

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-027678**Date Inspected:** 25-May-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite

CWI Name:	Steven Jensen		
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:** 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:

Skyway Hinge A

The QAI witnessed work in progress related to Contract Change Order (CCO) 193. The QAI observed ABF welder Jason Collins ID# 8128 welding in the 2G, 2F, 3F, and 4F positions with Shielded Metal Arc Welding (SMAW) utilizing 3.2mm E7018-H4R electrode. The QAI checked ampereage (125 DC Amps) and verified that the electrodes were obtained from a baking oven at the correct temperature and within acceptable exposure limits. Quality Control Inspector (QCI) Steven Jensen was observed monitoring the welding parameters for compliance to ABF-WPS-D1.5-1200A (Fillets) and ABF-WPS-D1.5-11160 (Partial Joint Penetration [PJP]). 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.

In process welding consisted of:

Fillet and PJP welding of angle (Piece# M1) to flat bar (Piece# S1).

Fillet welding of flat bar to existing WT.

Fillet welding of Stiffener Plates (2, Piece# Q1).

The QAI noted that the workmanship noted above appeared to be in conformance with "Red Line" changes to ABF Sheet ABN-406 6 of 6.

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The QAI randomly observed ABF certified welder Mike Jimenez (ID# 4671) at Panel 13W Complete Joint Penetration (CJP) Splice to 14W along A-0 (Interior). The QAI noted preheat maintained with Pro-heat 35 thermal blankets over the welds to 110°C (225°F). The welder was observed depositing weld metal cover passes by the SMAW process in the 4G position with 3.2mm E7018-H4R electrodes. 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. The QAI measured amperage at approximately 125 DC Amps. Welding parameters appear to conform to WPS ABF-WPS-D1.5-1040C-CU Revision 0. QCI William Sherwood was observed monitoring the welding parameters and measuring inter-pass temperatures between passes. The QAI noted that the workmanship herein appears to be in 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 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