

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:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026397**Date Inspected:** 22-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:** Bonifacio Daquinag Jr.**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 V -face B: This QA Inspector observed ABF personnel using a grinder to remove the temporary weld attachments used to hold the strong backs in position for the ESW process.

ESW weld location T -face B: This QA Inspector observed ABF personnel using a grinder to remove the temporary weld attachments used to hold the strong backs in position for the ESW process.

This QA Inspector was informed by Lead QC Inspector Bonifacio Daquinag Jr. that Lifting Lug Holes (LLH) at various locations had been inspected and accepted by QC personnel therefore ready for QA inspection.

9W-PP79-W4 LLH # 2: This QA Inspector performed verification testing using the Ultrasonic Testing (UT) method. A shearwave inspection was performed using a 70 degree wedge for weld defects and a longitudinal straight beam for laminations in the base material. This QA Inspector did not observe any signals at this time indicating a defect in the 25% (approximately) of the weld length inspected. See Ultrasonic Test Report (TL-6027) this date for further details.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

9W-PP80-W4 LLH # 3: This QA Inspector performed verification testing using the Ultrasonic Testing (UT) method. A shearwave inspection was performed using a 70 degree wedge for weld defects and a longitudinal straight beam for laminations in the base material. This QA Inspector did not observe any signals at this time indicating a defect in the 25% (approximately) of the weld length inspected. See Ultrasonic Test Report (TL-6027) this date for further details.

11W-PP92-W3 LLH #1 and #2: This QA Inspector performed verification testing using the Ultrasonic Testing (UT) method. A shearwave inspection was performed using a 70 degree wedge for weld defects and a longitudinal straight beam for laminations in the base material. This QA Inspector did not observe any signals at this time indicating a defect in the 25% (approximately) of the weld length inspected. 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 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
