

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-025896**Date Inspected:** 10-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:	William Sherwood / Fred Vonhoff			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:

In Process Visual Inspection**West Line**

This QA randomly observed ABF/JV qualified welder Rick Clayborn #2773 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A. The joint being welded were fillet welds at the West Line drip rails.

This work was located:

- 11W, Panel Points 97.9~98.1 at W1 for 965mm.
- 11W, Panel Points 95.9~96.1 at W1 for 940mm.
- 12W, Panel Points 113.3~113.9 at W6 for 1600mm.

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters. Welding parameters were recorded as (A=136/V=22.3).

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

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

longitudinal stiffener but splice designated as L#4 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=137/V=22.3).

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#1 on the "C" side of "A" 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=22.3).

Note:

This QA randomly observed that ABF welding personnel Mr. Wan has halted welding of the longitudinal stiffener designated as L#2. This QA was informed by QC Fred Vonhoff that welding was halted in response to Non Conformance Report (NCR) issued due to loss of post heat the daybefore.

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 80 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).

This QA randomly observed ABF/JV qualified welder Mike Jiminez #4671 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).

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

Summary of Conversations:

As noted above.

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

(Continued Page 3 of 3)

Inspected By: Clifford, William

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer