

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 #: 99.28**WELDING INSPECTION REPORT**

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027825
Date Inspected: 13-Jun-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge Manufacturing

OSM Arrival Time: 600
OSM Departure Time: 1630
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 (CCO) 230:

The QAI observed work by ABM personnel being performed preparing Suspender Brackets 108W, 108E, 110W and 110E for additional fillet (seal) welds on added stiffeners 1 and 2 (reference sheet X451-12B) in accordance with Request For Information (RFI) ABF-RFI-002872R00 "Option No. 2". Work noted was done to enlarge the clipped section of the added stiffeners at the Suspender Bracket web to flange joint, top and bottom. The QAI noted that the progression of work was: 1) enlarging the clipped section (weld access hole) by means of Carbon Arc Gouging by ABM welder Brian Moore (ID# B) and 2) use of power die grinders to achieve acceptable finish and radius in accordance with AWS D1.5 section 3.2.5. The QAI noted Quality Control Inspector James Vanek periodically observing operations above. Workmanship appears to be in conformance with plans and specifications.

Cable System Split Collars (CCO) 223:

The QAI was in progress through the shift performing Magnetic Particle Inspections (MT) on machined surfaces of Split Collars as required in Special Provisions, Section 10-1.60 in accordance with ASTM Method E-709 and the acceptance criteria of E-125. No relevant indications noted to date.

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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
Reviewed By: Foerder,Mike

Quality Assurance Inspector
QA Reviewer
