

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-026558
Date Inspected: 22-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 13E/14E Fit Up
- 3) Tower Access Platform

1) 2) The QAI observed ABF personnel installing and fillet welding steel angle members into cable tray supports at Orthotropic Box Girder (OBG) segments 2W (Crossbeam 1) and 5W (Crossbeam 4). The QAI noted that the 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 West bound OBG, ABF welder Mike Jiminez, ID 4671, and at crossbeam 4 in the West bound OBG, ABF welder Eric Sparks, ID 3040. The QAI noted that these welders are 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) Steve Jensen is monitoring this welding. The QAI noted that the zinc primer is being / has been 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.

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2) The QAI made observations of the fit-up of OBG 13E/14E field splice. The QAI noted that ABF personnel are welding temporary attachments onto the top of A deck and under the D plates. The QAI noted that this work is being monitored by the QAI Craig Hager. The QAI was asked to assist in verifying the fit up, root gap opening and planar alignment between the OBG segments 13E and 14E. The QAI accompanied the QCI Pat Swain and made observations of the fit-up of plate D in the interior and mid-section of the OBGs. The QAI noted that the root opening measured approximately 10mm with minor variances up to 12mm. The QAI and the QCI noted that there are sections of planar mis-alignment up to 5mm measurable between the interior faces of the OBGs. The QAI was informed that this information will be recorded and the Engineer will be notified of the non-conforming conditions of the fit-up. The QAI noted that the fit-up will be verified on Monday, 10-24-2011, as the field splice is not ready for welding at the end of the shift. See the attached photo.

3) The QAI observed ABF personnel fitting and preparing to weld 2 tower access platform mounting plates onto the South shaft of the Tower structure at the 53 meter elevation. The QAI noted that the originally installed mounts have been removed due to their incorrect placement. The QAI noted that as this work was progressing, additional paint needs to be removed from the parts prior to welding. The QAI noted that the fit of the members has been achieved using cable and winches to align the horizontal surface of the access platform. The QAI noted that the QCI Fred Von Hoff is monitoring this work. The QAI was informed that the fillet welding will be performed by Todd Jackson, ID 4639. The QAI made random observations of the work but did not witness any welding at this location. The QAI was informed at the end of the shift that only minor welding has been performed and the remainder will be done at a later time. See the attached photo.



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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 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
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Reviewed By:	Levell,Bill	QA Reviewer
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