

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025890**Date Inspected:** 09-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.

Self Anchored Suspension (SAS) Tower:

13-Meter Elevation: The previous day this QA Inspector had been informed that Ultrasonic Testing (UT) would be performed on the top 300 mm of various Electro Slag Welding (ESW) weld joints. This QA Inspector observed QC Inspector Jesus Cayabyab was in the process of performing Ultrasonic Testing (UT) at weld location "W" (weld number W-041). QC Inspector Jesus Cayabyab informed this QA Inspector the inspection was for information purposes only and that he would soon begin the UT at ESW weld joint locations "E" and "F". This QA Inspector randomly observed as QC Inspector Jesus Cayabyab performed UT at ESW joint location "E". QC Inspector Jesus Cayabyab informed this QA Inspector he had observed a UT signal in excess of the acceptance criteria and that he was rejecting the weld at the following location; Y-9800 and X-0. QC Inspector Jesus Cayabyab informed this QA Inspector the defect was approximately 60 mm long and at a depth of 33 mm from the scanning face. After marking the face of the weld with the defect location, length and depth QC Inspector Jesus Cayabyab performed UT on the top 300 mm of weld length at location "F". This QA Inspector randomly observed the UT being performed and was informed by QC Inspector Jesus Cayabyab the weld joint at this location for the length specified was accepted. This QA Inspector performed verification UT and did not observe any signals indicating a defect. See Ultrasonic Testing Report (TL-6027) this date for weld location "F" weld joint

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number E-045 for further details.

Orthotropic Bridge Girder (OBG) Sections:

9E-PP80-E3 Lifting Lug Hole (LLH) #4: This QA Inspector randomly observed ABF welding personnel Sal Sandoval (#2202) using the Shielded Metal Arc Welding (SMAW) process in the overhead (4G) position at this location. This QA Inspector observed QC Inspector Fred Von Hoff perform a verification of the following welding parameters; 130 amperes using a 3.2 mm diameter E7018H4R electrode. This QA Inspector performed a random verification of the base metal temperature using an electronic temperature gauge and observed the preheat and interpass temperatures were within the ranges specified on the Welding Procedure Specification (WPS). This QA Inspector randomly observed QC Inspector Fred Von Hoff monitoring the work at this location. The welding observed this date appeared to comply with ABF-WPS-D15-1050A-CU.

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
