

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-027579**Date Inspected:** 08-May-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:** William Sherwood**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 Closure Plates, East span - SAW
- 2) Deck Closure Plates, East span - SMAW
- 3) Document Reviews at Pier 7

1) The QAI observed ABF personnel making flat (1G) complete joint penetration (CJP) welds at on the East bound Deck Closure Plates. The QAI noted that Kenneth Chappell, ID 3833, is operating the Submerged Arc Welding (SAW) machine at panel point (PP) 120.6. The QAI noted that the Quality Control Inspector (QCI) William Sherwood is monitoring this welding. The QAI made random observations of the welding in progress and verified that the preheat temperature, interpass temperature and welding parameters were conforming to the welding procedure specification (WPS) ABF-WPS-D15-4043-1. The QAI noted that upon completion of this weld, the welding machine was moved to weld E2.3 and welding was in progress. The QAI noted that these welds will be back gouged and back welded at a later time.

2) The QAI observed ABF personnel making 1G CJP welds on the East bound Deck Closure Plates. The QAI observed 4 welders at the following locations: Jacob Stafford, ID 8020 at E2.3, Salvador Sandoval, ID 2202 at A2.1/A1; Eddie Brown, ID 9331 at A0/A1; Mike Jiminez, ID 4671 at PP121.2/E2.5. The QAI noted that all welders are using shielded metal arc welding (SMAW) with E7018 electrodes. The QAI observed that root and fill passes

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

are being made against the copper backing that is installed under the deck plates. The QAI noted that the QCI William Sherwood is monitoring all of this welding. The QAI was informed that ABF-WPS-D15-1040-1 is being used at all of these locations. The QAI made random observations of the welding at these locations and noted that the welding parameters and preheat temperature appeared to be conforming with the WPS. See the attached photos.

3) The QAI reviewed contract documents at pier 7. The QAI used approved weekly welding report submittals and cross referenced the welding and inspection status as reported with QA records to identify the overall weld status. The QAI continued reviewing welding report submittal packages 1536 revisions 114 and 115, for conformance with the contract requirements. These reviews were in progress until the end of the shift.



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 to the QAI Lead Bill Levell and the QAI Danny Reyes. At noon, the QAI was relieved of welding monitoring to continue the submittal reviews. 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
