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-026548
Date Inspected: 19-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. 7E PP57 Pipe Welding (Exterior)
2. 12W 13W Edge Plate “F/A” Transition Welding (Exterior)
3. 12W 13W Side Plate E2 Welding (Interior)
4. 12W 13W Side Plate C2 Welding (Interior)
5. 10W PP85Pipe Welding (Exterior)

1. 7E PP55 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 pipe and 2.5” compressed air pipe located at 7E PP57 weld #7/2.5/57/NE and weld #7/4/57/NE. 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 Sal Moreno 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.

2. 12W 13W Edge Plate “F/A” Transition Welding (Exterior)

The QA inspector randomly observed ABF welding operator Jorge Lopez ID#6149 performing Flux Core Arc Welding-Gas (FCAW-G) on edge plate F to deck plate A transition at 12W 13W of the OBG. The QA inspector observed the QC inspector identified as Fred Von Hoff monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3040B-3. The parameters were recorded as (A=240/V=24/TS=245/HI=1.41). 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. 12W 13W Side Plate E2 Welding (Interior)

The QA inspector randomly observed ABF welding operator Rory Hogan ID#3186 performing Flux Core Arc Welding with gas (FCAW-G) utilizing a “Bug-O” motorized rail system with a magnetic base attached in the 3G vertical position on side plate E2, at 12W 13W of the OBG. The QA inspector observed the QC inspector identified as Fred Von Hoff monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3042B-1. The parameters were recorded as (A=230/V=24/TS=250/HI=1.32). 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.

4. 12W 13W Side Plate C2 Welding (Interior)

The QA inspector randomly observed ABF welding operator Jeremy Dolman ID#5042 performing Flux Core Arc Welding with gas (FCAW-G) in the 3G vertical position on side plate C2, at 12W 13W of the OBG. The QA inspector observed the QC inspector identified as Fred Von Hoff monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3042B-1. The parameters were recorded as (A=230/V=23.3/TS=250/HI=1.28). 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.

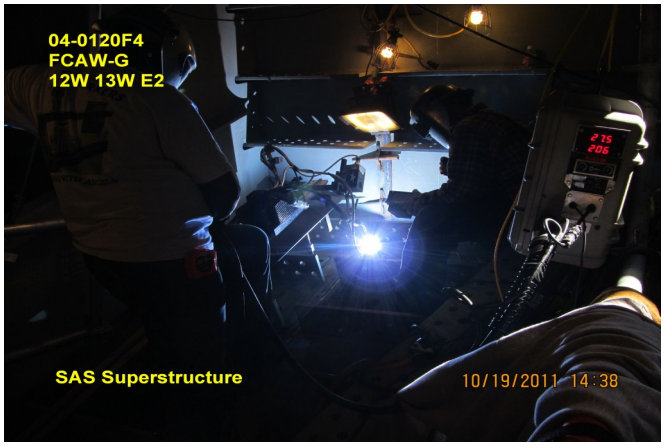
5. 10W PP85Pipe Welding (Exterior)

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 10W PP85 weld #1/DW1/85/SW and weld #1/CA2/85/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.

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