

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 #: 1.28**WELDING INSPECTION REPORT**

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-029866
Date Inspected: 10-Jul-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: 1530
Location: S.A.S. Job site

CWI Name:	N / A	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 traveled to Allied Engineering in Alameda, CA and observed the machining of components for the E2 Shear Key modifications. The QAI spoke with shop personnel and observed that the stock materials are being squared and 1 part is beginning to be milled to final shape. The QAI reviewed the drawings and informed the Structural Materials Representative of the observations made. The QAI also relayed that there will be dimensional variations in part lengths because the steel supplied to the shop by ABF is cut to the final dimensions prior to machining. The QAI relayed that the parts may be up to 100mm shorter than detailed. See the attached photos.

The QAI reviewed contract documents at pier 7. The QAI used the welding report submittals and welding report packages to cross reference the welding and inspection status as reported with QA records and to identify the overall weld status of work reported as complete and in progress. The QAI continued reviewing the contractor's reports and referencing the Requests for Weld Repair (RWRs) in order to determine the status of completion of the repairs of Electro-Slag Welds (ESW). The QAI continued reviewing welding report packages #175, #176 & #177 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 E2 shear key modification work, document reviews and weld repair tracking 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
