

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-027479**Date Inspected:** 19-Apr-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** Steve Jensen**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 project**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above.

This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and /or monitor American Bridge/Fluor (ABF) welding operations. This Quality Assurance (QA) Inspector, Craig Hager observed the following.

Orthotropic Box Girder (OBG) Deck Access Hole (DAH): This QA Inspector observed work and/or performed QA verifications at the locations noted below.

6E-PP46.5-E5: This QA Inspector randomly observed ABF welding personnel Mike Jiminez (#4671) setting up equipment to start back gouging from the bottom of the top deck. Later this shift this QA Inspector randomly observed ABF welding personnel Mike Jiminez (#4671) using the carbon arc process to back gouge the top deck access hole weld joint. This QA Inspector observed the back gouging was not completed this date and that welding was not performed at this location this date.

8W-PP61.5-W2: This QA Inspector observed ABF personnel Jose Torres using a grinder with a sandpaper flapper wheel to grind the face of the transverse and longitudinal stiffener welds flush. Toward the end of the shift this QA Inspector observed transverse stiffener and East longitudinal stiffener had been ground flush. This QA Inspector observed the weld access holes (rat holes) at the tops of the welds had not been ground.

8W-PP70.5-W2: This QA Inspector observed ABF welding personnel Eddie Brown (#9331) had excavated 4 areas on the deck access hole weld from the bottom side for repair. This QA Inspector observed the repair areas

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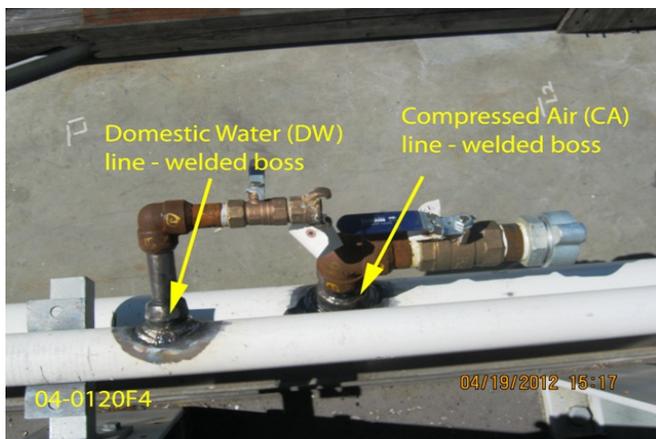
appeared to range in length from 50 mm to 125 mm and from 4 mm deep to 10 mm, approximately. This QA Inspector randomly observed QC Inspector Salvador Merino perform a visual and Magnetic Particle Testing (MT) on each of the excavations prior to welding. This QA Inspector performed a visual verification and the excavations appeared to comply with the contract requirements.

This QA Inspector performed Ultrasonic Testing (UT) verification on the following access hole stiffener welds: 5W-PP36.5-W2-LS-E, 5W-PP36.5-W2-LS-W, 5W-PP36.5-W2-TS, 6W-PP46.5-W2-TS. The UT verifications performed appeared to comply with the contract requirements, see Ultrasonic Test Report (TI-6027) this date for further details.

F.W. Spencer: This QA Inspector randomly observed F.W. Spencer welding personnel Damien Llanos using the Shielded Metal Arc Welding (SMAW) process to weld piping bosses to the main branch of piping. This QA Inspector observed QC Inspector Steve Jensen verify the following welding parameters; 95 amperes for the 1/8-inch diameter, E6010 electrode used for the root pass and 93 amperes for the 3/32-inch diameter, E7018 electrode used for the fill and cover passes. The welding observed appeared to comply with WPS 1-12-1 Rev-2, being used by QC. See photo below of weld in progress. This QA Inspector randomly observed the fit up and/or performed the final visual verification on the following welds: 1/CA2/94/NE, 1/DW1/94/NE, 1/CA2/100/NE. This QA Inspector observed the fit up on 1/DW/100/NE, but observed welding was not completed this date.

Summary of Conversations:

This QA Inspector had general conversations with American Bridge/Fluor (ABF) personnel, QC personnel and Caltrans personnel during the shift. Except as described above there were no notable 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 Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
