

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-027590**Date Inspected:** 11-May-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:	As noted below		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	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:** SAS Components**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QAI) David 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:

The QAI observed the following ABF welders noted below performing 1G (flat position) Shielded Metal Arc Welding (SMAW) on the Seismic Performance Critical Member (SPCM) Complete Joint Penetration (CJP) splice butt joint using 3.2mm E7018-H4R electrodes with an average of 130amps. This welding was in progress for the duration of the shift. The welding consists of root and intermediate weld passes. At the 13W-W2.3 and 13W-W2.4 locations Jacob Stafford ID# 8020, 13W-W2.5 Mike Jimenez, 13W-PP122.2, 13w-W2.5 and 13W-W2.2 Khit Lounechaney ID# 4985, PP122.3 Edward Brown ID# 9331. QCI Inspectors William Sherwood and Salvador Merino were observed monitoring the welding parameters for compliance to ABF-WPS-D1.5-1040C-CU Revision 0 and measuring inter-pass temperatures between passes. During subsequent observations it was noted that the welders were using a power disc grinder at weld starts and stops as needed and were cleaning between weld passes with power wire wheel brushes. QCI William Sherwood was observed checking fit-up and offsets of splice members. The QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general accordance with the project plans and specifications.

Summary of Conversations:

Except as noted above 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

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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
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Reviewed By:	Levell,Bill	QA Reviewer
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