

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: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026254
Date Inspected: 02-Sep-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Jobsite

CWI Name: As noted below
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
Component: SAS OBG

Bridge No: 34-0006**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:

- 11E 12E D2 (Exterior)
- 10W 11W PP95 Counterweight bracket (Exterior)
- Crossbeam #4 Service Platform 5 (Exterior)
- 11W 12W Side Plate C (Exterior)

- 11E 12E D2 (Exterior)

The QA Inspector noted the dimensions of the excavations at D1 Y+4020 as 65mm's in length, 30mm's wide and 16mm's depth. Y+4080 as 60mm's in length, 30mm's wide and 16mm's in depth. The QA Inspector observed the QC Inspector identified as Pat Swain perform Magnetic Particle inspection on the sites and found them to be acceptable. The QA Inspector observed ABF welder Xiao Jian Wan ID#9677 perform Shielded Metal Arc Welding (SMAW) in the 4G overhead position with the QC Inspector being present in order to monitor the welding and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1001-Repair. The QA Inspector noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

2. 10W 11W PP95 Counterweight bracket (Exterior)

The QA inspector observed ABF welder Eric Sparks ID#3040 perform Shielded Metal Arc Welding (SMAW) in the 2G horizontal position on the counterweight brackets at 10W 11W PP95 on the exterior of the OBG. The QA inspector observed the QC inspector identified as William Sherwood monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1080. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appeared to be in general conformance with the contract documents.

3. Crossbeam #4 Service Platform 5 (Exterior)

The QA inspector observed ABF welder Rick Clayborn ID# 2773 perform Flux Core Arc Welding (FCAW) in the 2F horizontal position on the service platform stair attachment tabs on stair 1 on crossover beam #4. The QA inspector observed the QC inspector identified as William Sherwood monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-F2200-3 and RFI# ABF-RFI-002417R00. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appeared to be in general conformance with the contract documents.

4. 11W 12W Side Plate C2 (Exterior)

The QA inspector randomly observed ABF welding operator 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 C2, at 11W 12W of the OBG. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3042B-1.

The parameters were recorded as (A=235/V=24/TS=250/HI=1.4). 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.

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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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
