

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-026805**Date Inspected:** 01-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See 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**Summary of Items Observed:**

At the start of the shift this Quality Assurance Lead Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Douglas Frey-OBG W14 (Welding of Ventilation and Lifting Lug Holes).

Scott Croft-OBG W13/W14 (Welding of Bottom Plate "D1"), OBG Field Splice E13/E14 (Observation of QC/UT of Bottom Plate Splice "D1"), OBG W14 (Observed Welding of Cable Pulley Components to "A" Deck) and Bike Path Panels (Assisted SMR Nicolai Hvass and Robert Mertz Developing Testing Method).

Craig Hager-FW Spencer at the South Tower Shaft (No Show/No Welding), West Jacking Saddle Frame (QA observation of QC/NDE). For additional information see Summary of Conversation.

Art Peterson-Continued observing the modification work of Bike Path Traveler and Belvederes of the following Contract Change Orders: CCO:178.

Joselito Lizardo-OBG Field Splice E13/E14 (QA Observation of MPT and Welding of A2.2), OBG E14 (QA Observation of MPT and Welding of Lifting Lug Holes).

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Douglas Frey, Art Peterson, Craig Hager, Scott Croft and Joselito Lizardo monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and no issues were noted on this date.

This QA Inspector continued the daily review of field inspection reports and update of the field document control tracking records regarding the Orthotropic Box Girders (OBG, Longitudinal and Transverse "A" Deck Stiffeners, Deck Access Holes and the Tower Shear plates).

Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

West Jacking Saddle Frame Issue

The QAI, Craig Hager, informed this QALI regarding the excavation of the linear indication located on the upper northside PJP of the West Jacking Saddle Frame. It was noted at the conclusion of the excavation and confirmed by Magnetic Particle Testing performed by the QC Inspector, Patrick Swain, that effective throat of the PJP was decreasing rather than increasing. Note: the shop drawings indicate a PJP groove weld with an effective throat of 14mm and the as welded PJP appeared to measure at 6 to 7mm. At this time Caltrans Structures personnel informed the ABF Supervisor Scott Smith and the QC Inspector Mr. Swain that the work be terminated and the issue would be addressed as soon as possible.

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:	Reyes,Danny	Quality Assurance Inspector
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Reviewed By:	Levell,Bill	QA Reviewer
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