

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 #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022027**Date Inspected:** 18-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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**Summary of Items Observed:**

This Quality Assurance Inspector (QAI) was present at the Tower Grillage assembly located at Pier 7. The following items were observed.

North Tower Shaft

This QA Inspector randomly observed ABF welding personnel Gilbert Peralta (#9453) and Rick Clayborn (#2733) performing Shielded Metal Arc Welding on complete joint penetration welds, P1 – P5 (Mr. Clayborn) and P8 –P9 (Mr. Peralta). Welding Procedure Specifications (WPS) ABF-WPS-D15-1042A-4 with both 3.2 mm and 4.0 mm diameter E9018H4R electrodes was utilized. This QA Inspector observed QC Inspector Fred Von Hoff verify the minimum preheat temperature at various times using an electronic temperature gauge. Welds P1 –P2, P2 –P3 and P7 – P8 have been completed. The welding/work observed this date appeared to comply with the contract requirements.

South Tower Shaft

No work performed on this date.

East Tower Shaft

This QA Inspector randomly observed QC Inspector Fred Von Hoff perform visual and Magnetic Particle Testing (MT) on the Complete Joint Penetration (CJP), Partial Joint Penetration (PJP) and Fillet welds in the east tower shaft. Mr. Von Hoff reported that the Magnetic Particle Testing was complete and no relevant indications were observed. This QA Inspector completed the Magnetic Particle Testing verification on the Complete Joint Penetration (CJP), Partial Joint Penetration (PJP) and Fillet welds (as applicable). See Magnetic Particle Test

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Report (TL-6028) for additional details.

West Tower Shaft

This QA Inspector randomly observed ABF welding personnel Salvador Sandoval (#2202) performing Shielded Metal Arc Welding on the various fillet welds. Welding Procedure Specification (WPS) ABF-WPS-D15-F1206 with 3.2 mm diameter E9018H4R electrodes was utilized. The fillet welds were completed on this date and QC Inspector Fred Von Hoff began an initial visual inspection of all welds in the West Tower Shaft. He marked various defects such as weld contour, excessive weld reinforcement, arc strikes and weld spatter for grinding with a soapstone marker. Mr. Sandoval then began performing minor repairs. The welding/work observed this date appeared to comply with the contract requirements.

Summary of Conversations:

General conversations with QC personnel regarding welding locations and schedule.

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:	Lanz,Joe	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
