

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-026525**Date Inspected:** 15-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:** 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:

C1/C2 section – Wai Kit Lai #2953 (A=240, V=25, T=353).

12E/13E "E" 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 "E" side plate. This weld is not a Seismic Performance Critical Member (SPCM) member.

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

E1 section – Jin Pei Wang #7299 (A=260, V=25, T=250)

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 “E” side 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:

E2 section – Xiao Jian Wan #9677 (A=280, V=25, T=275)

Approximately 7:15 QA observed the joint fit-up for connection 12E/13E “E” side plate. QA noted in “Daily Welding Report (TL-6031)”, dated 10-14-11, 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. This fit-up was observed to have been corrected. Backing bar was found to be within the 2mm gap tolerance before ABF welding personnel started welding operations.

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=244, V=24.2, T=178)

East Line

In Process Visual Inspection

This QA randomly observed ABF/JV qualified welder Salvador Sandoval #2202 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1010-R1. The joint being welded is a 20mm plate insert at the “A” deck to close a man way deck penetration hole. This work was located at 8E-PP70.5-E5 NE (Y=3325~3375) and was performed in the flat position from the top of the “A” deck plate.

During welding, ABF Quality Control (QC) Pat Swain was noted monitoring the welding parameters. Welding parameters were recorded as (A=134).

Ultrasonic Testing

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This QA Inspector performed Ultrasonic Testing (UT) of approximately 50% of the area previously tested by QC Ultrasonic technicians. This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

Locations of welds:

11E-PP101-E4-L#1

11E-PP101-E4-L#2

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.

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

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
