DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-025211
Date Inspected: 13-Jul-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 730
OSM Departure Time: 1600
Location: Job Site

CWI Name: Mike Johnson

	Yes	No	N/A
Inspected CWI report:	☑	☐	☐
Electrode to specification:	☑	☐	☐
Qualified Welders:	☑	☐	☐
Approved Drawings:	☑	☐	☐

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

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 following observations were made:

1) Service Platform repairs at Pier 7
2) General Atmospheric Conditions on S.A.S. structure
3) Submittal reviews at Pier 7

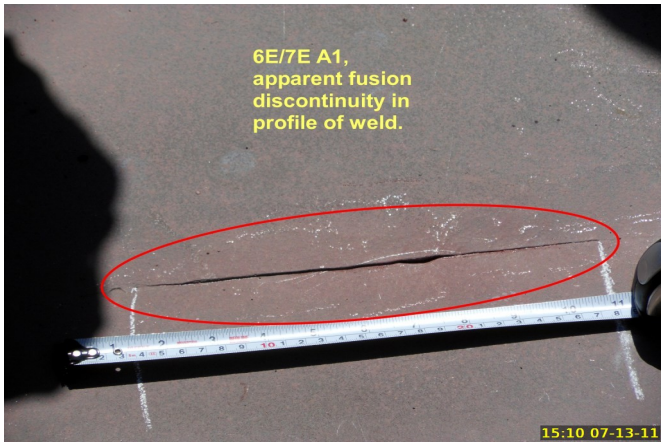
1)The QAI observed ABF personnel setting up welding equipment at Pier 7, in order to complete the service platform repairs. The QAI met with the Quality Control Inspector (QCI) Mike Johnson and was informed that fillet welds and weld repairs will be conducted. The QAI was informed that tentatively, Richard Bazewicz will be the qualified welder making these repairs. The QAI noted that parts have not been fit-up at this time but surface preparations are completed (paint and rust removed from areas to be welded). The QAI was not present to witness the welding of the service platform repairs. See the attached photo.

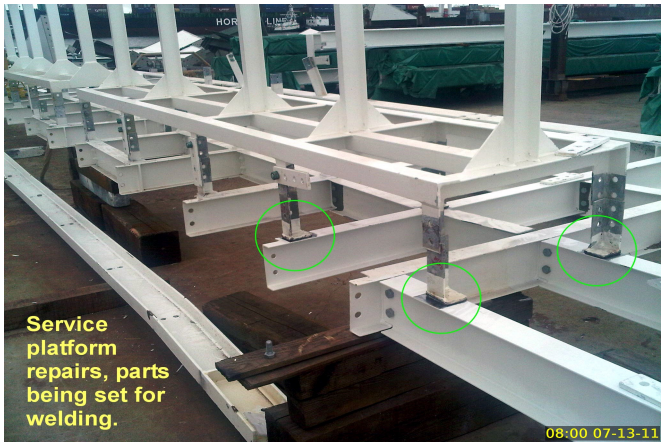
2) The QAI was present on the S.A.S. Structure and met with the contractor's painting personnel. The QAI was informed that painting operations are in progress inside the tower splice at 114m elevation and at Pier 7. The QAI measured the atmospheric conditions to be 63F ambient temperature, 73% relative humidity and 54F dew point temperature. The QAI noted that the steel temperature appears to be 62F and higher at the work locations. The QAI also noted that the cloudy weather was clearing up and warming up, with no apparent adversity to painting conditions. The QAI noted that through the remainder of this shift, there did not appear to be non-conforming

weather conditions while painting operations were underway.

3) 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 the informal welding report packages that consist of F.W. Spencer mechanical and pipe welding. The QAI noted that these reports cover all welding from the beginning of work up to June 2011. These reviews were in progress at the end of the shift.

While the report reviews were in progress, the QAI was asked to go to field splice 6E/7E, weld A1. The QAI was informed by ABF's Welding Quality Control Manager (WQCM) Jim Bowers, that there appeared to be a crack in the existing, completed and accepted weld. The QAI Lead Bill Levell requested that the QAI investigate and report the current visual condition of this weld. The QAI then noted that the weld appears to have a dark line and is not completely fused across it's width. The QAI observed ABF personnel removing the paint from this area. The QAI asked if any testing has been performed to determine the nature of this aberration. The QAI was informed that due to the time of day, all remaining investigation will take place tomorrow. The QAI relayed these observations and photos of the weld to the QAI Lead Bill Levell. The QAI was informed that the QAI Danny Reyes will follow up on the weld status tomorrow. See the attached photo.





Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed the observations and status of work to the QAI Danny Reyes and the QAI Lead Bill Levell. Except as described above, there were no other notable conversations or observations.

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