

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-022995**Date Inspected:** 25-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: John Pagliero
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: 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:** 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. 10W 11W Longitudinal Stiffener #5
2. 9W 10W Longitudinal Stiffener #3
3. 9W 10W Longitudinal Stiffener #4
4. 9W 10W E
5. 8W PP70.5 W5 LS6

1. 10W 11W Longitudinal Stiffener #5

The QA inspector periodically observed the in process Shielded Metal Arc Welding (SMAW) being performed in the 3G vertical position by ABF welder Jin Pei Wang on the Longitudinal Stiffener (LS)#5. QC inspector John Pagliero was noted to be present in order to monitor the progress and ensure the welding parameters were within the established Welding Procedure Specification (WPS). The work continued throughout the QA inspector's shift and was not completed on this date. The QA Inspector noted that the work appeared to be in general conformance with the contract documents.

2. 9W 10W Longitudinal Stiffener#3

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The QA inspector periodically observed the in process SMAW being performed in the 3G vertical position by ABF welder Hua Qiang Hwang on the LS #3. QC inspector John Pagliero was noted to be present in order to monitor the progress and ensure the welding parameters were within the established WPS. The work continued throughout the QA inspector's shift, and upon completion appeared to be in general conformance with the contract documents.

3. 9W 10W Longitudinal Stiffener #4

The QA inspector periodically observed the in process SMAW being performed in the 3G vertical position by ABF welder Xiao Jian Wan on the LS #4. QC inspector John Pagliero was noted to be present in order to monitor the progress and ensure the welding parameters were within the established WPS. The work continued throughout the QA inspector's shift, and upon completion appeared to be in general conformance with the contract documents.

4. 9W 10W E

The QA Inspector randomly observed the in progress semi-automatic Flux Core Arc Welding (FCAW) in the 4G overhead position by ABF welder Rory Hogan. The QA Inspector observed the QC Inspector identified as Fred Von Hoff monitor the progress and ensure the welding parameters were within the established WPS. The work continued throughout the QA inspector's shift, and was completed on this date. The QA Inspector noted that the work appeared to be in general conformance with the contract documents.

5. 8W PP70.5 W5 LS6

The QA Inspector noted the dimensions of the excavation to be 50mm's long, 25mm's wide and 6mm's deep from y=35mm – 80mm. The QA inspector periodically observed the in process SMAW being performed in the 3G vertical position by ABF welder Kit Kitlai. QC inspector John Pagliero was noted to be present in order to monitor the progress and ensure the welding parameters were within the established WPS. The work continued throughout the QA inspector's shift, and upon completion appeared to be in general conformance with the contract documents.

Summary of Conversations:

As noted above



WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
---------------------	-------------	-------------