

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-029039
Date Inspected: 15-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:	Pat Swain	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 met with the Quality Control Inspector (QCI) Pat Swain. The QAI was informed that there were modifications of service platform brackets being performed at Pier 7 work area. The QAI reviewed the request for information (RFI) 3158R00. The QAI noted that 2 welded plates will be moved and re-welded. The QAI made random observations of this work in progress. The QAI noted that welder Kevin Kananen, ID 6521, is performing this work. The QAI witnessed fillet welding of the brackets and noted that the welding appeared to be conforming to the welding procedure specification (WPS) ABF-D15-F1200A. Upon completion of the welding, the QAI noted that the QCI visually inspected and conducted Magnetic Particle Testing (MT) on the welds. The QAI was informed that the welds were acceptable. The QAI conducted visual examination of the welds and noted that they appeared to be conforming to the contract requirements. The QAI was informed that the plates / parts will be primer coated at a later time. See the attached photos.

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' overall reported condition. The QAI continued reviewing welding report packages 139 & 140, for contract conformance. This work was in progress at the end of the shift.

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Summary of Conversations:

The QAI relayed the status of the document / submittal reviews 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
