

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-026399**Date Inspected:** 26-Sep-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:	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

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:

- 10W PP92 W4 Lifting Lug Hole (Exterior)
- 10W PP92 W4 Lifting Lug Hole (Exterior)
- 4E PP28.2 Pipe Welding (Exterior)
- 7W PP57.5 Pipe Welding (Exterior)

- 10W PP92 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) #3 located at 10W PP92 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=140).

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.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

2. 10W PP92 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 PP92 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=140).

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

3. 4E PP28.2 Pipe Welding (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing Shielded Metal Arc Welding (SMAW) in the 2G horizontal position on 2.5" compressed air valve and 4" domestic water valve located at 4E PP28.2 weld #1/CA2/28/NE and weld #1/DW1/28/NE. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed implementing 6010 electrodes in the root pass with the balance using 7018 electrodes. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general conformance with the contract documents.

4. 7W PP57.5 Pipe Welding (Exterior)

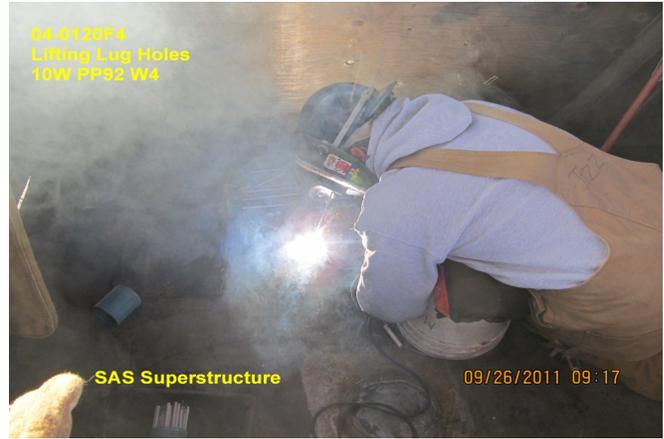
The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing Shielded Metal Arc Welding (SMAW) in the 2F horizontal position on a PS-5 bracket located at 7W PP57.5 weld #110926-01. The QA inspector verified the fit up of the joint and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed using 7018 electrodes. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears 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.

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