

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-026494**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:** Job Site**CWI Name:** See 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:** Tower & OBG**Summary of Items Observed:**

At the start of the shift the Quality Assurance Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) personnel. The inspection was performed as noted below:

A). OBG E12/E13

This QA SPCM Lead Inspector observed the fit-up and planar alignment of the Orthotropic Box Girder (OBG) field splice identified as E12-E13-A utilizing the fitting gear to bring the planar alignment of the "A" deck field splice within acceptable tolerances. The work was performed by Rick Clayborn utilizing the fitting gear and driving the bull pins through eye of the blank nuts. The QC inspection was performed by William Sherwood utilizing a Cambridge Gage to measure planar alignment and a pair of inside calipers, with a digital read out, to measure the root opening. This work was not completed during this shift.

B). OBG W12/W13

This QA SPCM Lead Inspector observed the fit-up and planar alignment of the Orthotropic Box Girder (OBG) field splice identified as W12-W13-A utilizing the fitting gear to bring the planar alignment of the "A" deck field splice within acceptable tolerances. The work was performed by Rick Clayborn utilizing the fitting gear and driving the bull pins through eye of the blank nuts. The QC inspection was performed by William Sherwood utilizing a Cambridge Gage to measure planar alignment and a pair of inside calipers, with a digital read out, to measure the root opening. This work was not completed during this shift.

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C). Review of QA Tracking Plan

This QA Inspector continued the daily review of field inspection reports and update of the field document control tracking records regarding the Orthotropic Box Girders (OBG, Longitudinal and Transverse "A" Deck Stiffeners, Deck Access Holes and the Tower Shear plates. The QAI also updated the tracking records for the pipe welds and the pipe supports.

On this date the QAI commence the review of QA tracking documents for the OBG's identified as E3, E4 and E5.

QA Summary

The welding was performed in the vertical position utilizing the E7018-H4R. The 3.2 mm H4R electrodes were stored in a electrically heated, thermostatically controlled oven after the removal from the sealed containers. The exposure limits of the electrodes appeared to comply with the minimum storage oven temperature of 120 degrees Celsius as per the contract documents. The welding parameters and surface temperatures were verified by the QC inspector's utilizing a Fluke 337 clamp meter to measure the electrical welding parameters and Tempil Heat Indicators for verifying the preheat and interpass temperatures. At the time of the observation no issues were noted by the QAI.

The digital photographs below illustrate some of the work observed during this scheduled shift.



Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

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.

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Inspected By: Reyes,Danny

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer