

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-026202**Date Inspected:** 25-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** N / A**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:** S.A.S. components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI reviewed contract related documents including the submitted and approved Welding Quality Control Plan (WQCP) and approved revisions to the WQCP. The QAI continued reviewing submittal 1536R74, for conformance with the contract requirements. The QAI continued reviewing bootleg weekly welding reports for conformance with the contract requirements. The QAI noted that 3 informal weekly report packages are still being reviewed.

The QAI witnessed rotational capacity testing (Rocap) of 2 groups of fastener assemblies at the contractor's Pier 7 bolt testing area. The QAI met with Caltrans representative Bernard Feather, ABF representative Chris Bausone and F.W.Spencer representative Tom Colombo. The QAI was informed that these fastener assemblies will be tested to determine torque values for installation on the W-2 pipe supports. The QAI observed that 5/8" 2.5" long A325 hot dip galvanized fasteners and 3/4" 3" long A325 hot dip galvanized fasteners were set up on the automated Skidmore testing station. The QAI witnessed the automated rocap testing of 3 fastener assemblies of each size and noted that all tested assemblies appeared to be above the minimum values listed in the contract requirements for turn of the nut method tensioning. The QAI was informed that additional testing / sampling will not be performed as allowed in request for information (RFI) 2454R00. See the attached photos.

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Summary of Conversations:

The QAI relayed the status of the document reviews and rocap testing observations to the QAI Lead Bill Levell. Except as described above, there were no other 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:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
