

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-024643**Date Inspected:** 23-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** William Sherwood**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. 9E PP77 E3 Lifting Lug Holes #2 and 4
2. 9E PP76 E4 Lifting Lug Hole #3
3. 7/8 Stud Welding (Bike Path)
4. 11E 12E D1/D2 Bottom Plate Splice

1. 9E PP77 E3 Lifting Lug Holes #2 and 4

The QA Inspector made periodic observations of ABF welder Jorge Lopez ID# 6149 performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on Lifting Lug Holes (LLH) #2 and 4 located at 9E PP77 E3. 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-D15-1050A-CU. The work was completed on this date and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

2. 9E PP76 E4 Lifting Lug Hole #3

The QA Inspector made periodic observations of ABF welder Fred Kaddu ID# 2188 performing SMAW in the 1G

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flat position on LLH #3 located at 9E PP76 E4. The QA Inspector observed the QC Inspector Pat Swain as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The work was completed on this date and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

3. 7/8 Stud Welding (Bike Path)

The QA Inspector continuously observed ABF operator Julian Paulk performing Stud Welding in the down hand position of 7/8 studs at the following locations; 8E PP69, 9E PP77, 9E PP73, 9E PP75, 9E PP77, 9E PP79 and 9E PP81. The QA Inspector observed the QC Inspector William Sherwood as being present in order to monitor the progress and ensure the welding parameters were in compliance with ABF-WPS-D15-5001 Stud. Upon placement of each stud, the weld was visually inspected for complete fusion (360 degrees) at the base. It was noted by the QA Inspector that the NE stud at PP73 and the NE stud at PP77 appeared to have lack of fusion and were removed. The QA Inspector observed the QC Inspector perform Magnetic Particle Testing on the placement area and upon approval the studs were replaced, re-inspected and found to be acceptable. The work was completed on this date and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

4. 11E 12E D1/D2 Bottom Plate Splice

The QA Inspector periodically observed ABF welding operator James Zhen ID# 6001 perform Submerged Arc Welding (SAW) on face D1 and D2 in the 1G flat position inside of the OBG. 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-F3200-2. The work progressed throughout the QA Inspector's shift. The QA Inspector noted that the work was in progress and appeared to be in general conformance with the contract documents.

Summary of Conversations:

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



Comments

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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
