

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-023162**Date Inspected:** 28-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name: Mike Johnson
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** S.A.S. components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

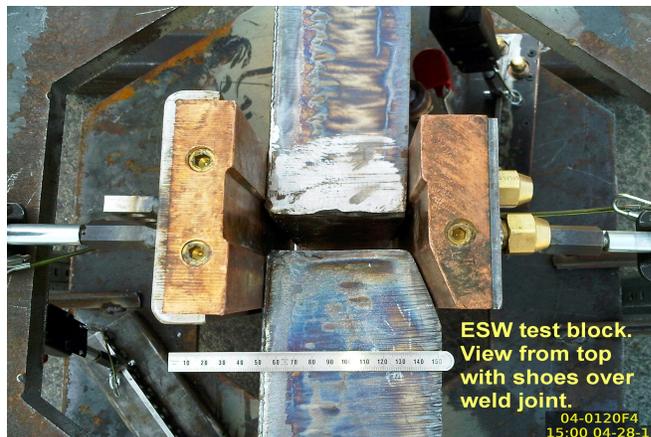
The QAI reviewed contract related documents including the submitted and approved Welding Quality Control Plan (WQCP) and approved revisions to the WQCP. The QAI continued reviewing re-flashed submittal #58. The QAI noted that the additional reports have been submitted to address category A comments from the original submittals. The submittal reviews were in progress at the end of the shift.

The QAI was requested to verify the fit-up of the full size Electro-Slag Welding (ESW) weld trial (mock up). The QAI noted that the ESW mock up is 10 meters tall. 1 half of the mock up is 80mm thick with the other half 80mm at the weld root, transitioning to 100mm thick. The QAI met with the Quality Control Inspector (QCI) Mike Johnson and was informed that root openings and planar offsets were measured every 1/2 meter. The QAI noted that the QCI's measurements were written near the root opening of the mock up. The QAI used a tapered gauge and bridge cam gauge and measured the root opening and planar offset at every 1/2 meter from the top of the ESW mock up. Reference the attached list of measurements. The QAI referenced the approved request for information (RFI) 2400 and noted that the ESW mock up is stated to have 6mm of offset in the top meter. The QAI relayed to the QAI Lead Bill Levell, there were no measurements observed that are 6mm or greater in offset, within the entire ESW mock up. The contractor was asked if they will adjust the ESW mock up so that it conforms with the approved RFI. The contractor relayed that grinding will be utilized on the top of 1 side of the mock up to induce 6mm offset. This work was in progress at the end of the shift. See the attached photo.

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The QAI noted that the contractor has set up an ESW test block. The QAI was informed that this weld will be made to verify the equipment functionality prior to the full size mock up welding. See the attached photo of the top down view of the 80mm to 100mm transition with ESW shoes in place. The QAI noted that this weld will be made at a later time.



Summary of Conversations:

The QAI relayed the status of document reviews and mock up fit-up to the QAI Lead Bill Levell. Except as described above, there were no other 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: Croff, Scott

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer
