

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-027634**Date Inspected:** 18-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:	N/A	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 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 noted work in progress related to Request for Information (RFI) 001190R00. The QAI observed ABF personnel using power grinding equipment on eastbound lane South Cable Bands adding chamfers in accordance with RFI attachment 1 of 1. The QAI noted that the attachment shows both the male and female Cable Band halves being chamfered. The QAI had conversations with ABF supervisory personnel (Levi Gatsos and Scott Smith). The ABF supervisors are directing to have only the male half chamfered. The QAI visually inspected areas that were ground and no casting discontinuities were noted. The following Cable Band numbers were observed and spot measurements on work completed appear to be in accordance with the RFI: EPP110, EPP108, EPP70, EPP80, EPP78, EPP76, EPP74, EPP72, EPP118, EPP56, EPP58, EPP60, EPP62, EPP68, EPP64, EPP82, EPP84, EPP18, EPP20, EPP22 and EPP66. 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.

The QAI was directed by the lead QAI (Daniel Reyes) to observe work in progress where Cable Bands were being milled at the mating faces. The QAI did not have a RFI or Contract Change Order on hand for verification of workmanship that follows. The QAI observed ABF personnel using power grinding equipment on westbound lane North Cable Bands removing material from the female Cable Band half mating face, top and bottom. Female halves numbered WPP94 and WPP 100 were in progress to have 15mm (+10, -0mm tolerance) removed as detailed on "Red Line" changes to Goodwin Steel Castings Drawing No. 554Q-B2-1-F. WPP94 and WPP100

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

pieces were removed from the work area before completion. The QAI observed the male Cable Band half shear key ends removed approximately 15mm by a power grinder with a cut off wheel in accordance with "Red Line" changes to Goodwin Steel Castings Drawing No. 554Q-B2-1-M. The QAI noted that shear key detail "JOINT AT KEY", from Sheet titled "CABLE BAND DETAILS NO. 3" denotes a chamfer face of 50mm, the removal of the key ends reduce that dimension by approximately 15mm (30-35mm average noted).



Summary of Conversations:

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 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
