

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-025388**Date Inspected:** 28-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:** Tony 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 Sections**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and monitor American Bridge/Fluor (ABF) welding operations. This Quality Assurance (QA) Inspector, Craig Hager observed the following.

This QA Inspector met with Assistant Structural Material Representative Jason Lee to verify the status of work, QC Inspections and QA verifications of various components on the Self Anchored Suspension (SAS) Bridge, Tower sections. This QA Inspector provided specific information and details as requested.

Orthotropic Bridge Girder (OBG) Sections:

11W/12W-E2: This QA Inspector randomly observed ABF welding personnel Hua Qiang Hwang (#2930) using the Flux Cored Arc Welding (FCAW) process in the vertical (3G) position inside this OBG section. This QA Inspector observed a magnetic track (Bug-O) system was being used for welding. This QA Inspector randomly observed QC Inspector Tony Sherwood verify the following welding parameters; 250 amperes and 24.5 volts at a travel speed of 300 mm per minute to produce a heat input value of 1.23 Kj per mm. The welding observed appeared to comply with ABF-WPS-D15-3042B-1. This QA Inspector periodically observed QC Inspector Tony Sherwood monitoring the work at this location. This QA Inspector observed that as of 0900 hours this date the groove weld joint was approximately 50% completed. This QA Inspector observed later this date that welding had been completed at this location and that ABF personnel were in the process of moving the magnetic track system or Bug-O to the E1 splice weld at this location.

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11W/12W-C1: This QA Inspector randomly observed as ABF welding personnel Wai Kitlai (#2953) was setting up the FACW process on the magnetic based track system being used. This QA Inspector observed production welding started approximately 1015 hours this date. This QA Inspector randomly observed as QC Inspector Tony Sherwood verified the following welding parameters; 240 amperes and 24 volts at travel speed of 270 mm per minute to produce a heat input value of 1.28. This QA Inspector observed at 1130 hour this date that ABF welding Foreman James Zhen replaced Way Kitlai as the welding operator at this location.

Summary of Conversations:

This QA Inspector had general conversations with American Bridge/Fluor (ABF) and Caltrans personnel during this shift. Except as described above and noted below there were no 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:	Hager,Craig	Quality Assurance Inspector
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Reviewed By:	Levell,Bill	QA Reviewer
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