

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-027835**Date Inspected:** 18-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) 230:

The QAI observed ABM welder Brian Moore (ID# B) welding 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" on Suspender Brackets 108W, 108E, 110W and 110E. The QAI observed the welder placing welds 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 checked welding parameters (235 DC Amps and 27.5 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.

Cable System Split Collars (CCO) 223:

The QAI noted that ABM personnel were in process of excavation procedures on Split Collars 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 using

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

die grinders. Work was in process to the end of the shift. Work is done in accordance with ABM's client American Bridge / Flour directions.

The QAI met with QAI Chris Kincheloe. The QAI conducted a tour of the facility and introduced him to key ABM personnel involved with coating operations. QAI Kincheloe shared his experience with coating preparations and procedures with the QAI. Items of discussion included the blasting and coating requirements of products currently in process at ABM.



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
