

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-027832**Date Inspected:** 05-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**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) 230:

The QAI observed ABM welder Brian Moore ID# B welding in the 2F position with Flux Cored Arc Welding with 100% CO2 Gas Shielding (FCAW-G) utilizing 1.4mm E71T-1C wire electrode. The QAI noted that Suspender Brackets 108W, 108E, 110W and 110E welding was halted. The Quality Control Manager (QCM) David Speakman has indicated to the QAI that he is initiating a Request for Information (RFI) in regards to wrapping the fillet weld at the stiffeners end near the web. The QAI noted that the distance between the two obstructs the additional weld (wrapping) the by the existing weld (Web to Flange) (reference ABF drawing X451-12A, X451-12B and RFI ABM-829210-2). During welding the Quality Control Inspector (QCI) James Vanek was observed monitoring the welding parameters for compliance to WPS ABM-SAS-06. The QAI observed that the welds were blended by power disc and die grinder to fillet welds previously deposited. Workmanship appears to be in conformance with plans and specifications.

The QCM requested the QAI to review documents and product packaging for 8ea sets of paint samples to be sent to the Sacramento Materials Engineering and Testing Services (METS) and issue TL-0101(s). The QAI noted a Certificate of Analysis(s) from International (paint manufacturer), A Certificate of Compliance (ABM) and Shipper(s) for the following:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Interzinc 22HS: Part A, Batch Numbers NB5541UH and NE8438UH. Part B, Batch Numbers ND4182YX, ND4181YX and ND4179YX.

Interzinc 52: Part A, Batch Number NW7657UH. Part B, Batch Number NC2445UU.

Interfine 979: Part A, Batch Numbers NB5571UH and NC6426UH. Part B, Batch Numbers ND7617UH and NC6366UH.

The QAI issued TL-0101(s) to accompany shipment. Paint and documents appear to comply with contract documents 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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Gray,David	Quality Assurance Inspector
----------------------	------------	-----------------------------

Reviewed By:	Foerder, Mike	QA Reviewer
---------------------	---------------	-------------