

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-026635**Date Inspected:** 03-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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:

In Process Visual Inspection**12W/13W**

This QA observed, at random intervals, ABF/JV qualified welder Fred Kaddu #2188 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E9018-MH4-R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1012-3. The joint being welded was a 35mm thick internal longitudinal stiffener butt splice designated as L#4 on the underside of "A" deck plate, 12W/13W segment splice location.

During welding, ABF Quality Control (QC) John Pagliano was noted monitoring the welding parameters. Welding parameters were recorded as (A=136).

12W/13W "D" Plate

This QA observed, at random intervals, an ABF/JV qualified welder, Rory Hogan #3186, 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 28/35mm butt weld joint (B-U2-S) connecting Lift 12 and Lift 13 "D" bottom plates. This weld is not a Seismic Performance Critical Member (SPCM) member.

During welding, ABF Quality Control (QC) Bernard Docena was noted monitoring the welding parameters. Welding parameters were recorded as (A=260, V=23.5, T=360).

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA observed, at random intervals, an ABF/JV qualified welder, Jeremy Dolman #5042, 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 28/35mm butt weld joint (B-U2-S) connecting Lift 12 and Lift 13 “D” bottom plates. This weld is not a Seismic Performance Critical Member (SPCM) member.

During welding, ABF Quality Control (QC) Bernard Docena was noted monitoring the welding parameters. Welding parameters were recorded as (A=262, V=23.3, T=363).

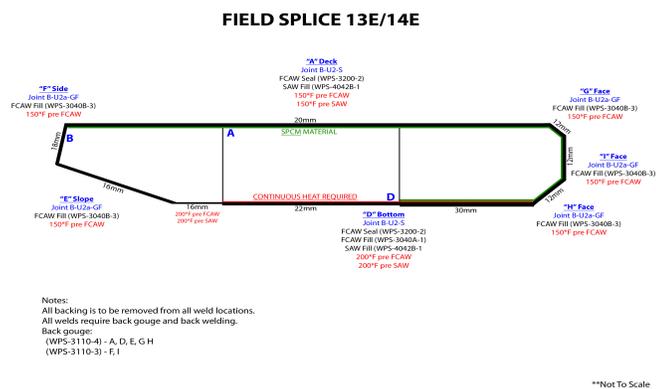
12W/13W “F” Plate

This QA observed QC Jesse Cayabyab performing Ultrasonic Testing (UT) of the completed weld at 12W/13W plate splice location. Testing was halted due to inclement weather and has not been completed at this time.

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.

This QA devoted a portion of the work day to developing field and final spreadsheets for the recording and tracking of planar offsets at field plate splices. These spreadsheets were submitted to QA Lead Daniel Reyes on this date for review and implementation.

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Clifford, William

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer