

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029431**Date Inspected:** 15-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** American Bridge Manufacture**Location:** Reedsport, Oregon**CWI Name:** Mike Inman**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:** Supplemental Cable Band Collar, Cable Safet**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) representative was present at American Bridge Manufacture for observations related to welding, fabrication and inspection performed for the Supplemental Cable Band Collar scheduled for this project. While onsite the QA Inspector observed the following.

At the time of arrival, the QA Inspector met with ABM Quality Control (QC) Inspector and discussed the welding, Non-Destructive testing (NDT) and other project related operations scheduled for this project for this date.

At approximately 1330 hours, The QA Inspector was present on a conference call between Structural Materials Representatives (METS on behalf of Gary Thomas) and ABM Project Manager Todd Pannell. Multiple discussions regarding production and material release were addressed during conference.

Supplemental Cable Band Collar Welding - CCO # 274

The QA Inspector periodically observed American Bridge Manufacture (MCM) welding personnel Cody Greer performing base material preheating, preparation and welding operations. The welding operation was being performed by using the Flux Cored Arc Welding Gas Shielded (FCAW-G) process in the horizontal position and it was being performed to make Complete Joint Penetration (CJP) and Partial Joint Penetration (PJP) welds. The welding operation was being performed between assembly members on the Supplemental Cable Band Collar identified as number 16. (A total of 6 plates were attached on bottom and 6 plates on top sides of the assembly).

The QA Inspector verified the electrical welding parameters and they appeared to be in general compliance with the referenced Welding Procedure Specification (WPS) number ABM-SAS-25 and ABM-SAS-08. The QA

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Inspector observed QC Inspector monitoring the welding operation at this location. The welding operation was not completed between assembly members at this location during the QA Inspector's shift.

Supplemental Cable Band Collar Welding - CCO # 274

The QA Inspector periodically observed ABM welding personnel Brian Moore performing base material preparation and welding operations. The welding operation was being performed by using the FCAW-G process in the horizontal position and it was being performed to make CJP and PJP welds. The welding operation was being performed between assembly members on the Supplemental Cable Band Collar identified as number 6. (A total of 6 plates were attached on bottom and 6 plates on top sides of assembly).

The QA Inspector verified the electrical welding parameters and they appeared to be in general compliance with the referenced WPS number ABM-SAS-25 and ABM-SAS-08. The QA Inspector observed QC Inspector monitoring the welding operation at this location. The welding operation was not completed between assembly members at this location during the QA Inspector's shift.

Supplemental Cable Band Collar Welding - CCO # 274

The QA Inspector periodically observed ABM welding personnel Ryan Whiteman performing base material preparation and welding operations. The welding operation was being performed by using the FCAW-G process in the horizontal position and it was being performed to make fillet welds. The welding operation was being performed between assembly members on the Supplemental Cable Band Collar identified as number 11 and 9. (A total of 4 plates were attached on top and 4 plates on bottom sides of assembly. Additionally two plates attached to top and two plates attached on bottom of assembly).

The QA Inspector verified the electrical welding parameters and they appeared to be in general compliance with the referenced WPS number ABM-SAS-07. The QA Inspector observed QC Inspector monitoring the welding operation at this location. The welding operation was not completed between assembly members at this location during the QA Inspector's shift.

Supplemental Cable Band Collar Fit-up - CCO # 274

The QA Inspector periodically observed ABM personnel Joe Reitmeir performing base material preparation, fit-up and tack welding operations. The fit-up operation was being performed to attach assembly plate members to continue making the Supplemental Cable Band Collar identified as number 1, 2, 9, 10 and 11. (A total of four plates will be attached to top and four on bottom of the assembly).

During the fit-up in progress and after the members were aligned, the QA Inspector observed ABM welding personnel performing tack welding operations using the FCAW-G process in the horizontal position. The QA Inspector verified the electrical welding parameters that appeared to be general compliance with the referenced WPS number ABM-SAS-07.

The QA Inspector observed QC Inspector monitoring the fit-up and tack welding operations at this location. The total fit-up and tack welding operations were completed between assembly members during the QA Inspector's shift.

OBG Cable Safety Railing Welding - CCO # 188

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The QA Inspector periodically observed ABM welding personnel Mike Hebert performing base material preparation and welding operations. The welding operation was being performed by using the FCAW-G process in the vertical position and it was being performed to make fillet and Partial Joint Penetration (PJP) welds. The welding operation was being performed between assembly members on the Cable Safety Railing Post identified as number 502HRP2C (CB-2C).

The QA Inspector verified the electrical welding parameters and they appeared to be in general compliance with the referenced WPS number ABM-SAS-06 for the fillet weld and ABM-SAS-035 for the PJP weld. The QA Inspector observed QC Inspector monitoring the welding operation at this location. The welding operation was completed between assembly members at this location during the QA Inspector's shift.

After the welding operation was completed, the QC Inspector performed final visual inspection and notified the QA Inspector that the welds were reported acceptable. The QA Inspector performed random visual verification on the completed welds and did not observe any major welding related discontinuities. The QA Inspector was notified by the QC Inspector the total posts were completed and that ABM will request a material verification prior to release to the galvanizer at a later date.

OBG Cable Safety Railing Coating - CCO # 188

The QA Inspector was notified by ABM QC Inspector Antony Corsaletti that the coating operation had been completed on the Cable Safety Railing (Post and Gates) during the last shift and that the final visual inspection and the coating repairs were in progress at this moment. The QC Inspector notified that he had reported coating discrepancies and that the coating personnel were in progress of performing coating repair operation at this time.

The QA Inspector did not perform final coating verification due to the fact that the coating personnel did not complete the coating repairs during the QA Inspector's shift. The QA Inspector performed random verification on the areas marked by the QC Inspector and confirmed the coating repairs.

Summary of Conversations:

As noted on the body of the report above. Other Basic communication was performed between the QA Inspector and the Quality Control Inspector during observations.

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:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Foerder,Mike	QA Reviewer
