

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022665**Date Inspected:** 18-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** Gary Ehram**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:** SAS OBG**Summary of Items Observed:**

Quality Assurance inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. Access Plate Longitudinal Stiffener Field Splice @ 8W PP70.5 W5
2. Lifting Lug Holes #1 and 3 @ 7W PP56 W3
3. Lifting Lug Hole #3 7E PP53
4. 10E 11E E1

1. Access Plate Longitudinal Stiffener Field Splice @ 8W PP70.5 W5

The QA Inspector noted that the ABF welder Jin Pei Wang had completed welding the Longitudinal Stiffener (LS) and observed the welder grinding and blending. The QA Inspector noted that the power had been lost and work had stopped in that area.

2. Lifting Lug Holes #1 and #3 @ 7W PP56 W3

The QA Inspector observed ABF welder Darcel Jackson preparing joint fit-up on Lifting Lug Holes (LLH) 1 and 3.

The QA Inspector observed the QC Inspector approve the fit up and the welders root pass. The QA Inspector observed the QC Inspector periodically monitor the welding parameters as specified by the approved WPS ABF-WPS-D1.5-1050A. The QA Inspector randomly observed the welder periodically throughout the remainder

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of the shift. It was noted by the QA Inspector that the welder had completed the welding by the end of the QA Inspectors shift.

3. Lifting Lug Hole #3 7E PP53

The QA Inspector randomly observed the ABF welder Jason Collins begin the root pass on the Lifting Lug Hole (LLH) plate #3. The QA Inspector observed the QC Inspector identified as Fred Von Hoff monitor the welding parameters as specified by the approved WPS ABF-WPS-D1.5-1050A. The QA Inspector randomly observed the welder periodically throughout the remainder of the shift. It was noted by the QA Inspector that the welder had completed the welding by the end of the QA Inspectors shift.

4. 10E 11E E1

The QA Inspector observed the QC Inspector identified as John Bagliero monitor the welding parameters as specified by the approved WPS ABF-WPS-D1.5-1040-B. The QA Inspector observed the welder periodically throughout the remainder of the shift.

Summary of Conversations:

As noted above

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 Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
