

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-023483**Date Inspected:** 10-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Steve Jensen**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**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 observed the work in progress on the upper and lower Interior Corner Closure Splice Plates located at the B- C and C-D corners in the Tower sections and elevations noted below.

South Tower, elevation 51 meters: This QA Inspector observed ABF welding personnel Salvador Sandoval (#2202) performing production welding using the Flux Cored Arc Welding (FCAW) process on the lower half of the upper splice plate located at the B-C corner of the tower. This QA Inspector observed QC Inspector Steve Jensen verify the following FCAW parameters; 273 amperes and 22.1 volts at a travel speed of 100 mm per minute to produce a heat input of 3.62 Kj per mm. The welding observed appeared to comply with ABF-WPS-D15-F2200-3.

This QA randomly observed ABF welding personnel Mike Jimenez (#4671) performing production welding using the FCAW process on the lower half of the lower splice plate located at the C-D corner of the tower. This QA Inspector observed QC Inspector Steve Jensen verify the following FCAW parameters; 250 amperes and 20.9 volts at a travel speed of 90 mm per minute to produce a heat input of 3.48 Kj per mm. The welding observed appeared to comply with ABF-WPS-D15-F2200-3. Later in the shift this QA Inspector observed ABF welding

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personnel Mike Jimenez (#4671) using FCAW process for production welding on the upper splice plate, bottom half (C-D corner).

At approximately 1700 hours this date welding stopped and induction heat blankets were placed over the production welding performed this date for post heating at a temperature of 300°F for a period of 3 hours.

North Tower, elevation 51 meters: This QA Inspector observed ABF personnel Paul Frambrini using a power grinder to remove the paint from the splice plates and tower areas for lay out purposes in the fit up.

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.

This QA Inspector had observed that ABF welding personnel Mike Jimenez (#4671) was not on the current list of certified welding personnel for the FCAW-G welding process and asked Lead QC Inspector Bonifacio Daquinag Jr. if he had a more current list that showed he was certified. This QA Inspector was informed that he was not on the list, but that Mike Jimenez (#4671) had taken the welding test and the test had passed the bend test and the certification paperwork had been submitted for approval. This QA Inspector informed that ABF would be proceeding at their own risk until the FCAW-G certification for Mike Jimenez (#4671) had been formally approved.

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
