

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-029438**Date Inspected:** 02-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** S.A.S. Job site**CWI Name:** Jim Bowers**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 witnessed ABF personnel using oxy-fuel torches to induce sweep into a traveler rail that didn't align properly to its mounting location between panel point 110 and 112 West. The QAI was informed that this work was apparently not performed at the fabricator and will be done at pier 7. The QAI noted that the work is outlined in Request for Information (RFI) 3233. The QAI and ABF Welding Quality Control Manager (WQCM) Jim Bowers observed 4 heating / cooling cycles across the flanges of the traveler rail. The process was monitored using 1100° and 1200° temperature indicating crayons. After the beam was cooled to ambient temperature after the last application of heat, the sweep was measured and the QAI was informed that the galvanizing and paint will be repaired. 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 the contractor's welding report submittals 1536R160, 161 and 162 for conformance with the contract requirements. The QAI also assisted the Structural Materials Representatives and Assistant Structural Materials Representatives in researching the testing history of the A354BD materials that were fabricated at Dyson. 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
