

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:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026482**Date Inspected:** 07-Oct-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:** Pat Swain**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:**

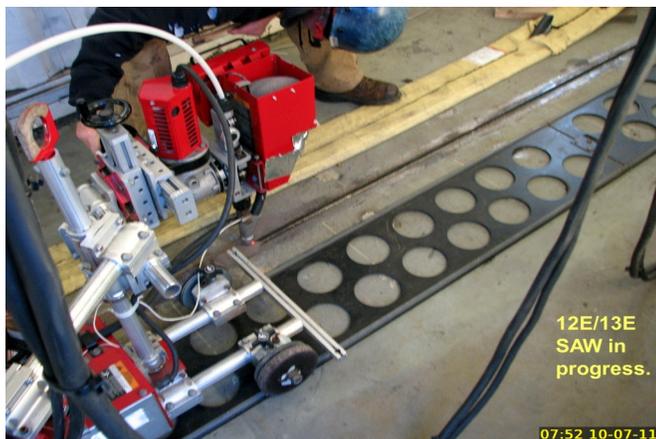
The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

1) OBG field splice welding at 12E/13E

1) The QAI observed ABF personnel making the field splice welds across the A deck, welds A1, A2, A3, A4 and A5. The QAI noted that 2 different submerged arc welding (SAW) machines are being used by operators Todd Jackson, ID 4639 and James Zhen, ID 6001. The QAI noted that the Quality Control Inspector (QCI) Patrick Swain is monitoring this work. The QAI was informed that welding procedure specification ABF-WPS-D15-4042B-1 is being used for this welding. The QAI randomly measured the preheat, interpass temperature, welding parameters and noted that they appeared to be conforming to the WPS requirements. The QAI noted that this weld is designated as seismic performance critical member (SPCM) and per the contract requirements is to be welded following AWS D1.5 2002 fracture critical requirements. At the beginning of the shift, the QAI was informed that the flux for the SAW has been baked out and was approximately 600°F. The QAI witnessed the welding operators draw the baked flux and load the SAW hoppers. The QAI was also informed that the fit-up and seal welding of the backing bar / weld joint was performed on 10-6-2011. The QAI noted that this welding was in progress at the end of the shift. See the attached photos.

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Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed the general observations and status of work to the QAI Danny Reyes and the QAI Lead Bill Levell. Except as described above, there were no other notable conversations or observations.

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