

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026529**Date Inspected:** 14-Oct-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**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. 9W PP79 Pipe Welding (Exterior)
2. 12W 13W D3 Welding (Interior)
3. 9W PP81 Pipe Welding (Exterior)
4. 12W 13W E1/E2 Fit Up (Interior)
5. 12W 13W F Plate Fit Up (Exterior)

1. 9W PP79 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 PP79 weld #1/DW1/79/SW and weld #1/CA2/79/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 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=250/V=22/TS=325/HI=1.01). 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 PP81 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 PP81 weld #22/2.5/81/SW and weld #22/4/81/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 E1/E2 Fit Up (Interior)

This QA performed observation at random intervals of approved ABF welding personnel performing fit-up and Shielded Metal Arc Welding (SMAW) of temporary attachments at the “E” plate of 12W/13W segment splice. In conjunction with QC William Sherwood this QA performed a visual survey of joint fit-up for the 22mm to 18mm thick section of the “E” plate of 12W/13W segment splice. In addition, this QA and QC Sherwood also measured the planar offset of this section of the joint. All areas of measurement were noted to be within 3mm or less.

5. 12W 13W F Plate Fit Up (Exterior)

This QA performed observation at random intervals of approved ABF welding personnel performing fit-up and Shielded Metal Arc Welding (SMAW) of temporary attachments at the “F” plate of 12W/13W segment splice. In conjunction with QC William Sherwood this QA performed a visual survey of joint fit-up for the 18mm thick section of the “F” plate of 12W/13W segment splice. In addition, this QA and QC Sherwood also measured the planar offset of this section of the joint. All areas of measurement were noted to be within 3mm or less with the exception of the following;

Y=130mm-180mm – offset = 4mm.

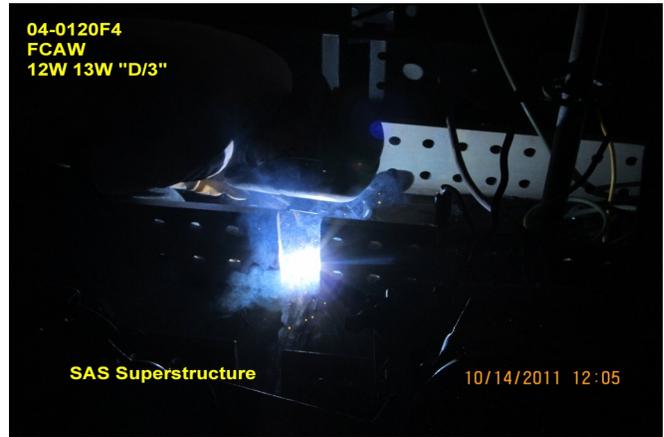
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Note: The QAI reviewed the observations and inspection with QA Lead Inspector, Daniel Reyes, written in this report. No issues were noted by the QAI and the QA Lead Inspector concurs with the QA report.

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.

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| Inspected By: | Frey,Doug | Quality Assurance Inspector |
| Reviewed By: | Levell,Bill | QA Reviewer |
