

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-022505**Date Inspected:** 13-Apr-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 below**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:** SAS OBG**Summary of Items Observed:**

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above. The QA Inspector was on site to randomly observe the in process welding the following observations were made:

5E-pp35-E3-4

The QA Inspector randomly observed the ABF welder identified as Jason Collins utilizing a burr bit grinder to excavate ultrasonic testing rejection in the above identified weld joint. The QA Inspector randomly observed and noted the above identified weld joint or lifting lug hole restoration had one UT reject. The QA Inspector observed the ABF welder begin the excavation in lifting lug hole #4. After the excavations were completed the QA Inspector randomly observed the QC Inspector Freddy Vonhoff performing MT of the excavated weld joint. The QA Inspector noted no rejectable indications were located at the time of the testing. The QA Inspector randomly observed the ABF welder preheat the excavated area and perform the SMAW repair. The QA Inspector noted the ABF welder utilized 1/8 E7018 low hydrogen electrodes with 123 Amps. The weld repair was completed and ground flush on this date.

7E-pp56-E4-2&4

The QA Inspector randomly observed the ABF welder Jason Collins performing carbon arc gouging and back grinding of the above identified weld joints. The QA Inspector randomly observed the ABF welder grind the back gouged weld joints to bright metal. The QA Inspector randomly observed the back gouged weld joints and noted they appeared to be in general compliance with the contract requirements. The QA Inspector randomly observed the SE QC Inspector Fred Vonhoff perform magnetic particle testing of the back gouged weld joint and noted no relevant indications were present at the time of the testing. The QA Inspector randomly observed the ABF welder

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

continue welding the in process lift lug hole restoration of the lifting lug hole identified as #2. The QA Inspector noted the weld joint was approximately 50% complete at the time of the SMAW 4G back weld. The QA Inspector randomly observed the ABF welder continue the SMAW cover pass. The QA Inspector noted the ABF welder completed #2 and moved over to #4. The QA Inspector randomly observed the SMAW parameters were 1/8" E7018 low hydrogen electrodes with 119 Amps. The QA Inspector noted the parameters appeared to be in general compliance with ABF-WPS-1070A R1. The QA Inspector randomly observed the ABF welder did complete the above identified lifting lug hole on this date. The QA Inspector noted the weld reinforcement was ground flush on the QA Inspectors shift. The QA Inspector observed the grinding did appear to comply with the contract requirements for the lifting lug hole identified as #2 & #4.

The QA Inspector then performed a job walk of both east and west bound OBG decks inside and out to document ABF production welding status to today's date. All data collected was updated in on site spreadsheets for future reference. The QA Inspector generated and updated in process weld tracking and NDT tracking of the transverse field splices, deck access holes, longitudinal 485 HPS stiffeners and lifting lug holes for the duration of the shift. The data that was recorded in the field was transferred to the on site tracking logs for future reference and traceability of completed Caltrans QA NDT. All QA tracking logs are on site for reference. In addition the QA Inspector worked with a familiarized the QA Inspector Doug Frey with the SAS and OBG components.

Summary of Conversations:

no pertinent conversation noted.

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:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
