

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-025586**Date Inspected:** 05-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. The QAI was informed that assorted piping components have been welded and are being inspected. The QAI was informed that all welding is completed, however, there are still threaded valves / fittings that need to be assembled on these components. The QAI met with the Quality Control Inspector (QCI) John Heine, from Smith-Emery Company and was informed that all welded parts have been visually accepted. The QAI noted that no welding is being performed. The QAI also confirmed with the shop foreman that there is no date scheduled for these parts to be sent out to the field for final assembly / welding.

The QAI made random observations of the welded compressed air and water 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. See the attached photo of the parts observed during this shop visit.

The QAI arrived at the Self Anchored Span (SAS) Pier 7 job site to continue reviewing contract documents and submittals. The QAI reviewed contract related documents including the submitted and approved Welding Quality Control Plan (WQCP) and approved revisions to the WQCP. The QAI continued reviewing submittal 1536R71 for conformance with the contract requirements. This review was in progress at the end of the shift.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

The QAI relayed the status of pipe welding at F.W. Spencer and the status of the document reviews 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
