

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:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026287**Date Inspected:** 12-Sep-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:** Jesus Cayabyab**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, Electro Slag Welding (ESW):

ESW weld location N-face B: This QA Inspector observed ABF welding personnel Jeremy Dolman (# 5042) using a grinder to remove and transition the excess weld metal from the removal of a temporary attachment weld at the 3-meter elevation base plate, the removal site was centered between ESW weld locations W and N inside the tower structure. This QA Inspector randomly observed as QC Inspector Jesus Cayabyab performed and accepted Magnetic Particle Testing (MT) on the ground area. The grinding and MT appeared to comply with the contract requirements. This QA Inspector observed ABF welding personnel Jeremy Dolman (# 5042) using a grinder to remove the excess weld metal form where the strong backs for the ESW had been positioned between the 3-meter and 9-meter elevations. This QA Inspector also observed ABF welding personnel Jeremy Dolman (# 5042) using the Shielded Metal Arc Welding (SMAW) process to fill shallow (less than 10 mm deep) excavations adjacent to and in the ESW at this location. This QA Inspector randomly observed as the area was preheated using a hand held gas torch and verified to have reached the minimum preheat temperature with a temperature indicating marker. This QA Inspector randomly observed QC Inspector Jesus Cayabyab verified the following welding parameters; 118 amperes. This QA Inspector observed a 3.2 diameter E7018H4R electrode was being used. The welding observed at this time appeared to comply with Welding Procedure Specification (WPS)

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

ABF-WPS-D15-1002 Repair.

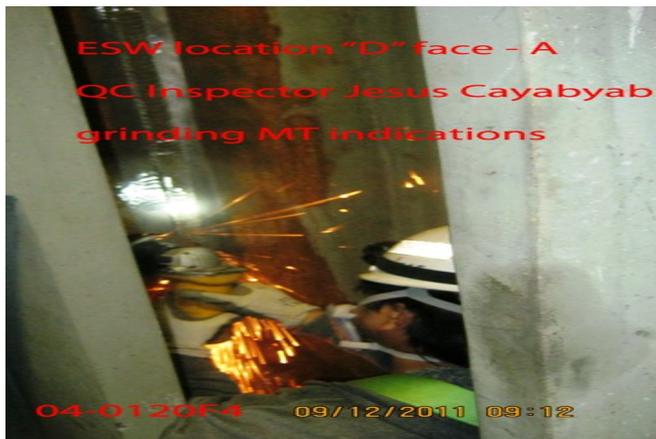
ESW weld location D -face A: This QA Inspector observed that after QC Inspector Jesus Cayabyab performed the verification of the welding parameters noted above he proceeded to start grinding MT indication at this ESW weld location, between the 3-meter and 9-meter elevations. This QA Inspector observed after performing the grinding QC Inspector Jesus Cayabyab performed MT to verify the defect was removed or to continue grinding to remove the defect. See photos below.

ESW weld location L -face A: This QA Inspector randomly observed ABF personnel Jeff Stone using a grinder to contour the weld between the 9-meter and 13-meter elevation at areas previously marked by various QC personnel.

ESW weld location M -face A: This QA Inspector randomly observed ABF personnel Alex Blanco using a grinder to contour the weld between the 9-meter and 13-meter elevation at areas previously marked by various QC personnel.

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 above 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