DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026508
Date Inspected: 11-Oct-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1700
Location: Job Site

CWI Name:	As noted 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 Components

Summary of Items Observed:

Quality Assurance Inspector (QA) William Clifford 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:

12E/13E "D" Deck

This QA observed, at random intervals, an ABF/JV qualified welder performing Submerged Arc Welding (SAW) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-4042B-1. Welding was performed at the 35mm butt weld joint (B-U2-S) connecting Lift 12 and Lift 13 "D" bottom plates. Welding operations appeared to be performed from open rib stiffener designated as #17 to open rib stiffener designated #27; approximately 4500mm in length. This weld is not a Seismic Performance Critical Member (SPCM) member.

During welding, ABF Quality Control (QC) Pat Swain was noted monitoring the welding parameters. Welding parameters were recorded as:
D2 section - Jimmy Zhen #6001 – A=580, V=32.2, T=348

Approximately:
13:00- QA recorded SAW flux storage oven temperature to be approximately 300F.

This QA observed, at random intervals, an ABF/JV qualified welder performing Flux Cored Arc Welding w/ Gas (FCAW-G) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3040A-1. Welding was performed at the 28mm butt weld joint (B-U2-S) connecting Lift 12 and

WELDING INSPECTION REPORT

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Lift 13 “D” bottom plates. Welding operations appeared to be performed from Y=1950mm ~ 2400mm; approximately 450mm in length. This weld is not a Seismic Performance Critical Member (SPCM) member.

During welding, ABF Quality Control (QC) Pat Swain was noted monitoring the welding parameters. Welding parameters were recorded as:
D1 section - Wai Kit Lai #2953 – A=269, V=24.9, T=340

This QA verbally informed QA SPCM Lead, Daniel Reyes, of the issues noted in this report for compliance. For further details of issues of significance see QA SPCM Lead, Daniel Reyes, “Daily Inspection Report” (TL-6031) submitted for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:
No relevant conversations.
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 SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford,William	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer