

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-027024**Date Inspected:** 12-Jan-2012**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:** 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:** SAS**Summary of Items Observed:**

Skyway Portion of the SFOBB: Bike Path at Expansion Joint Hinge "B"

CCO: 193 - Description: Modify the existing bike path panels at the expansion joints of the Skyway portion of the SFOBB East Span Seismic Safety Program.

The Caltrans Quality Assurance (QA) Inspector Rick Bettencourt randomly observed the American Bridge/Fluor (ABF) welder Jason Collins performing the root, fill and cover pass weld operation on a partial-joint-penetration (PJP) groove weld per the Flux Cored Arc Welding (FCAW-S) self-shielding process in the (2G) horizontal position connecting the new end plate to the existing bottom soffit plate of the bike path panel at expansion joint Hinge "B" as per ABF Submittal no. 2549R1 of Contract Change Order (CCO) 193. The QA Inspector observed Quality Control (QC) Inspector Bernard Docena verified the minimum required preheat of 150 degrees F prior to the start of the root, fill, and cover pass. The QA Inspector randomly observed the QC Inspector verify the FCAW welding parameters (Amps, Volts and Travel Speed) were in accordance with ABF-WPS-D15-2160-1 using the E71T8 NR232 electrode - (.072") diameter electrode. The QA Inspector randomly observed and noted the FCAW parameters were 246 Amps, 22 Volts and a travel speed of 80mm/min. It was noted by the QA Inspector the above identified welding parameters did appear to comply with the above noted WPS.

The root, fill, and cover pass weld operation observed on this date appeared to be in general compliance with the aforementioned weld procedure specification and the work observed appeared to be in general compliance with contract change order (CCO) 193.

Note: At the Expansion Joint Hinge "B", this QA Inspector previously observed ABF personnel cut back the Top

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skin plate, Side skin plate and the Diaphragm plate of the bike path box panel using an oxyacetylene cutting torch on a track system and also observed ABF personnel use a mechanical cutting blade on the existing Bottom skin soffit plate of the bike path box panel. The cut back distance was measured at 306 mm as per Contract plan sheet number 1164S8 and ABF Submittal number 2549R1. The new end plate weld operation connecting to the bike path box panel is being performed on this date as mentioned above. It was noted by the QA Inspector the welding and grinding was completed for the end plate in weld detail F1.



Summary of Conversations:

The QC Inspector Bernard Docena informed the QA Inspector the end plate welding of the bike path was completed on this date. The QC Inspector went on to inform the QA Inspector Friday ABF will begin working on the bottom of the bike path where additional welding will be performed.

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:	Bettencourt,Rick	Quality Assurance Inspector
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Reviewed By:	Levell,Bill	QA Reviewer
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