

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-025375**Date Inspected:** 29-Jul-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. 10E PP88E4 (Exterior)
2. 11W 12W A5 (Exterior)
3. 11E 12E C (Exterior)
4. 11W 12W A4 (Exterior)
5. 11W 12W A3 (Exterior)
6. 10E PP92 E4 (Exterior)

1. 10E PP88E4

The QA inspector observed ABF welder Mike Jiminez ID# 4671 performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on Lifting Lug Hole (LLH) #2 located at 10E PP88 E4. Prior to welding the QA inspector observed QC inspector Fred Von Hoff inspecting the fit up of the joint. The QA inspector verified the fit up alignment which was deemed acceptable as pertaining to the contract requirements. The QA inspector observed the QC inspector monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The work is in progress and the QA inspector noted that the work appeared to be in general conformance with the contract documents.

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2. 11W 12W A5 (Exterior)

The QA inspector noted the dimensions of the excavation at A5 y+4270 as 100mm's in length and 21mm's deep and the dimensions of A5 y+5220 as 110mm's in length and 22mm's deep. The QA inspector observed the QC inspector identified as John Pagliero perform Magnetic Particle inspection on the sites and found no indications. The QA inspector observed ABF welder Wai Kit Lai ID#2953 perform SMAW in the 1G flat position with the QC inspector being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1001-Repair. The QA inspector noted that the work appeared to be in general conformance with the contract documents.

3. 11E 12E C (Exterior)

The QA inspector randomly observed ABF welder Fred Kaddu ID#2188 utilizing the Plasma Arc Cutting (PAC) method to remove the backing bar from the exterior face of side plate C at 11E 12E. The work progressed throughout the shift and the QA inspector noted that the work appeared to be in general conformance with the contract documents.

4. 11W 12W A4 (Exterior)

The QA inspector noted the dimensions of the excavation at A4 y+3445 as 80mm's in length and 15mm's deep and the dimensions of A4 y+3800 as 80mm's in length and 16mm's deep. The QA inspector observed the QC inspector identified as John Pagliero perform Magnetic Particle inspection on the sites and found no indications. The QA inspector observed ABF welder Wai Kit Lai ID#2953 perform SMAW in the 1G flat position with the QC inspector being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1001-Repair. The QA inspector noted that the work appeared to be in general conformance with the contract documents.

5. 11W 12W A3 (Exterior)

The QA inspector noted the dimensions of the excavation at A3 y+4460 as 80mm's in length and 15mm's deep and the dimensions of A3 y+3230 as 85mm's in length and 14mm's deep. The QA inspector observed the QC inspector identified as John Pagliero perform Magnetic Particle inspection on the sites and found no indications. The QA inspector observed ABF welder Wai Kit Lai ID#2953 perform SMAW in the 1G flat position with the QC inspector being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1001-Repair. The QA inspector noted that the work appeared to be in general conformance with the contract documents.

6. 10E PP92 E4 (Exterior)

The QA inspector observed ABF welder Mike Jiminez ID# 4671 performing SMAW in the 1G flat position on LLH #3 located at 10E PP92 E4. Prior to welding the QA inspector observed QC inspector Fred Von Hoff inspecting the fit up of the joint. The QA inspector verified the fit up alignment which was deemed acceptable as pertaining to the contract requirements. The QA inspector observed the QC inspector monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The work is in

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progress and the QA inspector noted that the work 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 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.

Inspected By: Frey,Doug

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer