

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 #: 1.28**WELDING INSPECTION REPORT**

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

Report No: WIR-027966
Date Inspected: 13-Jul-2012

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

OSM Arrival Time: 700
OSM Departure Time: 1930
Location: Job Site

CWI Name:	As noted below.	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:	Tower Component	

Summary of Items Observed:

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the 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:

This QA compiled a current status sheet for tower Electroslag Welds (ESW) and Orthotropic Box Girder (OBG) drop-ins. This QA emailed a copy of the current status sheet to Task Leader Bill Levell, Structural Materials Representative (SMR) Aaron Prchlik, and SMR Bahjat Dagher.

Tower

ESW B - 100% QA/QC complete
ESW C - 100% QA/QC complete
ESW F - 100% QA/QC complete
ESW H - 100% complete Face B, QC technician Keech unavailable
ESW L - 100% complete Face B, DeArmond/Cayabyab
ESW M - 100% QA/QC complete
ESW R - 100% QA/QC complete
ESW S - 100% QA/QC complete
ESW G - 95% complete (4000mm~6000mm, Face B, In-progress) Patterson/Kortum
Current In-Process: (QA Lizardo)
ESW Q - Excavation, Y=3400mm, L= 1300mm
ESW P - Excavation, Y= 3400mm & 3700mm, L= 480mm

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East OBG Drop In Panel

13E PP120 - 100% QA
13E PP120.5-E2.3 - 100% QA
13E PP122-LS1 - 100% QA
13E PP122-LS2 - 100% QA
13E PP122-LS3 - 100% QA
13E PP122-E2.1-BW1 - 100% QA
13E PP123.5-E2.1-BW1 - 100% QA
13E PP123.5-E2.1-BF1 - 100% QA
13E PP123.5-E2.1-BF2 - 100% QA
13E PP123.5-E2.1-BF3 - 100% QA
13E PP124-E2.2-BF1 - 100% QA
13E PP124.5-E2.2-BW1 - 100% QA
13E PP124.5-E2.8-BW1 - 100% QA
13E PP124.5-E2.8-BW1 - 100% QA

West OBG Drop In Panel

No new additions

East Corner Drop In (QA Frey)

12E-E2.1 (internal)
2 welders FCAW, WPS 3040A-1
2 welders, SMAW WPS 1040-CU

West Corner Drop In (QA Daggett)

12W (internal)
2 welders, SMAW WPS 1040-CU
2 welders, FCAW WPS 3040A-1

Orthotropic Box Girder - 13E

This QA randomly observed ABF/JV qualified welder Richard Garcia #5892 performing Shielded Metal Arc Welding (SMAW) with 3.2mm" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1040C-CU. The joint being welded was 12E-E2.1.

During welding, ABF Quality Control (QC) Salvador Moreno was noted monitoring the welding parameters.

This QA observed, at random intervals, ABF/JV qualified welder Jeremy Dolman #5042 performing Flux Core Arc Welding (FCAW) implementing Caltrans approved Welding Procedure Specification Specification (WPS) ABF-WPS-D15-3040A-1. The joint being welded was 12E-E2.1.

During welding, ABF Quality Control (QC) Salvador Moreno was noted monitoring the welding parameters.

Orthotropic Box Girder - 13W

This QA observed, at random intervals, ABF/JV qualified welder Jin Pei Wang #7299 performing Flux Core Arc Welding (FCAW) implementing Caltrans approved Welding Procedure Specification Specification (WPS)

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ABF-WPS-D15-3040A-1. The joint being welded was 12W Corner Drop-In.

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters.

This QA observed, at random intervals, ABF/JV qualified welder Xiao Jian Wan #9677 performing Flux Core Arc Welding (FCAW) implementing Caltrans approved Welding Procedure Specification Specification (WPS) ABF-WPS-D15-3040A-1. The joint being welded was 12W Corner Drop-In.

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

This QA met with Caltrans representative Mohammad Awal and Rick Morrow. The discussion was focused around interpretation of transverse indication groupings discovered using the Ultrasonic method. This QA performed Ultrasonic Testing (UT) for those in attendance to provide a visual demonstration of indication discovery, orientation, and interpretation of attained UT signals.

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 SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford,William	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
