

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

Report No: WIR-026391
Date Inspected: 22-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	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:	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. 10W PP88 W4 Lifting Lug Hole (Exterior)
 2. 12E PP111 E4 Lifting Lug Hole (Exterior)
 3. 11W 12W D1/D2 (Exterior)
 4. 10W PP88 W4 Lifting Lug Hole (Exterior)
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1. 10W PP88 W4 Lifting Lug Hole (Exterior)

The QA inspector observed ABF welder Mike Jimenez ID# 4671 performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on Lifting Lug Hole (LLH) #2 located at 10W PP88 W4. The QA inspector verified the fit up of the joint and found it to be satisfactory. The QA inspector observed the QC inspector identified as Sal Moreno monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU.

The parameters were recorded as (Amperes=145).

The QA inspector made subsequent observations throughout the shift to monitor quality and the QA inspector noted that the work was completed this date and appeared to be in general conformance with the contract documents.

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2. 12E PP111 E4 Lifting Lug Hole (Exterior)

The QA inspector observed ABF welder Jorge Lopez ID# 6149 performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on Lifting Lug Hole (LLH) #4 located at 12E PP111 E4. The QA inspector verified the fit up of the joint and found it to be satisfactory. 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-D15-1050A-CU.

The parameters were recorded as (Amperes=140).

The QA inspector made subsequent observations throughout the shift to monitor quality and the QA inspector noted that the work appeared to be in general conformance with the contract documents.

3. 11W 12W D1/D2 (Exterior)

The QA Inspector noted the dimensions of the indications at D1 y+615 as 125mm's in length, and 8mm's depth, y+725 as 180mm's in length and 12mm's in depth, y+1195 as 100mm's in length and 13mm's depth, y+1445 100mm's in length and 6 mm's deep. D2 y+2515 100mm's in length, 10mm's deep, y+2615 180mm's in length, 25 mm's deep, y+3045 90mm's in length and 6mm's deep. The QA Inspector observed the QC Inspector identified as Jesse Cayabyab perform Magnetic Particle inspection on the excavations and found them to be free of indications. The QA inspector verified that the proper procedure was utilized as well as correct technique. The QA inspector observed ABF welder Wai Kit Lai ID#2953 perform Shielded Metal Arc Welding (SMAW) in the 1G flat 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-R. The QA Inspector noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

4. 10W PP88 W4 Lifting Lug Hole (Exterior)

The QA inspector observed ABF welder Mike Jimenez ID# 4671 performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on Lifting Lug Hole (LLH) #4 located at 10W PP88 W4. The QA inspector verified the fit up of the joint and found it to be satisfactory. The QA inspector observed the QC inspector identified as Sal Moreno monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU.

The parameters were recorded as (Amperes=147).

The QA inspector made subsequent observations throughout the shift to monitor quality and the QA inspector noted that the work was completed this date and appeared to be in general conformance with the contract documents.

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.

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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