

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:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026329**Date Inspected:** 20-Sep-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See Below**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:** Tower**Summary of Items Observed:**

At the start of the shift the Quality Assurance Inspector (QAI) traveled to the SAS project site to observe the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) personnel. The inspection was performed as noted below:

A). Tower Shear Plates

At the request of Quality Control Lead Inspector, Bonifacio Daquinag, Jr., this QAI performed a VT verification of the ESW located at the joint "C" and identified as WN: S-044. The verification was performed utilizing the contractor's inspection procedure identified as SE-VT-CT-D1.5-103. At the conclusion of the verification this QAI noted a planar misalignment of the square groove butt joint of approximately six millimeters (6mm) located at the Y axis coordinate 0 Meter-9 Meter. This QAI notified Mr. Daquinag of the misalignment and the issue in question was whether the correct transition of 2.5 to 1 was applied to ensure that the correct effective throat of the weld joint exists. Mr. Daquinag informed this QAI that he would verify the dimensions at this time and requested this QAI presence. This QAI observed Mr. Daquinag perform a dimensional survey of the misalignment, demonstrate and verify the transition. At the completion of the survey it appears that the welded transition complies with the contract specifications.

Later in the shift this QAI performed a VT verification of the ESW located at joint "B" identified as WN: E-044. At the conclusion of the verification the weld appears to comply with the contract specifications. The verification was performed at the request of the QC inspector John Pagliero and was performed between the 9 Meter and the 13 Meter elevations on the "B" side of the weld joint. These tasks were performed as a preliminary verification.

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B) OBG W13

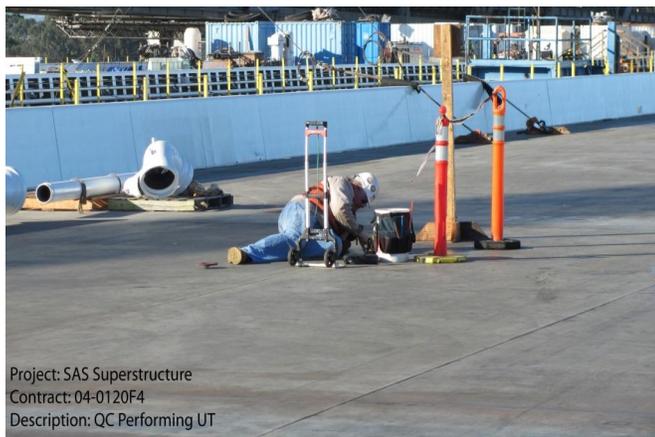
This QAI also observed the lifting, erection and placement of the Orthotropic Box Girder (OBG) W13 which commence at approximately 0600 and concluded at 1330.

C). Document Control Review

This QA Inspector continued the daily review of field inspection reports and update of the field document control tracking records regarding the Orthotropic Box Girders (OBG, Longitudinal and Transverse "A" Deck Stiffeners, Deck Access Holes and the Tower Shear plates. The QAI also updated the tracking records for the pipe welds and the pipe supports.

On this date the QAI commence the review of QA tracking documents for the OBG's identified as E3, E4 and E5.

The digital photographs below illustrate some of the work observed during this scheduled work date.



Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

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: Reyes, Danny

Quality Assurance Inspector

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Reviewed By: Levell,Bill

QA Reviewer