

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-026398**Date Inspected:** 23-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:****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.

Orthotropic Bridge Girder (OBG) sections:

8E-PP70-E5 NW – Access Hole: This QA Inspector observed ABF personnel Jose Gonzales using a grinder to bevel the deck side of weld joint in preparation for the fit up. Later this date this QA Inspector observed ABF welding personnel Rick Clayborn (#2773) working with ABF personnel Jose Gonzales on the fit up of the access plate hole. This QA Inspector observed QC Inspector Tony Sherwood was present and was informed that the fit up inspection was not completed this date.

12E-PP115-E3 Lifting Lug Hole (LLH) # 1: This QA Inspector observed ABF welding personnel Fred Kaddu (#2188) using the Shielded Metal Arc Welding (SMAW) process on the top deck of this weld joint. This QA Inspector observed QC Fred Von Hoff verify the following welding parameters; 240 amperes. This QA Inspector observed a 4.8 mm diameter E7018H4R electrode was being used. The welding observed appeared to comply with Welding Procedure Specification (WPS) ABF-WPS-D15-1050-CU. This QA Inspector randomly observed during the shift a hand held gas torch was used to preheat the base material and used an electronic temperature gauge to monitor the preheat and interpass temperatures.

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12E-PP114-E4 lifting Lug Hole (LLH) # 1: This QA Inspector observed ABF welding personnel Jorge Lopez (#6149) using the Shielded Metal Arc Welding (SMAW) process on the top deck of this weld joint. This QA Inspector observed QC Fred Von Hoff verify the following welding parameters; 270 amperes. This QA Inspector observed a 4.8 mm diameter E7018H4R electrode was being used. The welding observed appeared to comply with Welding Procedure Specification (WPS) ABF-WPS-D15-1050-CU. This QA Inspector randomly observed during the shift a hand held gas torch was used to preheat the base material and used an electronic temperature gauge to monitor the preheat and interpass temperatures.

10W-PP92-W4 Lifting Lug Hole (LLH) #1: This QA Inspector observed ABF welding personnel Mike Jiminez (#4671) using the Shielded Metal Arc Welding (SMAW) process on the top deck of this weld joint. This QA Inspector observed QC Salvador Merino verify the following welding parameters; 146 amperes. This QA Inspector observed a 3.2 mm diameter E7018H4R electrode was being used. The welding observed appeared to comply with Welding Procedure Specification (WPS) ABF-WPS-D15-1050-CU. This QA Inspector randomly observed during the shift a hand held gas torch was used to preheat the base material and used an electronic temperature gauge to monitor the preheat and interpass temperatures.

8E-PP61.5-E5 NW Access Hole: This QA Inspector observed QC Inspector Pat Swain using the Ultrasonic Testing (UT) method to perform a QC inspection. QC Inspector Pat Swain informed this QA Inspector he had previously performed and accepted a visual and Magnetic Particle Testing (MT) on the weld joint. The UT observed by this QA Inspector appeared to comply with the contract requirements, the UT inspection was in process therefore no results were provided at this time.

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
