

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 #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025360**Date Inspected:** 27-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 Xiao Jian Wan #9677 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-2200-A. The joints being welded were 6mm fillet welds, all around, at West line, cat walk anchorage to deck plate, pp107 and pp108.

During welding, ABF Quality Control (QC) Fred Vonhoff was noted monitoring the welding parameters.

Welding parameters were recorded as (A=310/V=22.5).

This QA randomly observed ABF/JV qualified welder Jimmy Zhen #6001 performing Flux Core Arc Welding w/gas (FCAW-G) and implementing Caltrans approved Welding Procedure Specification (WPS)

ABF-WPS-D15-3042B-1. The joints being welded were in the 3G vertical position at the side plate C1 on the outside of the OBG 10W/11W.

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

Welding parameters were recorded as (A=246/V=24.5).

-During random visual inspection this QA inspector observed three (3) individual locations where slag inclusions could be seen in the weld groove prior to Mr. Zhen starting the weld procedure. Mr. Zhen employed an angle grinder to remove these inclusions before welding was initiated.

A photograph representing these inclusions is attached to this report.

WELDING INSPECTION REPORT

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This QA randomly observed ABF/JV qualified welder Hua Qiang Huang #2930 performing Flux Core Arc Welding w/gas (FCAW-G) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3042B-1. The joints being welded were in the 3G vertical position at the side plate E2 on the inside of the OBG 11W/12W.

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters. Welding parameters were recorded as (A=245/V=24.5).

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



Summary of Conversations:

No relevant conversation.

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
