

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-026478**Date Inspected:** 06-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 13W "D" Deck welding (Interior)
- 10W PP92 W4 Lifting Lug Hole (Interior)
- Tower 9 Meters Elevation ESW Repair (Interior)
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The QA inspector observed ABF personnel attempt to remove excess water from bottom plate "D" at 12W 13W on the interior of the OBG. ABF personnel were placed on standby due to inclement weather conditions for four hours when operations were cancelled.

- 10W PP92 W4 Lifting Lug Hole (Interior)

The QA inspector noted that ABF welder Mike Jimenez was placed on standby for four hours due to inclement weather. No welding commenced during this period and ABF personnel were released after the four

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

hour standby.

3. Tower 9 Meters Elevation ESW Repair (Interior)

The QA inspector randomly observed ABF welding personnel Jeremy Dolman utilizing carbon air arc to excavate the majority of the repair followed by grinding using a die grinder on F joint E-045 face "B". The QA inspector noted the dimensions of the excavation as 220mm's in length, 55mm's wide and 40mm's in depth. The QA Inspector observed the QC Inspector identified as John Pagliero 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. Welding did not commence on this date and the QA inspector noted that the work appeared to be in general conformance with the contract documents.

4. Tower 9 Meters Elevation ESW Repair (Interior)

The QA inspector randomly observed ABF welding personnel Fred Kaddu utilizing carbon air arc to excavate the majority of the repair followed by grinding using a die grinder on J joint N-042 face "B". The QA inspector noted the dimensions of the excavation as 85mm's in length, 20mm's wide and 10mm's in depth. The QA Inspector observed the QC Inspector identified as Sal Moreno 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 Fred Kaddu ID#2188 perform Shielded Metal Arc Welding (SMAW) in the 3G vertical 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 Rev. 2. The QA Inspector noted that the work is in progress 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.



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
