

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-026528
Date Inspected: 13-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: 1730
Location: Jobsite

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:	SAS OBG	

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:

1. 8W PP67 Pipe Welding (Exterior)
2. 12W 13W D2 Welding (Interior)
3. 9W PP73 Pipe Welding (Exterior)
4. 12W 13W D1 Welding (Interior)
5. 12W 13W D3 Welding (Interior)

1. 8W PP67 Pipe Welding (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing Shielded Metal Arc Welding (SMAW) in the 2G horizontal position on 4" domestic water valve and 2.5" compressed air valve located at 8W PP67 weld #1/DW1/67/SW and weld #1/CA2/67/SW. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed implementing 6010 electrodes in the root pass with the balance using 7018 electrodes. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general conformance with the contract documents.

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2. 12W 13W D2 Welding (Interior)

The QA inspector randomly observed ABF welding operator Rory Hogan ID#3186 performing Submerged Arc Welding (SAW) on "D2" at 12W 13W of the OBG. The QA inspector observed the QC inspector identified as William Sherwood monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-4042 B-1. The parameters were recorded as (A=560/V=32.5/TS=395/HI=2.76). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

3. 9W PP73 Pipe Welding (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing Shielded Metal Arc Welding (SMAW) in the 2G horizontal position on 4" domestic water valve and 2.5" compressed air valve located at 9W PP73 weld #1/DW1/73/SW and weld #1/CA2/73/SW. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed implementing 6010 electrodes in the root pass with the balance using 7018 electrodes. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general conformance with the contract documents.

4. 12W 13W D1 Welding (Interior)

The QA inspector randomly observed ABF welding operator Rory Hogan ID#3186 performing Submerged Arc Welding (SAW) on "D1" at 12W 13W of the OBG. The QA inspector observed the QC inspector identified as William Sherwood monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-4042 B-1. The parameters were recorded as (A=560/V=32.5/TS=400/HI=2.75). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

5. 12W 13W D3 Welding (Interior)

The QA inspector randomly observed ABF welding operator Richard Garcia ID#5892 performing Flux Core Arc Welding with Gas (FCAW-G) on "D3" at 12W 13W of the OBG. The QA inspector observed the QC inspector identified as William Sherwood monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3040 A-1. The parameters were recorded as (A=295/V=25/TS=340/HI=1.30). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

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Note: The QAI reviewed the observations and inspection with QA Lead Inspector, Daniel Reyes, written in this report. No issues were noted by the QAI and the QA Lead Inspector concurs with the QA report.

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.



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
