

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-025655**Date Inspected:** 05-Aug-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:** Fred Von Hoff**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.

Orthotropic Bridge Girder (OBG) Sections:

10E-PP88-E3 LLH-#2 and #4 : This QA Inspector randomly observed ABF welding personnel Salvador Sandoval (#2202) using the Shielded Metal Arc Welding (SMAW) process in the overhead (4G) position inside this OBG section. This QA Inspector observed QC Inspector Fred Von Hoff perform a verification of the following welding parameters; 134 amperes using a 3.2 mm diameter E7018H4R electrode. This QA Inspector was informed by QC Inspector Fred Von Hoff that he had previously performed and accepted Magnetic Particle Testing (MT) on the back gouged section of the welds. This QA Inspector randomly observed QC Inspector Fred Von Hoff periodically monitoring the work at this location. The welding observed this date appeared to comply with Welding Procedure Specification (WPS) ABF-WPS-D15-1050A-CU. See photo below.

10E-PP92-E4 LLH-#1 and #3 : This QA Inspector randomly observed ABF welding personnel Mike Jiminez (#4671) using the SMAW process in the overhead (4G) position inside the OBG section. This QA Inspector randomly observed as QC Inspector Fred Von Hoff verified the following welding parameters; 130 amperes using a 3.2 mm diameter E7018H4R electrode. This QA Inspector observed QC Inspector Fred Von Hoff periodically monitoring the welding at this location. The welding observed appeared to comply with

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ABF-WPS-D15-1050A-CU.

10W-PP94-W1 and 11W-PP95-W1: This QA Inspector randomly observed ABF welding personnel Rick Clayborn (#2773) using the SMAW process to attach Drip Rails of approximately 400 to 500 mm each in length at each side of the locations noted above. This QA Inspector observed QC Inspector Tony Sherwood monitoring the work at this location. QC Inspector Tony Sherwood informed this QA Inspector of the following welding parameters; 125 amperes using a 3.2 mm diameter E7018H43R electrode. The welding observed by this QA Inspector appeared to comply with ABF-WPS-D15-F1200 for the fillet welds and ABF-WPS-D15-1080 for the vertical splices. See photo below of typical drip rail section and ABF personnel removing the paint with a grinder in preparation of welding.

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

Reviewed By: Levell, Bill

QA Reviewer