

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-029959**Date Inspected:** 28-Aug-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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:** Runner Blade, Tower Skirt Ladder at 3M**Summary of Items Observed:**

The 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:

This QAI witnessed work in progress related to the Runner Blade Assemblies:

This QAI randomly observed Quality Control Inspector (QCI), Mike Inman, of American Bridge Manufacturing (ABM) monitoring the welding of the Runner Blade Assemblies. The QCI was noted to monitor joint preparation and

welding amperage / voltage with an Amprobe Model ACDC-100. The QAI noted that welding was performed by a certified welder, Brian Moore (Welder ID "B"), with amps at 300 and volts at 28. The Welding process performed was Flux Core Arc Welding (FCAW) using E71T-1JH8, 1/16" diameter electrode in accordance to Welding Procedure Specification (WPS) # ABM-SAS-09. This QAI verified amperage, voltage, interpass temperature and joint preparation. The Runner Blade Assembly Piece Marks are X26B (RH) 5 total, and X24B (LH) 5 total as noted on approved ABF Drawing #X2018A. The material utilized was ASTM A572 Gr. 50, .375" thick. The welding noted above appeared to have been in conformance with AWS D1.1, Standard Specification and Special Provisions.

The QAI witnessed work in progress related to the Tower Skirt Ladder at 3M:

This QAI noted Tower Skirt Ladder Cage was received today from Galvanizers Company, QAI collected green tag and COC from ladder cage. This QAI monitored ABM QCI Mike Inman inspect delivered parts for damage.

This QAI randomly observed American Bridge Manufacturing (ABM) certified welding personnel Brian Moore

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performing fit up of new galvanized ladder cage to existing ladder supplied from job site. This QAI observed ABM personnel removing galvanizing from areas to receive welding between cage and ladder according to approved ZPMC drawing number WD1-A14 A/B.



Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI, ABM QC, and ABM personnel.

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: Combs,Dennis

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer
