameters. The QC inspector verified the welding parameters and were observed as 98 amps.

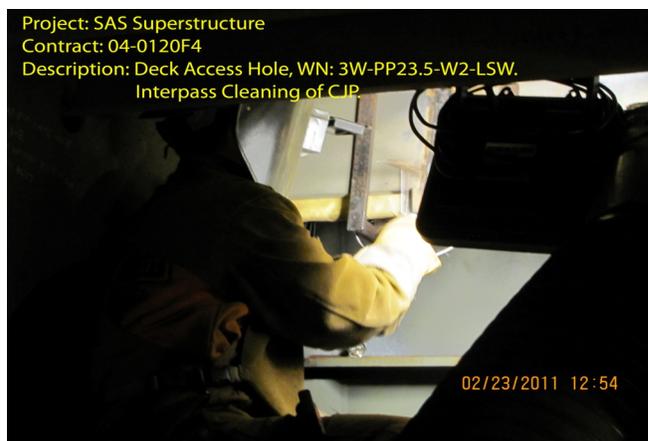
E). Miscellaneous Task

The QAI also performed a review and update of the project progress utilizing QA field reports and NDT reports. The updated project information was documented into the various QA tracking logs.

QA Observation and Verification Summary

The QA inspector observed the QC activities and the welding of the field splices utilizing the WPS as noted above, which appeared to be posted at the weld station. The welding parameters and surface temperatures were verified by the QC inspectors utilizing a Fluke 337 clamp meter for the electrical welding parameters and a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. The ESAB consumables utilized for the SMAW welding process appeared to comply with the AWS Specification and AWS Classification. The QC inspection, testing and welding performed on this shift appeared to be in general compliance with the contract documents. At random intervals, the QAI verified the QC inspection, testing, welding parameters and the surface temperatures utilizing various inspection equipment and gages which included a Fluke 337 Clamp Meter and Tempilstik Temperature indicators.

The digital photographs below illustrate some of the work observed during this scheduled shift.



WELDING INSPECTION REPORT

(Continued Page 4 of 4)

Summary of Conversations:

There were general conversations with Quality Control Field Supervisor, Bonifacio Daquinag, Jr. at the start of the shift regarding the location of American Bridge/Fluor welding, inspection and N.D.E. testing personnel scheduled for this shift.

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:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
