

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-021717**Date Inspected:** 09-Mar-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:** 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:** Tower Grillage**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 monitor American Bridge/Fluor (ABF) welding operations. This Quality Assurance (QA) Inspector, Craig Hager was on site between the times noted above.

This QA Inspector performed a random visual verification of the work in process on the Partial Joint Penetration (PJP) welds in the South Tower leg and observed excessive weld reinforcement outside the required fillet weld area towards the toe of the weld adjacent to the 25 mm thick plates at several areas. This observation was discussed with QC Inspector Fred Von Hoff who brought up the issue with QCM Jim Bowers later this date. The issue was discussed and both QC Inspector Fred Von Hoff and QCM Jim Bowers agreed conditions typical to as stated above would require grinding to correct the contour of the weld profile. This QA Inspector was informed by QCM Jim Bowers that all Complete Joint Penetration (PJP) welds would be ground flush or within 2 mm of flush to perform the required Ultrasonic Testing (UT). As of this date ABF personnel have not started removing arc strikes, weld spatter and in general cleaning the PJP welds in the South Tower for QC/QA inspection.

South Tower leg:

This QA Inspector randomly observed ABF Welding personnel Richard Garcia (#5892) and Jason Collins (#8128) were performing Shielded Metal Arc Welding (SMAW). ABF welding personnel Jason Collins (#8128) was welding on fillet welds TGS-P2-F, TGS-P5-F and TGS-P8-F which appeared to approximately 25% completed at the end of the shift this date. ABF welding personnel Richard Garcia (#5892) proceeded with repair

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welding at CJP weld TGS-P1-P5. ABF welding personnel Richard Garcia (#5892) had completed welding of the CJP's except for several fill and cover passes on TGS-P1-P5 prior to relocating to the East Tower leg this afternoon. ABF welding personnel Jason Collins (# 8128) finished welding on TGS-P1-P5, which completed welding on the CJP weld this date.

East Tower leg:

This QA Inspector randomly observed ABF welding personnel Sal Sandoval (#2202) was performing SMAW fill passes on various CJP welds. This, afternoon ABF welding personnel Richard Garcia (#5892) moved to this tower and started production welding CJP welds. This QA Inspector observed the following CJP welds had been completed by the end of the shift this date; TGE-P1-P2, TGE-P2-P3 and TGE-P8-P9. The welding observed appeared to follow the weld sequence map.

West Tower leg:

This QA Inspector randomly observed ABF welding personnel Gilbert Peralta (#9453) and Rick Clayborne (#2733) performing SMAW root passes on various CJP welds depositing a minimum thickness of 4-5 mm. This QA Inspector observed the preheating blankets, hoses and power supplies had been moved and the blankets secured to the outer skins of this tower leg. At approximately 1300 hours preheating of outer skin plates D and A was started. The root passes of the CJP welds were completed in what appeared to be compliance with the weld sequence map and welding on the PJP welds at skin plates D and A was started as soon as the outer plates were up to the minimum preheat temperature of 350°F. This QA Inspector randomly observed ABF welding personnel Todd Jackson monitoring the preheat using an electronic temperature gauge. This QA Inspector randomly observed the welding personnel use hand held gas torches to preheat the weld area. This QA Inspector also observed QC Inspector Fred Von Hoff verify the preheat temperature prior to welding using an electronic temperature gauge.

This QA Inspector was informed by QC Inspector Fred Von Hoff the welding parameters for the personnel noted above were within the required heat input range in the Welding Procedure Specifications (WPS) ABF-WPS-D15-1162-4 for the PJP welds, ABF-WPS-D15-1042A-4 for CJP welds and ABF-WPS-D15-F1206 for Fillet welds. Note the welding parameters are the same for all three procedures. This QA Inspector randomly observed the amperages and voltages of ABF welding personnel noted above and they appeared to be within the ranges in the WPS. This QA Inspector observed that both 3.2 mm and 4.0 mm diameter E9018H4R electrodes were being used and stored in separate heated storage containers. This QA Inspector also observed the 1-hour exposure limit for the electrodes appeared to be monitored and adhered to.

The welding/work observed this date appeared to comply with the contract requirements.

This QA Inspector had previously received Weekly Welding Report submittal; ABF-Sub-001536 Rev-44. This QA Inspector performed a review of the documents to determine compliance with the Welding Quality Control Plan (WQCP) submitted by the contractor, compliance with the applicable contract requirements and to determine if any Quality Control (QC) documents were missing. This QA Inspector documented the findings on a weld specific tracking log and informed QA Inspector Bill Levell of the findings. This QA Inspector placed the reviewed documents in the applicable files.

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Summary of Conversations:

This QA Inspector had general conversations with American Bridge/Fluor (ABF) and Caltrans personnel during this shift. Except as described above there were no 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.

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