

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-026555
Date Inspected: 21-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:	Listed 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:	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) Utility Piping Welding
- 2) OBG cable tray supports

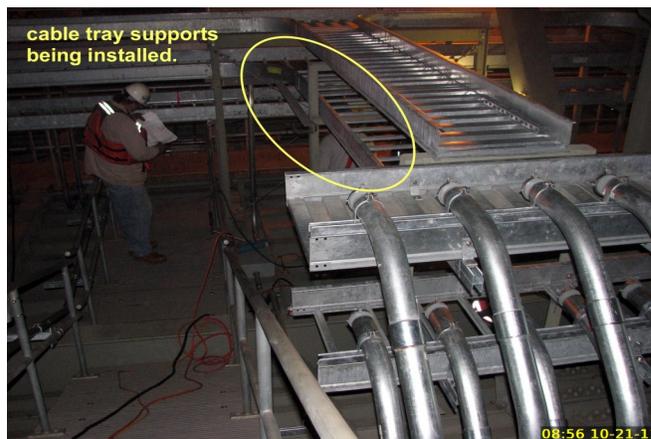
1) The QAI observed ABF / F.W. Spencer personnel fitting and welding utility piping on the E5 line at approximately panel point 50, on the outside of the barrier rails. The QAI met with the Quality Control Inspector (QCI) Steve Jensen and was informed that the installed piping (utility air & utility water) lines will be moved from the location they are being welded. The QAI noted that the welding is being performed by Curtis Jump, ID 7326. The QAI was informed that welding procedure specification (WPS) 1-12-1, is being used for the open root pipe welding. The QAI noted that the WPS lists a 6010 electrode for the root passes and 7018 electrode for the final passes. The QAI noted that the welder had both types of electrodes in his possession. The QCI informed the QAI that the work was acceptable and that the welding was within the parameters of the WPS. The QAI made random observations of the work in progress and noted that it appeared to be conforming to the contract requirements. The QAI was informed that after this section of piping is welded, it will be pulled into place. The QAI was informed that the painting and final bolt up will be done later, as there are branch connections that still need to be installed.

2) The QAI observed ABF personnel installing and fillet welding steel angle members into cable tray supports at Orthotropic Box Girder (OBG) segments 2E (Crossbeam 1) and 5E (Crossbeam 4). The QAI noted that the

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contract requirements for this welding are specified to use American Welding Society (AWS) D1.1, code year 2002. The QAI noted that 2 crews are performing this work. At crossbeam 1 in the East bound OBG, ABF welder Mike Jiminez, ID 4671, and at crossbeam 4 in the East bound OBG, Eric Sparks, ID 3040. The QAI noted that each welder is performing similar tasks at each area including, fitting and welding the cable tray supports at the OBG / Crossbeam transition areas. The QAI observed that the Quality Control Inspector (QCI) Pat Swain is monitoring this welding. The QAI noted that the zinc primer is being ground off of the areas to be welded, the parts are then fit and tack welded with 6mm fillet welds being placed after fit-up has been accepted by the QCI. The QAI made random observations of the work in progress and noted that it appeared to be conforming to the contract requirements. The QAI was informed that after completion of work at each location, a painting crew will re-apply the zinc primer to the areas where welding was performed. The QAI noted that this will happen at a later time. See the attached photos.



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
