

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-025900**Date Inspected:** 09-Aug-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. 11E 12E E (Exterior)
2. 11E 12E C (Exterior)
3. 11E 12E South side (Interior)

1. 11E 12E E (Exterior)

The QA inspector randomly observed ABF welding operator Fred Kaddu ID#2188 performing Plasma Arc Cutting (PAC) utilizing a "Bug-O" motorized rail system with a magnetic base attached in the overhead position to remove the backing bar from the underside of side plate E, at 11E 12E of the OBG.

The QA Inspector observed the operator adjust the equipment in order to make consecutive passes to remove the backing bar and back gouge the weld. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the removal of the backing bar was complete and the weld had been back gouged.

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2. 11E 12E C (Exterior)

The QA inspector randomly observed ABF welding operators James Zhen ID#6001 and Jin Pei Wang ID#7299 performing Flux Core Arc Welding with gas (FCAW/g) utilizing a “Bug-O” motorized rail system with a magnetic base attached in the 4G overhead position on the underside of side plate C, at 11E 12E of the OBG. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3042B-1. The parameters were recorded as (A=240/V=22/TS=300/HI=1.06). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

3. 11E 12E South Side (Interior)

The QA inspector observed ABF welder Xiao Jian Wan ID#9677 performing Shielded Metal Arc Welding (SMAW) in the 3G vertical position on Longitudinal Stiffener (LS)#2 located at 11E 12E in the interior of the OBG. The QA inspector noted the use of an electrode oven at the required temperature for the E9018-MH4-R electrodes. The QA inspector observed the QC inspector identified as Fred Von Hoff monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1012-3. The parameters were recorded as (Amperes=134). Upon completion of the south face of the joint, the QC notified the QA inspector that the induction heating blankets were implemented on the completed weld and that the Proheat machine shut down. ABF welding personnel halted welding at this point and the QC inspector reported the incident to the QC Supervisor.

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
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Reviewed By:	Levell,Bill	QA Reviewer
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