

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-026532**Date Inspected:** 13-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:** Fred Von Hoff**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:

11E-PP100-E3 Lifting Lug Hole (LLH) # 1 and # 2: This QA Inspector observed the following repair (R-1) excavations had been performed; LLH #1 Y-471 – length = 90 mm and depth = 11 mm. LLH # 2 Y-593 – length = 80 mm and depth = 7 mm, Y-100 – length = 120 mm and depth = 11 mm. This QA Inspector was informed by QC Inspector Bernard Docena that he had performed and accepted the visual and Magnetic Particle Testing (MT) on each of the excavations listed above. This QA Inspector performed a random visual verification of the excavations. This QA Inspector was informed by QC Inspector Bernard Docena that ABF welding personnel Fred Kaddu (# 2188) who had performed the excavations had been requested to perform work at another location. This QA Inspector observed the excavations listed above had been covered with tape to help prevent rusting. This QA Inspector did not observe any further work at this location this date.

12E/13E weld joint F: This QA Inspector randomly observed ABF welding personnel Jorge Lopez (#6149) setting up to gain access and start cleaning the weld joint. This QA Inspector observed QC Inspector Fred Von Hoff perform a visual inspection of the fit up at this location. This QA Inspector performed a verification of the fit up and observed the following; Y-0 to 110 the planar offset was from 6 mm (at Y-0) to 2 mm (at Y-110), Y-2095 to

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Y-2315 the planar offset was 2 mm (at Y-2095) to 5 mm (at Y-2315), from Y-1420 to Y-1495 the root opening exceeded the maximum allowed and at the largest area was 17 mm, the backing bar at the bottom 580 mm (Y-1735 to Y-2315) appeared to have a gap ranging from 2 mm (at Y-1735) to 9 mm (at Y-2315). QC Inspector Fred Von Hoff was aware of the issues noted above. This QA Inspector observed that "U bars" had been used as fit up aids on the inside of the OBG section and had been welded on in a transverse direction, see photo below. This QA Inspector provided a complete turnover to QA Inspector Jojo Lizardo regarding these issues at the end of this QA Inspectors shift for further verifications.

This QA Inspector verbally informed QA SPCM Lead Inspector, Daniel Reyes, of the issues noted in this report for compliance therefore for further details of issues of significance see QA SPCM Lead Inspector, Daniel Reyes, Daily Inspection Report (6031) for this date.

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
