

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-023228**Date Inspected:** 28-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**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:** Tower**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 observed the following.

This QA Inspector was requested to monitor the Electro Slag Welding (ESW) of the 10 meter mock up at pier # 7. This QA Inspector arrived at pier # 7 at approximately 0800 hours and observed the two plates had been positioned in a jig and QC Inspector Mike Johnson was measuring the root gap and off set of the two plates from a portable lift. QC Inspector Mike Johnson informed this QA Inspector he would put the information regarding the gap and off set in a chart for QCM Jim Bowers and that a copy could be obtain from him later. ABF Engineer John Callahan was also present and informed this QA Inspector he would have the lift operator available at noon and that a verification inspection could be performed at this time. This QA Inspector met with QCM Jim Bowers and was informed a QC checklist of the parameters for the ESW would be available the following day and that he would provide this QA Inspector a copy at that time.

Later this date, at approximately 1100 hours this QA Inspector was requested to assist Structural Material Representative (SMR) Jason Lee obtain the actual root gap and off set measurement at the ESW weld joint on the tower in the field. This QA Inspector and SMR Jason Lee determined elevations at the 3-meter, 5-meter, 9-meter, 11-meter and 13-meter provided access for the measurements. This QA Inspector and SMR Jason Lee decided to use the weld joint numbers provided by QC personnel to track the measurement of the 20 weld joints (weld # 9 thru # 28). This QA Inspector used a stand 15-30 mm taper gauge to measure the root gaps and a Cambridge

WELDING INSPECTION REPORT

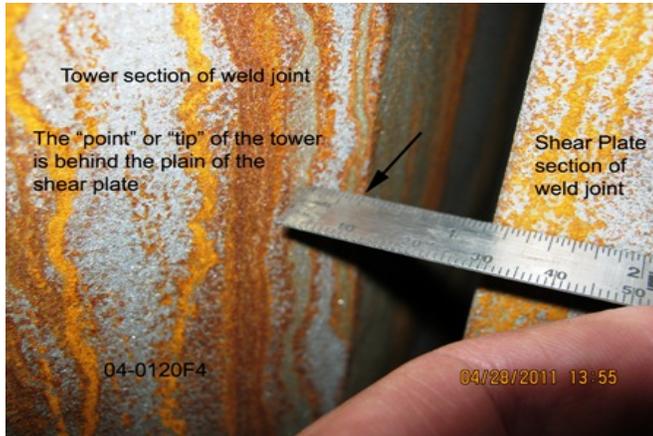
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gauge to measure the offset. See photo below of the offset found at weld joint # 16 and other joints typical to this configuration.

By the end of the shift this date approximately 50 of the 200 reading had been taken and recorded.

Summary of Conversations:

This QA Inspector had general conversations with American Bridge/Fluor (ABF) and Caltrans personnel during this shift. Except as described above and noted below 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
