

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-028546**Date Inspected:** 29-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** S.A.S. Job site**CWI Name:** Steve Jensen**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 tasked with monitoring the welding and repairs being performed on the Complete Joint Penetration (CJP) groove welds on the OBG 12E corner assembly. At panel point (pp)116.5, the QAI observed ABF welder Deli Zhang, ID 4735, welding repairs on the Bottom Web (BW)2 and Bottom Flange (BF)2. The QAI noted that the welding is being monitored by the Quality Control Inspector (QCI) Steve Jensen. Throughout the shift, the QAI made random observations of the work in progress. During the observations of the welding, the preheat and interpass temperatures were maintained and the welding parameters were within the ranges listed on Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair. See the attached photo. The QAI noted that the work was not completed at the end of the shift.

At pp115.5, the QAI observed ABF welders Xiao Hua Luo, ID 1291, and James Zhen, ID 6001, welding repairs on face A and face B of BW2 and BF3. The QAI noted that this welding is also being monitored by the QCI Steve Jensen. Throughout the shift, the QAI made random observations of the work in progress. During the observations of the welding, the preheat and interpass temperatures were maintained and the welding parameters were within the ranges listed on Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair. See the attached photo. The QAI noted that the work was not completed at the end of the shift.

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Summary of Conversations:

The QAI relayed the observation of the welding and repairs to the QAI Danny Reyes and the QAI Lead Bill Levell.

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:	Levell, Bill	QA Reviewer
