DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-025893
Date Inspected: 08-Aug-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Job Site

CWI Name: Fred Vonhoff

Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Component

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:

In Process Visual Inspection
11E/12E

This QA randomly observed ABF/JV qualified welder Hua Qiang Huang #2930 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E9018-MH4-R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1012-3. The joint being welded was a 14mm thick internal longitudinal stiffener but splice designated as L#5 on the “E” side plate, 11E/12E segment splice location.

During welding, ABF Quality Control (QC) Fred Vonhoff was noted monitoring the welding parameters. Welding parameters were recorded as (A=135/V=22.1).

-Note: Approximately 10:55 this QA observed QC Fred Vonhoff perform Magnetic Particle (MT) inspection of the weld of the excavated root area of this weld. MT was performed to ensure the presence of sound material at the root area before the back fill welding process was initiated. Mr. Vonhoff recorded no rejectable indications at this time.

This QA randomly observed ABF/JV qualified welder Xiao Jian Wan #9677 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E9018-MH4-R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1012-3. The joint being welded was a 30mm thick internal longitudinal stiffener but splice designated as L#3 on the “C” side plate, 11E/12E segment splice location.

During welding, ABF Quality Control (QC) Fred Vonhoff was noted monitoring the welding parameters. Welding parameters were recorded as (A=137/V=22.3).

This QA randomly observed ABF/JV qualified welder Salvador Sandoval #2202 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A-R1. The joint being welded was a 14mm plate insert at the “A” deck to close the lifting lug deck penetration holes. This work was located at panel point 88 and was performed in the overhead position from the bottom side of the “A” deck.

During welding, ABF Quality Control (QC) Fred Vonhoff was noted monitoring the welding parameters. Welding parameters were recorded as (A=135/V=22.3).

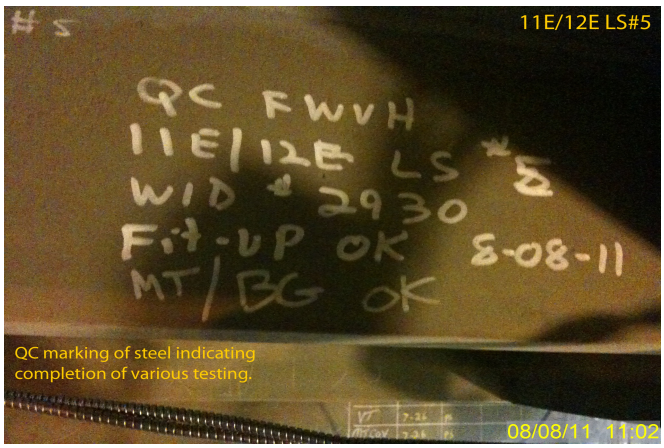
Ultrasonic Testing

This QA also performed Ultrasonic Testing (UT) on approximately 11% of a CJP deck plate splice weld previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. This QA observed no rejectable indications at the time of testing. This QA generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

Included in this testing percentage is the second time repair (R2) that was previously rejected by QC inspection using the UT inspection method at Y=3335 of the weld area designated as A1.

This weld was previously excavated to a depth = 14mm, a width = 20mm, and a length = 130mm, from Y location 3335mm – 3465mm and repair welded using WPS ABF-D15-1001-R.

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.

WELDING INSPECTION REPORT

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Inspected By:	Clifford,William	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer