

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-026464**Date Inspected:** 03-Oct-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:** 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:

- 12W PP109 Temporary Winch (Exterior)
- 9W PP79 W4 Lifting Lug Hole (Exterior)
- 9W PP80 W4 lifting Lug Hole (Exterior)
- 7W PP49 Pipe Welding (Exterior)
- 7W PP55 Pipe Welding (Exterior)

- 12W PP109 Temporary Winch (Exterior)

The QA inspector observed ABF welder Mike Jimenez ID#4671 performing Flux Core Arc Welding (FCAW) in the 2F horizontal position on 13mm plate to deck for the temporary winch at 12W PP109. The QA inspector verified the layout in accordance with RFI 2569 Revision 0 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 ABF-WPS-D1.5-1-2200-2. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

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2. 9W PP79 W4 Lifting Lug Hole (Exterior)

The QA Inspector noted the dimensions of the excavation on Lifting Lug Hole #4 as y+510 80mm's length, and 11mm's deep. The QA Inspector observed the QC Inspector identified as Pat Swain 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 Mike Jimenez ID#4671 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-Repair. The QA Inspector noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

3. 9W PP80 W4 lifting Lug Holes (Exterior)

The QA Inspector performed a Magnetic Particle Test (MT) on Lifting Lug Hole #4 at 9W PP80 W4. The QA Inspector utilized the MT procedure SE-MT-D1.5-CT-100 Rev. 4 to test 10% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. The QA Inspector noted that the work appeared to be free of defects and was found to be acceptable and in general conformance with the contract documents. Upon completion of the MT, the QA Inspector performed Ultrasonic Testing utilizing a G.E./Krautkramer USN 60. The QA Inspector also utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4 during the examination. Upon completion of the testing, it was noted by the QA Inspector that no indications were present and the work was found to be acceptable.

4. 7W PP49 Pipe Welding (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing Shielded Metal Arc Welding (SMAW) in the 1G flat and 3G vertical positions on 2.5 inch compressed air and 4 inch domestic water valves to schedule 80 pipe located at 7W PP49 welds # 2DW1/49/SW and #2/CA2/49/SW. 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 was completed on this date and appeared to be in general conformance with the contract documents.

5. 7W PP55 Pipe Welding (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing Shielded Metal Arc Welding (SMAW) in the 1G flat and 3G vertical positions on 2.5 inch compressed air and 4 inch domestic water

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valves to schedule 80 pipe located at 7W PP55 welds # 3DW1/55/SW and #3/CA2/55/SW. 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 was completed on 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.



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
