

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026506**Date Inspected:** 10-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:** OBG and Tower**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 W12/W13 and Piping System (FW Spencer)

This QA Lead Inspector (QALI) assigned QAI, Doug Frey, to observe the Complete Joint Penetration (CJP) welding of the field splice identified as 12W-13W-D. The welding was performed utilizing the Sub-Merged Arc Welding (SAW) as per the Welding Procedure Specification (WPS) ABF-WPS-D15-4042B-1, Rev. 0 which was utilized by the QC Inspector, William Sherwood, as a reference to monitor the welding, verify the welding parameters, the minimum preheat and maximum interpass temperatures. The QAI, Doug Frey also observed and monitored the inspection performed by the QC inspector.

The QAI, Doug Frey, was also assigned to observe the work performed by FW Spencer in regards to the piping systems identified as the compressed air and domestic water. The welding was performed by Curtis Jump utilizing the WPS identified as 1-12-1, Rev. 2 (1.12)

B). OBG E12/E13 and Deck Access Hole (DAH)

This QA Lead Inspector (QALI) assigned QAI, Craig Hager, to observe the Complete Joint Penetration (CJP) welding of the field splice identified as 12W-13W-D. The welding was performed utilizing the Sub-Merged Arc

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Welding (SAW) as per the Welding Procedure Specification (WPS) ABF-WPS-D15-4042B-1, Rev. 0 which was utilized by the QC Inspector, William Sherwood, as a reference to monitor the welding, verify the welding parameters, the minimum preheat and maximum interpass temperatures. The QAI, Craig Hager, also observed and monitored the inspection performed by the QC inspector.

The QAI, Craig Hager, also observed the Complete Joint Penetration (CJP) groove welding of the DAH identified as WN: 8E-PP70.5-E5-NE. The welding was performed by, Salvador Sandoval ID-2202, utilizing the Shielded Metal Arc Welding (SMAW) as per the Welding Procedure Specification (WPS) identified as ABF-WPS-D15-1010, Rev. 1. The QC inspector representing the contractor was Patrick Swain.

C). Tower Shear Plates, Electro-Slag Weld (ESW)

The QA Lead Inspector (QALI) assigned QAI, Joselito Lizardo, to observe the continued excavations, repair welding regarding the Visual Inspection (VT) repairs. This work was performed by the welder Fred Kaddu ID-2188 on the weld joint designated as "F" and identified as WN: E-045. The QC inspection was performed by John Pagliero utilizing the WPS, ABF-WPS-D15-1000 Repair, Rev. 2, as a reference to monitor the welding, verify the welding parameters and the related work in regards to this operation. The welding was not completed during this shift.

This QA Lead Inspector (QALI) also was informed by the QAI, Joselito Lizardo, that two (2) excavations were performed and completed during this shift on the weld joint "F" and identified as WN: E-045. Mr. Lizardo informed this (QALI) Inspector of the dimensions of the excavations and were noted as follows; 1) Y=2480 mm, L=150 mm, W=30 mm and d=13 mm; 2) Y=3380 mm, L=290 mm, W=25 mm and d=17 mm. At the conclusion of this conversation this QALI contacted Cal Trans Structures Representative Saman Soheilifard to attain a verbal approval. Verbal approval to proceed with the welding of the excavations was attained from Mr. Soheilifard on this date.

QAI Lead Inspector Summary

Later in the shift, this QA SPCM Lead Inspector (QALI) also observed the QAI's, Mr. Lizardo, Mr. Frey, Craig Hager and William Clifford monitor the work performed by the QC inspectors and at random intervals observed QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures. At the conclusion of the shift this QA Lead Inspector discussed and reviewed the work performed by QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures as described above. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and AWS D1. 5-Section 12.16, 2002 with no issues were noted on this date. The welding performed at the various work areas was not completed during this shift.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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.

Summary of Conversations:

As noted above.

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:	Reyes,Danny	Quality Assurance Inspector
----------------------	-------------	-----------------------------

Reviewed By:	Levell,Bill	QA Reviewer
---------------------	-------------	-------------