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 #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

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

Report No: WIR-027563
Date Inspected: 08-May-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: 1730
Location: Jobsite

CWI Name: Steve Jensen

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: As noted below.

Summary of Items Observed:

The Caltrans Quality Assurance Inspector (QAI) David R Gray was at the American Bridge Fluor (ABF) job site between times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

At Tower Base 13 meter outer East external diaphragm, QAI randomly observed ABF/JV qualified welder James Zhen perform Partial Joint Penetration (PJP) T-joint welding fill pass on shear plate to diaphragm plate weld joint #W102. The welder was observed welding in the 2G (horizontal) position utilizing a dual shield Flux Cored Arc Welding (FCAW-G) with E71T-1M, 1/16” diameter wire electrode. Quality Control Inspector (QCI) Inspector Fred Von Hoff was observed monitoring the welding parameters for compliance to approved Welding Procedure Specification (WPS) ABF-WPS-D15-3160-1. The welder was using a track mounted welder holder assembly that was remotely controlled. The QAI noted the preheat application had obtained 325 degrees Fahrenheit at 1000 hours when the QAI was relieved by QAI Joselito Lizardo.

The QAI witnessed work in progress related to Contract Change Order (CCO) 179. The QAI observed ABF welder Jason Collins ID# 8128 fillet welding in the 2F and 4F positions with FCAW utilizing E71T-11 wire electrode. Bikepath Divider Rail Conduit Routing 16mm pipe sleeves were "Seal Welded" (reference note 4 of Contract Change Order No. 179 Sheet 5 of 7) to the top and bottom plates at dividers 140, 141 and 142. QCI Steve Jensen was observed measuring welding parameters for compliance to ABF-WPS-D11-F2201. Holes for the 16mm Pipe Sleeve were observed being drilled from panel 145 to approximately 155. The QA Inspector made subsequent observations to the end of the work shift (1430 hours) to monitor quality and noted that the work appears to be in general accordance with the project plans and specifications.

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At OBG top deck plate 13W-W2.1 @ location, QAI randomly observed ABF certified welder Steve Davis ID# 7889 continuing to perform root and fill passes, 1G (flat position) (SMAW) on the Seismic Performance Critical Member (SPCM) CJP splice butt joint. At OBG top deck plate 13W-W2.8, QAI randomly observed ABF certified welder Khit Lounezhaney ID# 4985 and Salvador Sandoval ID# 2202 continuing to perform 1G (flat position) (SMAW) on (SPCM) CJP splice butt joint. At OBG top deck plate 13W-PP 122.2, QAI randomly observed ABF certified welder Khit Lounezhaney (ID# 4985) start root pass welding 1G (flat position) (SMAW) on (SPCM) CJP splice butt joint.The welders were noted welding 1G flat position using 3.2mm E7018-H4R electrodes with an average of 130amps. This welding was in progress for the duration of the shift. QC Inspector Salvador Merino was observed monitoring the welding parameters for compliance to ABF-WPS-D1.5-1040C-CU Revision 0 and measuring pre-heat and inter-pass temperatures between passes. During subsequent observations it was noted that the welder was using a power disc grinder at weld starts and stops as needed and was cleaning between weld passes with power wire wheel brushes and chipping hammer. The QA Inspector made subsequent observations to the end of the work shift to monitor quality and noted that the work appears to be in general accordance with the project plans and specifications.

Summary of Conversations:

No significant conversations were held on this date.

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:	Gray,David	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer