

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 #: 1x.28**WELDING INSPECTION REPORT**

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

Report No: WIR-026577
Date Inspected: 26-Oct-2011

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

OSM Arrival Time: 630
OSM Departure Time: 1530
Location: On Site

CWI Name:	Freddie Von Hoff	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 Sections	

Summary of Items Observed:

This Quality Assurance (QA) Inspector, Art Peterson arrived on site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and monitor the welding operations performed by American Bridge Fluor (ABF) welding personnel. The following observations were:

This QA Inspector randomly observed ABF welder Mr. Dan Ieraci (Welder ID 3232) performing the welding operation per the Submerged Arc Welding (SAW) process in the (1G) flat position on OBG deck plate section 13E / 14E at weld location A2.2 ~ A5. This QA Inspector observed QC Inspector Mr. Freddie Von Hoff verify that the preheat temperature was at the minimum of 150 Degrees F and that the welding parameters (Amps, Volts, and Travel Speed) were in accordance with WPS 4042B-1. This QA Inspector observed the welding parameters were recorded as follows: (Amps = 556; Volts = 32.5 and Travel Speed = 432 mm / minute. The welding parameters observed at this location appeared to be in general compliance with approved WPS and the contract specifications. Note: Prior to the start of the welding operation in which ABF welding personnel were setting up to weld at two locations for weld sequencing, this QA Inspector observed that the ABF welding personnel were experiencing a power outage and were unable to utilize two welding personnel to weld the deck plate section per the SAW process for the purpose of weld sequencing. ABF Welding Superintendent Mr. Dan Ieraci made the decision after approximately one hour to only utilize one welder to perform the welding operations at the aforementioned locations.

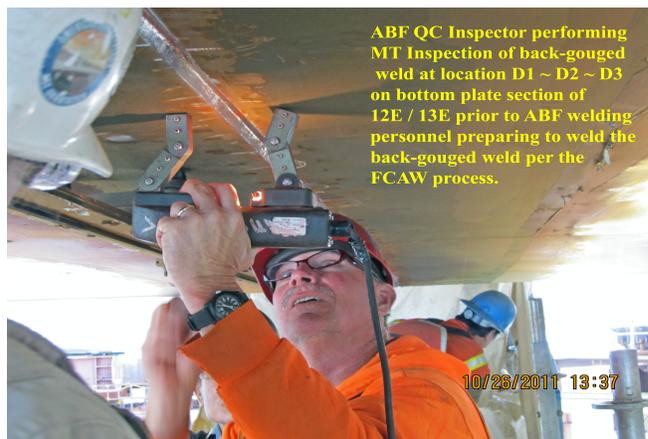
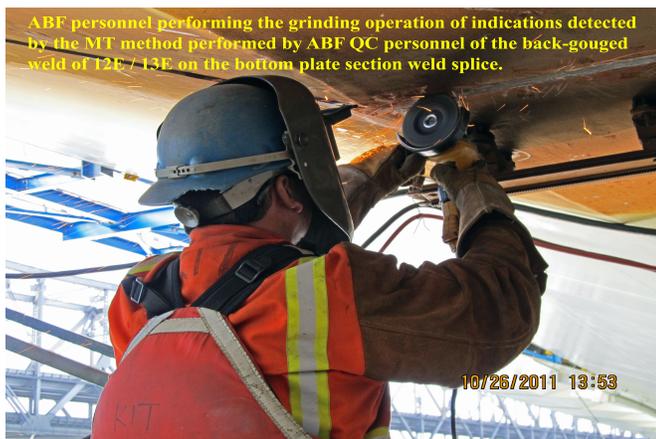
This QA Inspector randomly observed QC Inspectors' Mr. Pat Swain and Mr. John Pagliero performing the Magnetic Particle Test (MPT) inspection per the (dry method) using a calibrated Yoke after the back gouge

WELDING INSPECTION REPORT

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operation was completed and the weld was ground to bright metal on the outside of bottom plate section 12E / 13E at weld locations D1 = 2400 mm; D2 = 8500 mm and D3 = 2400 mm. This QA Inspector observed that there were areas marked up by the QC Inspectors for the ABF personnel to perform the grinding operations on these areas where indications were detected by the MPT method. After the re-inspection was performed after the grinding operations of the marked up locations, Mr. Pat Swain informed this QA Inspector that the MPT inspection performed on the back-gouged weld at the aforementioned locations was acceptable for the ABF welding personnel to start to set up their equipment and shielding to complete the welding operation on the bottom plate section of 12E / 13E. The set up of the weld operation was in-process at the end of this QA Inspectors Shift.

The observations made on this date appeared to be in general compliance with the contract specifications.



Summary of Conversations:

This QA Inspector had general conversations with ABF and QC personnel and no significant conversations were reportable on this date.

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: Peterson, Art

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer