

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-026682**Date Inspected:** 10-Nov-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:

13W/14W "D" Plate

This QA observed, at random intervals, an ABF/JV qualified welder, Richard Garcia #5892, performing Flux Cored Arc Welding (FCAW) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3200-2. Welding was performed at the 30/35mm butt weld joint (B-U2-S) connecting Lift 13 and Lift 14 "D" bottom plates. Welding operations were performed from approximately Y=6500mm~8500mm. This weld is 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 (A=255, V=25.3, T=335).

This QA observed, at random intervals, an ABF/JV qualified welder, Jeremy Dolman #5042, performing Flux Cored Arc Welding (FCAW) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3200-2. Welding was performed at the 30/35mm butt weld joint (B-U2-S) connecting Lift 13 and Lift 14 "D" bottom plates. Welding operations were performed from approximately Y=2500mm~4600mm. This weld is 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 (A=263, V=25.5, T=351).

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Note:

Approximately 8:35 this QA randomly observed the preheat temperature of the weld joint at 13W/14W “D” plate to be 188 degrees Fahrenheit (188 *F). The weld joint was being brought to the mandated preheat temperature and welding operations had not been started at that time. The weld joint was brought to the proper preheat temperature (200 *F) before welding procedures began.

13W/14W “T” Plate

Approximately 9:00 this QA randomly observed ABF/JV personnel performing joint fit-up operations for joint 13W/14W “T” plate. Initial preliminary QC measurements found the planar off-set to be in excess of acceptable tolerances. ABF/JV personnel are currently bolting this connection in an attempt to pull the plate offset into compliance. This work is in process and no final measurements have been recorded at this time.

Approximately 13:15 this QA randomly observed ABF/JV personnel adding Submerged Arc Welding (SAW) flux to the hopper located at the 12W/13W weld joint location. This QA randomly observed the temperature gauge attached to this flux hopper indicating approximately (250*F). See attached photograph for visual representation.

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.

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Inspected By:	Clifford, William	Quality Assurance Inspector
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Reviewed By:	Levell, Bill	QA Reviewer
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