

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-028516**Date Inspected:** 03-Oct-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** S.A.S. Job site**CWI Name:** John Hays**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 provided with an inspection request (TL-38) that has been submitted by the contractor. The QAI noted that the request is to green tag release partially fabricated components, Hinge Cover Plates B1, C1 and D1, for additional fabrication according to Contract Change Order (CCO) 217S1. At approximately 740 hours, the QAI called the referenced person to contact, Mark MacDonald, and left a message. Throughout the day, the QAI did not observe the plates or receive additional information for the requested release. The QAI contacted the Quality Control Manager (QCM) Chuck Kanapicki, and inquired about the status of the plates. The QAI was informed that the shipment was made without being released. The QAI informed the QCM that a non-conforming incident report will be written, as the provided request was not allowed to be completed.

The QAI was tasked with monitoring the welding that is scheduled at pier 7. The QAI noted that the Architectural Shroud Assembly for the East bound OBG has a bolted field splice and the internal splice plate requires stiffeners to be welded on. The QAI observed that this is the work that will be performed. The QAI noted that there are approved ZPMC drawings with the details for the 6mm fillet welded stiffeners. The QAI reviewed the drawings with the Quality Control Inspector (QCI) John Hays. The QAI noted that the welding will be performed by Kevin Kananen, ID 6521, utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-F1200. The QAI noted that 1 of the 3 plates to be welded has been fit up. The welder was tasked with other work and when the QAI returned to the work area, the fillet welds were complete. The welding was not observed by the QAI. The QCI informed the QAI that the remaining plates to be welded have not been scheduled for this shift and the final inspection of the

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completed welds will be performed at a later time. See the attached photo.

The QAI 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 QC inspection reports for identified recordable indications and compiling the data. The QAI also reviewed the log of approved welding repairs to reference with the reported status of the welds. This work was in progress until the end of the shift.



Summary of Conversations:

The QAI was informed that the QAI Danny Reyes will be the Lead and review all reports generated at the job site. The QAI relayed the status of the stiffener welding and document reviews to the QAI Lead Danny Reyes. The QAI also relayed that the hinge cover plates were shipped prior to being released and that a non-conforming incident report was written. 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 Gary Thomas, (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Reyes, Danny	QA Reviewer
