

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-028189**Date Inspected:** 14-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** S.A.S. Job site**CWI Name:** Listed 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:** S.A.S. Structure**Summary of Items Observed:**

The Caltrans 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 was present at the West bound OBG and the following observations were made. At OBG 13W pp122.2, longitudinal stiffener flange # 3 S, the QAI randomly observed ABF/JV welder Gue Wu Chen, ID 1556, making overhead (4G) partial joint penetration (PJP) shielded metal arc welds (SMAW). The QAI noted that the welding is being monitored by the Quality Control Inspector (QCI) William Sherwood. The QAI noted that welding procedure specification (WPS) ABF-WPS-D15-1162-4 is being used for this work. The QAI made random observations of the welding. During these observations, the preheat, interpass temperature and welding current was verified. The QAI noted that the welding observed was within the ranges listed on the WPS. The welds at this location were completed and cleaned up. The QAI performed visual examination of the welds and noted that there were arc strikes and weld terminations that require additional work for the welds to be visually acceptable. The QAI was informed that the final inspection will be performed after the 24 hour required holding time. At the end of this shift, the QAI noted that the welds appeared to be visually acceptable. See the attached photo.

The QAI observed additional welding of longitudinal stiffener flanges at 13W/14W field splice, stiffener #3 and #2. The QAI observed welder Xiao Jian Wan, ID 9677, making 4G PJP stiffener welds. The QAI noted that the QCI William Sherwood is also monitoring this welding. Through-out the work shift, the QAI made random observations of the welding. During these observations, the preheat, interpass temperature and welding current was verified. The QAI noted that the welding observed was within the ranges listed on the WPS. This work was in progress at the end of the shift. See the attached photo.

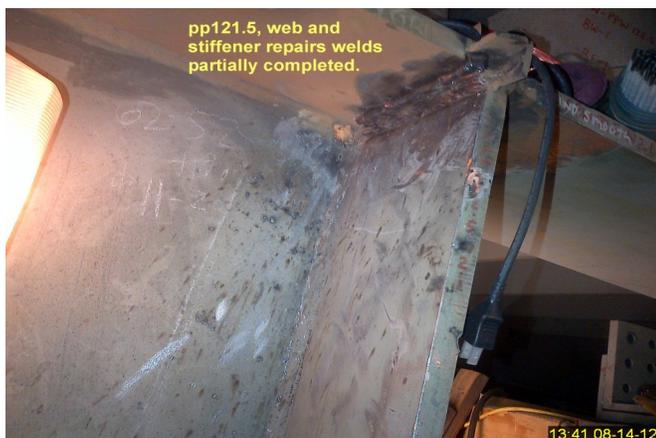
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The QAI witnessed the QCI John Pagliero conducting Ultrasonic Testing (UT) of completed complete joint penetration (CJP) welds on the K plate of the west OBG. The QAI noted that several of the associated splice welds that are being inspected have been rejected by the QCI. The QAI was informed that the repairs have not been scheduled at this time. See the attached photo

The QAI observed welder Rick Clayborn, ID 2773, working at pp121.5. The QAI noted that flange and web splices are being repaired. The QAI made several attempts to verify the welding but the welding was not continuous through the shift. The QAI noted that the weld repairs are not completed by the end of the shift. See the attached photo.

The QAI observed welder Lin E Yun, ID 9344, making 4G CJP repairs on the bottom flange and web at pp121.5 W2.5 and pp122 W2.5. The QAI noted that the QCI William Sherwood is monitoring this welding. The QAI was informed that this welding is conforming to ABF-WPS-D15-1004-repair. Through-out the work shift, the QAI made random observations of this welding at this location. The QAI noted that the welding observed was within the ranges listed on the WPS. The repairs in this are were completed at the end of shift.



Summary of Conversations:

The QAI had conversations with the QCI personnel, ABF workers and other QAI regarding the general work in progress. The QAI relayed the status of the welding / inspections observed to the QAI Danny Reyes and the QAI Lead Bill Levell. Except as described above, there were no other notable conversations.

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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
