

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-026473**Date Inspected:** 04-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

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 (interior)
- 9W PP79 W4 Lifting Lug Holes (Exterior)
- 8W PP66 Pipe Welding (Exterior)
- 8W PP64 Pipe Welding (Exterior)
- 8W PP61 Pipe Welding (Exterior)
- 12W 13W Fit-Up (Interior)

- 10W PP92 W4 Lifting Lug hole (Exterior)

The QA Inspector noted the dimensions of the excavations of Lifting Lug Hole #4 as y+160 as 110mm's in length, and 12mm's depth, 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

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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.

2. 10W PP92 W4 Lifting Lug hole (interior)

The QA Inspector noted the dimensions of the excavations of Lifting Lug Hole #3 as y+175 as 75mm's in length, and 6mm's depth, 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 PP79 W4 Lifting Lug Holes (Exterior)

The QA Inspector performed a Magnetic Particle Test (MT) on Lifting Lug Holes #1, 3 and 4 at 9W PP79 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. 8W PP66 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 and 4 inch schedule 80 pipe located at 8W PP66 weld #'s 13/2.5/66/SW and 13/4/66/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 is in progress and appeared to be in general conformance with the contract documents.

5. 8W PP64 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 and 4 inch schedule 80 pipe located at 8W PP64 weld #'s 12/2.5/64/SW and 12/4/64/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

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

6. 8W PP61 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” domestic water valve and 4” compressed air valve located at 6W PP43 weld #4DW1/61/SW and weld #4/CA2/61/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 appears to be in general conformance with the contract documents.

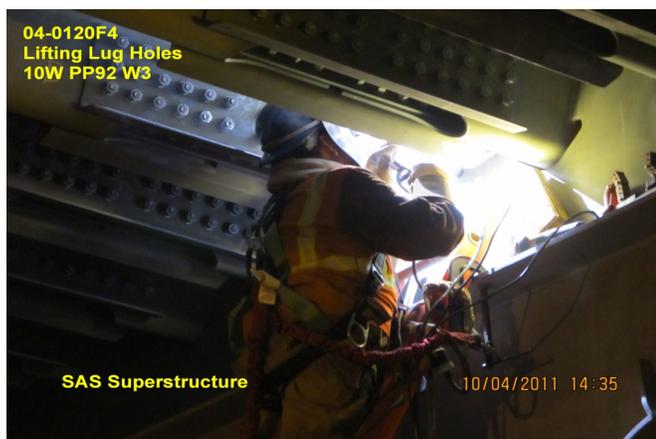
7. 12W 13W Fit-Up (Interior)

The QA inspector performed observation at random intervals of approved ABF welding personnel performing fit-up and Shielded Metal Arc Welding (SMAW) of temporary attachments at the “A” deck plates and “D” bottom plates of 12W/13W segment splices. At these temporary attachment locations the QA has observed arc strikes outside the weld joint at various locations on both the Lift 12 (non SPCM material) and the Lift 13 (SPCM material) sides of these segment splices.

This QA Inspector verbally informed QA SPCM Lead Inspector, Daniel Reyes, of the issues noted in this report for compliance therefore for further details of issues of significance see QA SPCM Lead Inspector, Daniel Reyes, Daily Inspection Report (6031) for this date.

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

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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
