

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-027990**Date Inspected:** 16-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Scott Kortum**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:** S.A.S. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI met with the contractor's personnel at Hinge K. The QAI noted that re-bar coupling operator qualification tests will be conducted for the Hinge K pending work. The QAI observed the workers setting up the pairs of re-bars that will be assembled / tested. This work was in progress when Caltrans Transportation Engineer Jason Wilcox arrived and assumed the test monitoring. The QAI relayed the names of the persons who will be testing, as informed by the job site foreman.

The QAI met with the QCI Scott Kortum and reviewed the Electro-Slag Weld (ESW) survey report for weld H at Y=4000-6000mm. The QAI noted that the QCI report for the Ultrasonic Testing (UT) examination did not have several indications that were observed by the QAI. The QAI noted that the majority of indications are located while performing scanning pattern E and generally appear to have a transverse planar orientation. The QAI and the QCI performed a re-examination of the areas where indications were reported. The QCI was shown these and agreed that 1 additional transverse indication would be reported. The QAI noted that the weld cap is not ground flush and could affect the 1st leg examination of the planar recordable indications. The UT inspection was performed using 70 degree shear wave and ABF's ESW scanning procedure. The QAI and QCI were in general agreement regarding the location and nature of UT indications reported for ESW weld H (W-045). The weld inspection was reported on the joint ESW inspection report and a TL-6027 report. Reference those documents for additional information.

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The QAI then reviewed contract documents at pier 7. The QAI used approved weekly welding report submittals and cross referenced the welding and inspection status as reported with QA records to identify the overall weld status. The QAI continued reviewing the welding report packages #121 and 122, for conformance with the contract requirements. This work was in progress until the end of the shift.

Summary of Conversations:

The QAI relayed the status of the re-bar testing and UT inspections to the QAI Lead Bill Levell. There were other conversations between the QAI and ABF personnel regarding the general work in progress. The QAI and the QCI Scott Kortum had conversations regarding the ESW scanning and identification of indications. The QAI did not monitor any welding or repairs during this shift. Except as described above, there were no other notable conversations.

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:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
