

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-029605**Date Inspected:** 20-May-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge Manufacturing**Location:** Reedsport, OR**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:** Skyway Traveler Rail Replacement**Summary of Items Observed:**

This Caltrans Quality Assurance Inspector (QAI) Dennis Combs was at the offsite fabrication facility of American Bridge Manufacturing (ABM) between times noted above in order to monitor Quality Control functions and the in process work being performed by ABM personnel. The following items were observed:

Skyway Traveler Rail Replacement - CCO # 24S0

This QAI periodically observed American Bridge Manufacture (ABM) welding personnel Mike Hebert and Ryan Whiteman 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. Complete Joint Penetration (CJP) and fillet welding performed on the web to bottom flange connections on side B in the flat and horizontal position on traveler rail numbers 3031TR1, and 3033TR1. These traveler rails, 3031TR1, and 3033TR1 flange to web welding was completed, further welding on these rails is required and will be performed after heat straightening is completed.

This QAI randomly monitored fit up, complete Joint Penetration (CJP), and fillet welding on the web to top flange connections on side A in the flat and horizontal position on traveler rail numbers 3030TR1, and 3034TR1.

This QAI observed QC Inspector verifying the electrical welding parameters according to Welding Procedure Specification (WPS) numbers ABM-SAS-07 and ABM-SAS-08, they appeared to be in general compliance.

The welding operation on traveler rails 3031TR1, and 3033TR1 had not been completed during this shift.

OBG Cable Safety Railing Coating - CCO # 188

The QA Inspector periodically observed ABM coating personnel performing coating operations on the OBG Cable

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Safety Railing Posts. The QC Inspector Tony Corsaletti notified QA Inspector ABM was starting the coating operation on this date on the cable safety railing.

Summary of Conversations:

No relevant 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.

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| Inspected By: | Combs,Dennis | Quality Assurance Inspector |
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| Reviewed By: | Riley,Ken | QA Reviewer |
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