

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027701**Date Inspected:** 31-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 Manufacturing**Location:** Reedsport, OR**CWI Name:** James Vanek**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:** As Noted Below**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QAI) David Gray was at the offsite fabrication facility of American Bridge Manufacturing (ABM) 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 witnessed work in progress related to Contract Change Order (CCO) 189.

The QAI observed ABM personnel threading a 16mm hole on Tube Steel Uprights at drilled holes for electrical conduit fitting (Reference approved shop drawing Sheet 900SR6, Railing Detail No.3A, Section J-J for Bike path Divider Rails. The QAI noted there are approximately 50 pieces in process and appear to be in accordance with approved shop drawings.

The QAI observed ABM welder Tom Daily ID# 3 welding in the 2F position with Flux Cored Arc Welding with 100% CO2 Gas Shielding (FCAW-GS) utilizing 1.4mm E71T-1C wire electrode. The QAI noted that the light fixture pipe assembly was being welded to the Tube Steel Uprights at drilled holes (Reference approved shop drawing Sheet 899R3, Railing Detail No.2, Detail U and 900R6, Railing Detail No.3, Detail F) for Bike path Divider Rails at Expansion Joints. The QAI checked welding parameters (237 DC Amps and 28.6 DC Volts) and appear to be in compliance with Welding Procedure Specifications (WPS) ABM-SAS-06. Quality Control Inspector (QCI) James Vanek was observed monitoring the welding parameters. During subsequent observations it was noted that the welder was using a power die grinder to profile the weld at weld to a smooth finish, and was cleaning between weld passes with power wire wheel brushes. Welding was in process to the end of the shift. The QAI noted that the workmanship herein appears to be in accordance with the project plans and specifications.

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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:	Foerder,Mike	QA Reviewer
