

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-026524
Date Inspected: 14-Oct-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Job Site

CWI Name:	As noted below.	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 Component	

Summary of Items Observed:

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

12E/13E "C" Plate

In Process Visual Inspection

This QA observed, at random intervals, an ABF/JV qualified welder performing Flux Core Arc Welding w/gas (FCAW-G) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3042A-1. Welding was performed at the 22mm butt weld joint (B-U2a-GF) connecting Lift 12 and Lift 13 "C" side plate. This weld is not a Seismic Performance Critical Member (SPCM) member.

During welding, ABF Quality Control (QC) Pat Swain was noted monitoring the welding parameters. Welding parameters were recorded as:

D2 section - Jimmy Zhang #6001 (A=260, V=24, T=340).

This QA observed, at random intervals, an ABF/JV qualified welder performing Flux Core Arc Welding w/gas (FCAW-G) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3042A-1. Welding was performed at the 22mm butt weld joint (B-U2a-GF) connecting Lift 12 and Lift 13 "C" side plate. This weld is not a Seismic Performance Critical Member (SPCM) member.

During welding, ABF Quality Control (QC) Pat Swain was noted monitoring the welding parameters. Welding

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parameters were recorded as:

D2 section – Jin Pei Wang #7299 (A=280, V=25.3, T=350)

This QA observed, at random intervals, an ABF/JV qualified welder performing Flux Core Arc Welding w/gas (FCAW-G) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3042A-1. Welding was performed at the 22mm butt weld joint (B-U2a-GF) connecting Lift 12 and Lift 13 “C” side plate. This weld is not a Seismic Performance Critical Member (SPCM) member.

During welding, ABF Quality Control (QC) Pat Swain was noted monitoring the welding parameters. Welding parameters were recorded as:

D3 section - Wai Kit Lai #2953 (A=263, V=24.5, T=340)

This QA observed, at random intervals, an ABF/JV qualified welder performing Flux Cored Arc Welding w/ Gas (FCAW-G) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3040A-1. Welding was performed at the 22mm butt weld joint (B-U2a-GF) connecting Lift 12 and Lift 13 “C” side plate. This weld is not a Seismic Performance Critical Member (SPCM) member.

During welding, ABF Quality Control (QC) Pat Swain was noted monitoring the welding parameters. Welding parameters were recorded as:

D3 section – Xiao Jian Wan #9677 (A=279, V=25, T=349)

12E/13E “F” Plate

In Process Visual Inspection

This QA observed, at random intervals, an ABF/JV qualified welder performing Flux Core Arc Welding w/gas (FCAW-G) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3040B-3. Welding was performed at the 22mm butt weld joint (B-U2a-GF) connecting Lift 12 and Lift 13 “F” edge plate. This weld is not a Seismic Performance Critical Member (SPCM) member.

During welding, ABF Quality Control (QC) Fred Vonhoff was noted monitoring the welding parameters. Welding parameters were recorded as:

F section – Jorge Lopez #6149 (A=245, V=24, T=178)

This QA verbally informed QA SPCM Lead, Daniel Reyes, of the issues noted in this report for compliance. For further details of issues of significance see QA SPCM Lead, Daniel Reyes, “Daily Inspection Report” (TL-6031) submitted for this date.

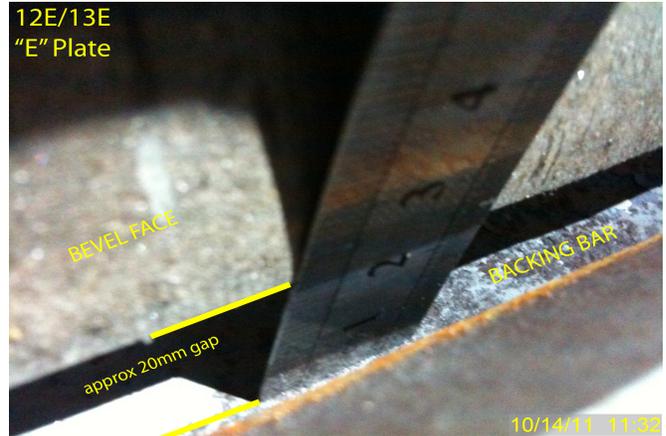
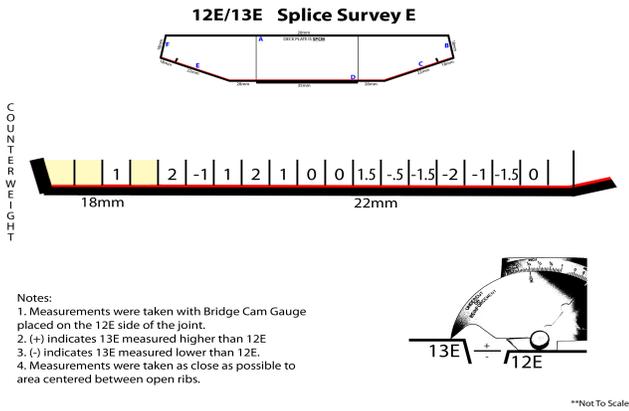
Approximately 11:00 QA observed the joint fit-up for connection 12E/13E “E” side plate. QA noted that the backing bar from approximately (Y=1524mm ~ 3657mm) was not within 2mm of base material. The gap between the backing bar and the base material measured from (15mm ~ 25mm) at various locations throughout aforementioned Y locations.

Please see attached photograph for visual representation.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant 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 SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Clifford, William

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer