

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: 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-026190**Date Inspected:** 23-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:	Jesse Cayabyab		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	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 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:

10W/11W – C2: This QA Inspector observed QC Inspector Jesse Cayabyab performing Ultrasonic Testing (UT) on this Complete Joint Penetration (CJP) weld joint. This QA Inspector observed a lamination scan was being performed using a longitudinal wave transducer and a shear wave scan using a 70 degree transducer wedge. The scanning patterns and overall technique appeared to comply with the contract requirements. This was an in process inspection and results were not available at this time.

11W/12W LS-1 thru LS-6: This QA Inspector observed all the weld joints except for LS-1 and LS-2 appeared to be ready for QC inspections (visual, magnetic particle testing and ultrasonic testing), which need the run off tabs removed and/or additional grinding of the final weld contour.

9E-PP79-E4 Lifting Lug Holes #1 thru #4: This QA Inspector was informed by QC Inspector Bonifacio Daquinag Jr. and/or Pat Swain that all QC Inspections had been completed and accepted. This QA Inspector performed the visual and Ultrasonic Testing (UT) of all 4 welds. This QA Inspector performed 100% visual verification and approximately 25% of the weld length was inspected by UT. See Ultrasonic Test Report (TL-6027) this date for

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further details.

9E-PP80-E4 Lifting Lug Holes #1 thru #4: This QA Inspector was informed by QC Inspector Bonifacio Daquinag Jr. and/or Pat Swain that all QC Inspections had been completed and accepted. This QA Inspector performed the visual and Ultrasonic Testing (UT) of all 4 welds. This QA Inspector performed 100% visual verification and approximately 25% of the weld length was inspected by UT. See Ultrasonic Test Report (TL-6027) this date for further details.

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
