

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-027481**Date Inspected:** 17-Apr-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Pier 7 Job Site**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:** S.A.S. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) Deck Access Hole (DAH) welding, East span
- 2) F.W. Spencer - Utility pipe welding
- 3) Fastener sampling for verification testing

1) The QAI observed an ABF welder making vertical (3G) complete joint penetration (CJP) welds at the transverse stiffener under the DAH at panel point (PP) 46.5 E2. The QAI noted that ABF welder Todd Jackson, ID 4639, is welding the stiffener splice. The QAI noted that the Quality Control Inspector (QCI) Steve Jensen is monitoring this welding. The QAI noted that this weld is being back welded and was completed during this shift. The QAI made random observations of the welding in progress and verified that the preheat temperature, interpass temperature and Shielded Metal Arc Welding (SMAW) welding parameters were conforming to the welding procedure specification (WPS) ABF-WPS-D15-1010-1. The QAI was informed that the weld tabs and grinding needed to be performed and the weld will not be ready for final inspections.

2) The QAI observed F.W. Spencer personnel installing and making CJP welds at PP 107 along the outside of the barrier rails along line E2. The QAI noted that welder Damien Llanos, ID 6845, is welding with E6010 and E7018 SMAW electrodes to make the 4" compressed air pipe welds. The QAI noted that the QCI Steve Jensen is monitoring this welding. The QAI noted that as the pipe was fit up, the root pass is made with E6010 and the

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remainder is welded using E7018 with WPS 1-12-1, is being used for the open root CJP pipe welding. The QAI noted that the (2) pipe splice welds were completed and visually inspected by the QCI. The QCI informed the QAI that the weld was acceptable. The QAI examined the weld and it appeared to be conforming to the contract requirements. See the attached photo

3) The QAI was requested to sample fastener assemblies that have been delivered to the pier 7 staging area. The QAI was provided with a representative sample of the fasteners and the supporting documentation for the fasteners. The QAI noted that these fasteners are intended for use with Contract Change Order 204. The QAI completed a TL-102 sampling form with lot number B212-041-12. The QAI noted that these fasteners will be field released upon acceptable verification testing. See the attached photo.



Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed the general observations and status of work and fastener sampling to the QAI Lead Bill Levell and the QAI Danny Reyes. The QAI noted that the fasteners will be delivered to Translab at a later time. Except as described above, there were no other notable conversations or observations.

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:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
