

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-026521**Date Inspected:** 12-Oct-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** American Bridge/Fluor Enterprises, a JV**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" Plate

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=570, V=32, T=349

Approximately:

8:00- 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

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Lift 13 “D” bottom plates. Welding operations appeared to be performed from open rib stiffener designated as #27 to open rib stiffener designated #29; approximately 700mm 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=279, V=24.7, T=420

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)

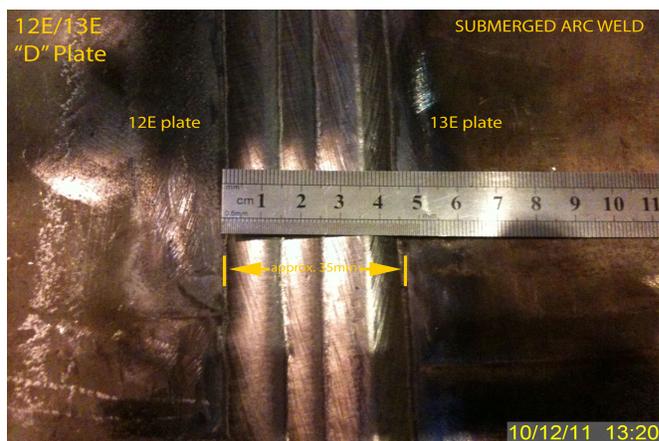
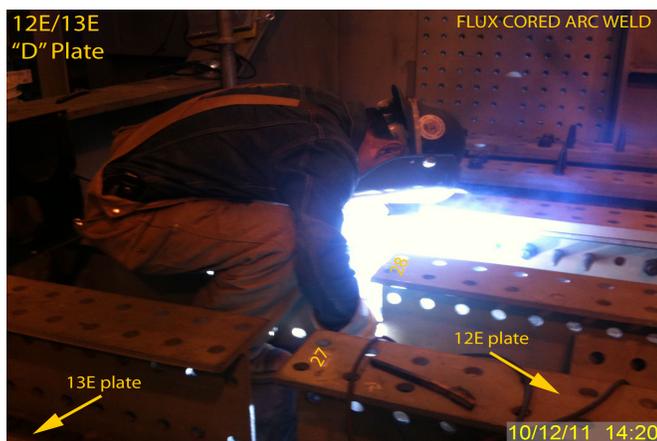
ABF-WPS-D15-3040A-1. Welding was performed at the 28mm butt weld joint (B-U2-S) connecting Lift 12 and Lift 13 “D” bottom plates. This weld is not a Seismic Performance Critical Member (SPCM) member.

During welding, ABF Quality Control (QC) Pat Swain was noted monitoring the welding parameters. Welding parameters were recorded as:

D3 section - Wai Kit Lai #2953 – A=265, V=24.5, T=343

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.

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