

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 #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025359**Date Inspected:** 26-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** William Sherwood**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:** OBG COmponents**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

This QA randomly observed ABF/JV qualified welder Jorge Lopez perform Complete Joint Penetration (CJP) groove welding of cover pass on the splice butt joint where the track mounted "Bug-O" nozzle holder has limited access. The location was at OBG 11W/12W side plate (750mm) inside at intersection of the side and bottom plate (D/C). The welder was observed performing manual welding in the 3G (vertical) position utilizing a Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1040B. The joint being welded has a single V-groove butt joint with backing bar.

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters.

This QA Inspector randomly observed ABF welding operator Jin Pei Wang ID#7299 performing Flux Core Arc Welding w/gas (FCAW-G) operations in the 3G vertical position on side plate C on the outside of the OBG 10W/11W. The QA Inspector observed the QC Inspector William Sherwood as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3042B-1. The QA Inspector noted that the work is appears to be in general conformance with the contract documents.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant 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 SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Clifford, William

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer