DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-011072
Date Inspected: 30-Dec-2009

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: Pier 7, Oakland CA

CWI Name: Mike Johnson

Inspected CWI report:	☑ Yes	☐ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☐ Yes	☐ No	☑ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: ABF-PQR-033

Summary of Items Observed:

This Quality Assurance (QA) Inspector arrived at American Bridge/Fluor (ABF) warehouse to monitor the welding of Procedure Qualification Record (PQR) test plates and Quality Control (QC) functions.

The QC Inspector Mike Johnson informed this QA Inspector that welding personnel Rory Hogan would start welding on PQR test plate ABF-PQR-033 using the FCAW-G process in the vertical (3G) position. This QA Inspector observed as QC Inspector Mike Johnson performed a visual inspection of the weld joint fit up and recorded the welding parameters for the root pass. The QA Inspector randomly observed the welding was performed utilizing the semi automated bug-o track system. The QA Inspector randomly observed the QC Inspector record the welding parameters for every pass, root through cover passes.

The QA Inspector randomly observed the welding was completed on the groove side or front side of PQR test plate ABF-PQR-033 using the Flux Core Arc Welding (FCAW) process with ESAB, Ultracore filler metal in the overhead (3G) position. The QA Inspector noted the PQR was performed in a manner in which the plate was placed and held in position at a 22 degree angle. The QA Inspector was informed by the QA Inspector Robert Mertz, the PQR would be performed in welded in the same position, angle and process to be used in the field during fabrication. The QA Inspector noted the groove was filled up and completed on this date. The QA Inspector was informed by ABF personnel, the steel backing will be removed, the weld will be back gouged and back welded in the 4G vertical position at a 22 degree angle on the following shift on 12-31-09.

WELDING INSPECTION REPORT

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Summary of 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 , who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer