

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-027055
Date Inspected: 17-Jan-2012

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

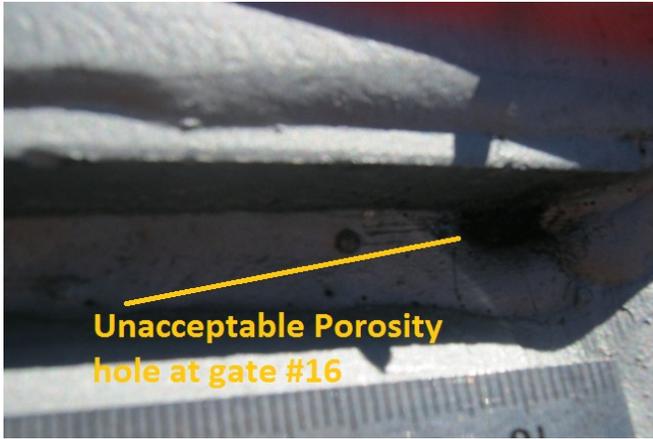
CWI Name:	See below	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	Emergency Gates	

Summary of Items Observed:

The Caltrans Quality Assurance (QA) Inspector Rick Bettencourt performed a visual inspection of the bike path emergency gates associated with CCO 179. The QA Inspector noted 28 gates arrived on site from an outside vendor. Upon arrival the American Bridge/Fluor (ABF) Quality Control (QC) personnel performed visual testing of the material. It was noted by the QA Inspector the material arrived on site without prior inspection from QC at the fabrication facility. The ABF QC personnel identified 12 of the 28 emergency gates with unacceptable groove welds and fillets welds. The QA Task Lead Bill Levell instructed the QA Inspector to perform visual testing of the gates after ABF QC had completed their inspection. The QA Inspector located several defects including unacceptable porosity and a single linear indication initiated from a piping porosity hole. The QA Inspector Rick Bettencourt and the QA Inspector Robert Mertz observed the above identified defects and concurred with them. The QA Inspector noted the SE QC Inspector Bill Norris and ABF Welding Quality Control Manager (WQCM) Jim Bowers observed the additional defects located by the QA Inspectors. The WQCM and QC Inspector concurred with the QA Inspector and agreed to reject the two additional gates along with the previous rejected 12 and increase the total of rejected emergency gates to 14. The QA Inspector noted the QC Inspector Bill Norris indicated the #14 and #16 emergency gates with red tape and added them to the stack of rejected material to be sent back to the vendor.

WELDING INSPECTION REPORT

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Summary of Conversations:

The QC Inspector Bill Norris and ABF WQCM Jim Bowers informed the QA Inspector that they did agree with the rejected emergency gates and they would add them to the stack of rejected material. Mr. Bowers went on to inform the QA Inspector the material will be sent back to the fabricator for repairs.

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
Reviewed By:	Levell,Bill	QA Reviewer
