

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-028960
Date Inspected: 03-Jan-2013

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: 1730
Location: S.A.S. Job site

CWI Name:	Jesus Cayabyab	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:

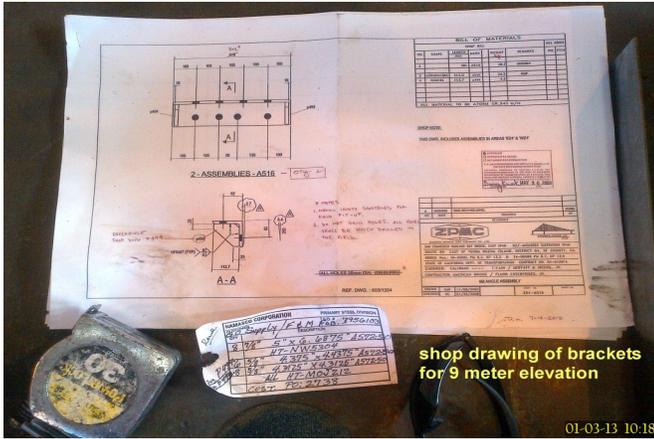
The Caltrans Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI 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 contractor's submitted Electro-Slag Welding (ESW) reports and referencing the Requests for Weld Repair (RWRs) in order to determine the status of completion of the repairs and welds. The QAI continued reviewing welding report packages #136, #137 and #138, for conformance with the contract requirements. This work was in progress at the end of the shift.

At pier 7, the QAI observed welding of angle brackets that will be installed at the 9 meter elevation on the tower structure. The QAI observed ABF welder Chris Bowles, ID 9317, using Shielded Metal Arc Welding (SMAW) and E7018 electrodes to make the 8mm horizontal (2F) fillet welds. The QAI noted that gusset plates are being welded onto angle steel to make the following assemblies: A510 (1); A72 (1); A520 (2); A516 (2) & A508 (1). The QAI noted that the Quality Control Inspector Jesus Cayabyab is monitoring the work. The QAI was informed that the Welding Procedure Specification (WPS) ABF-D15-F1200 is being used for the fillet welding. The QAI noted that the work observed appeared to be conforming to the WPS requirements. The QAI noted that welding of the brackets was completed and a final inspection will be performed after the required 24 hour hold time. See the attached photos.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

The QAI relayed the status of the document / submittal reviews and pier 7 bracket welding to the QAI Lead Danny Reyes. 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