

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-023501**Date Inspected:** 11-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Steve McConnell**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:** 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 was informed that a verbal approval of welder qualifications for Mike Jimenez, ID 4671, and that he is approved to weld using flux cored arc welding (FCAW). The QAI also had conversations with the Quality Control Inspector (QCI) William Norris, regarding the status of the contractor's weekly welding report submittals. There were some general questions regarding the TL-20s that have category A and category B comments and the QAI was informed that the reports were being forwarded to the Welding Quality Control Manager (WQCM) Jim Bowers, and that he was not aware of when they would be submitted. The QAI noted that at this time, the most recent dates of submitted weekly welding reports is 2.13.2011.

The QAI met with the QAI Robert Mertz, the QCI Steven McConnell and the QCI Jesse Cayabyab. The QAIs witnessed the QCIs performing Ultrasonic Testing (UT) on the full height ElectroSlag Welding (ESW) weld trial (mock up). The QAIs noted that the procedures being used for the UT have not been approved by the Engineer at this time, however, the QCIs informed the QAIs that upon completion of the mock up testing, the procedures will be submitted for approval. The QAIs were informed that there were no rejectable indications observed during the UT inspection. The QAI began to conduct a verification UT and could not complete the testing during this shift. The QAI also noted that the contractor is setting up to conduct Radiographic Testing (RT) of the mock up. The QAI noted that the QAI Joe Lanz will be monitoring this work.

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Summary of Conversations:

The QAI relayed the status of document reviews and the ESW mock up testing 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
