

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025369**Date Inspected:** 29-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 / Pat Swain**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 welders Xiao Jian Wan #9677 and Jin Pei Wang #7299 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=220/V=13.6/T=195).

13:34 - This QA randomly observed a loss of electrical power at this welding location. The welding process was halted until 13:45 when electrical power was restored. A loss of preheat was observed with the material registering a temperature of 126 degrees fahrenheit. Preheat was restored to a WPS required minimum of 150 degrees fahrenheit before welding was resumed.

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 E1 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=265/V=25/T=265).

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This QA randomly observed ABF/JV qualified welder 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 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=150/V=23.5/T=250).

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

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
