

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-022413**Date Inspected:** 28-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:** Steve McConnell**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 randomly observed the following.

North and South Suspender Brackets:

Production welding is completed, QC inspections are completed and accepted, QA verification inspections completed.

East Tower leg:

Production welding is completed, QC inspections are completed and accepted, QA verification inspections completed.

South Tower leg:

Production welding is completed, QC inspections are completed and accepted, QA verification inspections completed.

West Tower leg:

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This QA Inspector randomly observed QC Inspector Steve McConnell perform Ultrasonic Testing of the repaired section of weld at weld joint TG-W-P2-P3, after the 48 hour hold time. QC Inspector Steve McConnell informed this QA Inspector the weld repair was accepted. This QA Inspector had performed UT verification after the 48 hour hold time and the work appeared to comply with the contract requirements.

North Tower leg:

This QA Inspector randomly observed QC Inspector Steve McConnell perform Ultrasonic Testing of the repaired section of weld at weld joints TG-N-P5-P7 and TG-N-P1-P2, after the 48 hour hold time. QC Inspector Steve McConnell informed this QA Inspector the weld repair at both of the weld joints, TG-N-P5-P7 and TG-N-P1-P2, were not acceptable due to defects observed during the UT. This QA Inspector randomly observed as QC Inspector Steve McConnell re-inspected the areas marked as reject and the UT signals. QC Inspector Steve McConnell informed ABF welding Foreman Frank Brajkovich of the repairs. ABF welding Foreman Frank Brajkovich stated he did not think the repair welding would be performed this date and implied that it might be performed after the tower section was in place. At this time it appeared the welding connex was closed and locked by ABF welding Foreman Frank Brajkovich. QC Inspector Fred Von Hoff was present and this QA Inspector requested to be notified if and when repair welding was performed this date.

Later this date, this QA Inspector went by the grillage jobsite and observed ABF welding personnel were on site. This QA Inspector observed that repair excavations had been started on weld joints TG-N-P5-P7 and TG-N-P1-P2. This QA Inspector observed QC Inspector Steve McConnell was present. This QA Inspector observed the excavation at weld joint TG-N-P5-P7 was located at Y-500 mm, 140 mm long, 26 mm deep and 30 mm wide. QC Inspector Steve McConnell informed this QA Inspector he had performed Magnetic Particle Testing (MT) and accepted the excavation. This QA Inspector observed the repair excavation at weld joint TG-N-P1-P2 was in process. QC Inspector Steve McConnell stated he had not performed MT at this location. These observations did not change by the end of the shift this date.

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
