

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-025584**Date Inspected:** 03-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** John Heine**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:** S.A.S. components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at F.W. Spencer's fabrication shop to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI arrived at F.W. Spencer and met with the shop foreman Paul King and was given a general orientation of the facility where this work is being performed. The QAI was informed and observed that assorted piping components are being fit-up, welded and are set in 2 different shop areas. The QAI met with the Quality Control Inspector (QCI) John Heine, from Smith-Emery Company and discussed the work in progress. The QAI was informed that Curtis Jump is performing all pipe fitting and welding at this facility. The QAI was also informed that welding procedure specification (WPS) FWS P1 6010/7018 is being used for all welds. The QAI observed that at this time, 2" pipe and sockets are being fit up to make compressed air attachments that will be partially welded with threaded valves / fittings before final assembly in the field. The QAI made observations of the welding and noted that it appeared to be within the ranges listed by the WPS. The QAI was shown completed piping components that consisted of 1" and 2" water and compressed air parts that will be installed on the East end of the bike path and also Tower shaft lines.

The QAI made random observations of the completed piping components and noted that they appeared to be generally conforming with the contract requirements. The QAI also observed that at other areas of F.W. Spencer's shop, additional personnel were installing the threaded valves and fittings that are required for the final assembly of these components. The QAI noted that the ends of the socket fitting are set for field welding. The QAI asked the shop foreman if there were any shipments scheduled for these components to be delivered to the field. The foremen confirmed that he was aware that a request for release of materials would be needed prior to any

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shipments of parts and he also remarked that there are none scheduled at this time. See the attached photos of the conditions / parts observed during this shop visit.



Summary of Conversations:

The QAI relayed the status and progress of the piping component welding to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations.

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: Croff, Scott

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer