

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-027826**Date Inspected:** 14-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**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 (CCO) 233:

The Quality Control Manager (QCM) David Speakman requested the QAI observe material stock intended for use as Standard Base Plates for Bike Path Divider Rails (reference sheet FAB 0706-04, BILL OF MATERIAL, and General Notes). Material is: 1) 0.625" (16mm) heat number 812T43800, A572 GR-50 Type 2 and 2) 0.875" (22mm) heat number 2A323 ASTM A709 GR-50, Type 2. The QAI recorded the heat number and received Certified Mill Test Reports. The material appears to comply with approved plans and specifications and an OK to Cut issued. Base Plates cut from the material: 130ea part number P-3 0.625" (16mm), 30ea part number BKX12C 0.875" (22mm). ABM personnel are in process grinding burrs and cut edges.

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

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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.

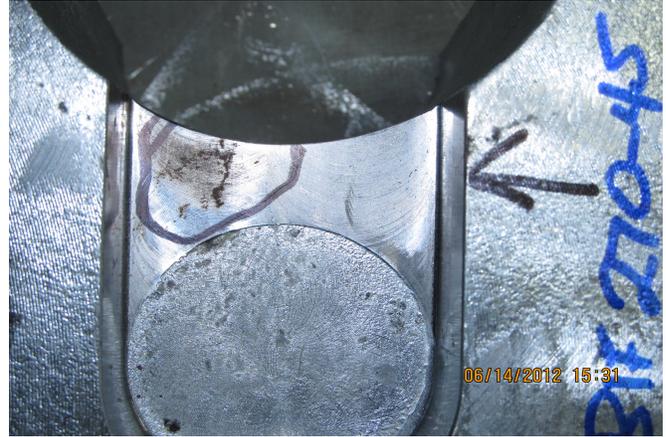
Cable System Split Collars (CCO) 223:

The QAI observed excavation procedures on Split Collars cast identification numbers BIR-036-06, BIF-401-67 and BIF-270-45 noted with casting discontinuities exposed on the machined surfaces after slotting that require repair in accordance with Special Provisions, Section 10-1.60. The QAI noted that ABM personnel excavated to a maximum of a 13mm depth with the following results: BIR-036-06 and BIF-401-67 had repairable discontinuities beyond excavated depth. BIF-270-45 was excavated to sound metal within the 13mm depth.



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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
