

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 #: 1x.28**WELDING INSPECTION REPORT**

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027408
Date Inspected: 03-Apr-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: On Site

CWI Name:	Sal Marino	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 Components	

Summary of Items Observed:

This Quality Assurance (QA) Inspector, Art Peterson arrived on site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel monitor the welding operations performed by American Bridge Fluor (ABF) welding personnel. The following observations on this date were:

CB16:

This QA Inspector observed ABF welder Jeremy Dolman (Welder ID 5042) performing root, fill, and cover pass weld operation on the complete-joint penetration (CJP) butt-joint groove weld connecting the handrails to make continuous in Crossbeam (CB) 18 for its full length per the Flux Cored Arc Welding (FCAW) process in the (1G) and (3G) flat and vertical positions.

This QA Inspector observed QC Inspector Sal Marino verify prior to the start of the root, fill and cover pass weld operation, that the minimum preheat temperature as per the approved WPS was established and afterwards; verified that the welding parameters (Amps, Volts and Travel Speed) were in accordance with WPS D11-F2201 Revision 0 using NR 211 (.035") diameter electrode.

This QA Inspector observed that the root, fill and cover pass weld operation on the handrail butt-joint groove welds were still in-process at the end of this QA Inspectors' shift.

This Caltrans OSM Quality Assurance (QA) Inspector also performed the review and inspection of a punchlist item from outstanding work not performed by ABF's fabricator Zhenhua Port Machinery Company (ZPMC) in

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

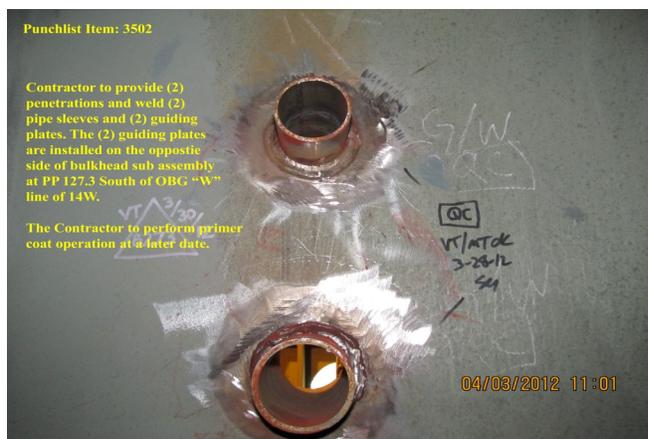
Shanghai, China and the work to be performed and verified on site regarding OBG Segment 14 (West).

The following punch list item reviewed on this date was:

Punch List Item No. 3502: Lift 14 West: Segment 14W: Category: Outstanding: Location: PP127.3 South of "W" Line

Description: The Contractor to provide two (2) penetrations, weld two (2) pipe sleeves and two (2) guiding plates
Reference: Shop drawing SA 3410 and X4950.

Status: Welding: complete / Paint: outstanding - Comment: The Contractor provided the two (2) penetrations and welded two (2) pipe sleeves with the two (2) guiding plates for MEP. The Contractor has yet to perform the primer coat painting operation at the aforementioned locations.



Summary of Conversations:

Only general conversations with ASMR Pari Aghili regarding the current status of the punchlist item above and the recommended disposition of the outstanding item for discussion with SMR Bahjat Dagher and Task Leader Bill Levell.

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, 510-285-5910, who represents the Office of Structural Materials for your project.

Inspected By: Peterson, Art

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer
