

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-022537**Date Inspected:** 13-Apr-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:** Jobsite**CWI Name:** Gary Ehram**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:**

Quality Assurance inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. Access Plate Longitudinal Stiffener Field Splice @ 8W PP70.5 W5
2. Lifting Lug Hole #2 @ 7W PP55 W3

1. Longitudinal Stiffener Field Splice 8W PP70.5 W5

The QA Inspector observed that the ABF welder Jin Pei Wang had completed welding the west end face B of the Longitudinal Stiffener (LS) on the access plate located at PP70.5. The QA Inspector randomly performed a Visual Inspection of the ground and blended weld surface and it appeared to be acceptable. The QA observed the welder begin to install the induction heating blankets on face A of the east end of the LS to ensure the minimum required preheat for grade 485W HPS steel was achieved prior to welding. The QA Inspector randomly verified utilizing a 200°F temperature indicating marker and noted the minimum required preheat had been achieved. The QA Inspector noted that the root gap varied in width from 7mm-10mm throughout the length of the root gap. The QA Inspector observed the QC Inspector identified as Gary Ehram performed a Visual Inspection of the completed weld and found it to be acceptable. It was noted by the QA Inspector that the QC annotated dimensions of the root gap adjacent the joint for the welder to repair. The QA Inspector periodically observed the welder repairing the joint. It was noted by the QA Inspector the ABF welder did not complete the repairs on the QA Inspectors shift.

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2. Lifting Lug Hole #3 7W PP55 W3

The QA Inspector observed the ABF Welder Darcell Jackson had completed the repair of the UT Indications at y=610mm. The QA Inspector recorded the measurements of the excavation to be 13mm's deep 140mm's long and 25mm's wide. The QA Inspector noted the measured ground flush condition to be +.5mm.



Summary of Conversations:

There was conversation with the QC Gary Ehram pertaining to the excessive root gap on the LS, to which the QC generally stated; "I do not like it and I marked the dimensions next to the joint for the welder to repair".

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:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
