

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024266**Date Inspected:** 03-Jun-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. 8E PP64 E4 Lifting Lug Holes #1 & 3
2. 10E 11E E2 Diagonal Plate Splice (Inside)
3. 8W PP64 Lifting Lug Holes #2 & 4
4. 8E PP68 E4 Lifting Lug Holes VT, MT and UT

1. 8E PP64 E4 Lifting Lug Holes #1 & 3

The QA Inspector made periodic observations of ABF welder Jason Collins performing Shielded Metal Arc Welding (SMAW) in the 4G overhead position on the Lifting Lug Holes (LLH) #1 and 3 located at 8E PP64 E4. The QA Inspector observed the QC Inspector Fred Von Hoff as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1110A-Rev. 1. The work progressed throughout the shift and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

2. 10E 11E E2 Diagonal Plate Splice (Inside)

The QA Inspector randomly observed ABF welding operators Song Tao Huang and Jin Quan Huang

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performing Flux Core Arc Welding w/gas (FCAW-G) operations in the 3G vertical position on face E2 inside of the OBG. The QA Inspector observed the QC Inspector John Pagliero as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3042B-1. The work progressed throughout the QA Inspector's shift. The QA Inspector noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

3. 8W PP64 Lifting Lug Holes #2 & 4

The QA Inspector made periodic observations of ABF welder Fred Kaddu performing Shielded Metal Arc Welding (SMAW) in the 4G overhead position on the LLH's #2 and 4 located at 8W PP64. The QA Inspector observed the QC Inspector John Pagliero as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1110A Rev. 1. The QA Inspector noted that the work is in progress and appeared to be in general conformance with the contract documents.

4. 8E PP68 E4 Lifting Lug Holes VT, MT and UT

The QA Inspector performed a Magnetic Particle Test (MT) on LLH's at 8E PP68 E4. The QA Inspector tested 10% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. . The QA Inspector noted that the work appeared to be free of defects and was found to be acceptable and in general conformance with the contract documents. Upon completion of the MT, the QA Inspector performed Ultrasonic Testing utilizing a G.E./Krautkramer USN 60. The QA Inspector also utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4 during the examination. Upon completion of the testing, it was noted by the QA Inspector that no indications were present and the work was found to be acceptable.

Summary of Conversations:

At the beginning the shift the QA Inspector met with QC Inspector John Pagliero and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.



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.

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Inspected By: Frey,Doug

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer