

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-026600
Date Inspected: 27-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:

- 12W 13W (Exterior)
- 11W PP100 W4 (Exterior)

- 12W 13W (Exterior)

The QA inspector randomly observed ABF welding personnel setting up to continue welding operations on Side Plate "E" on the exterior of the OBG at 12W 13W. The QA inspector witnessed one of the heat induction blankets used for preheating of the weld smoking and burning up. The QA inspector notified the ABF personnel and the blanket was removed, replaced and welding operations commenced. 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 4G overhead position. The QA inspector observed the QC inspector identified as John Pagliero monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3110-4. The parameters were noted as (A=250/V=23/TS=160/HI=2.15). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appeared to be in general conformance to the contract requirements.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The QA inspector observed ABF welding operator Jeremy Dolman ID# 5042 setting up a 2nd Plasma Arc gouging machine (ESAB) with no success. ABF welding personnel made alterations to the equipment to operate manually and cutting commenced on this date. The QA inspector randomly monitored the operator removing the backing bar from the weld on the bottom plate "D" on the exterior of the OBG. The QA inspector made subsequent observations throughout the shift to monitor quality and the QA inspector noted that the work was in progress and appeared to be in general conformance with the contract documents.

2. 11W PP100 W4 (Exterior)

The QA inspector observed ABF welder Jorge Lopez ID# 6149 performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on Lifting Lug Hole (LLH) #3 located at 11W PP100 W4. The QA inspector observed the QC inspector identified as Pat Swain monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU.

The parameters were recorded as (Amperes=135).

The QA inspector made subsequent observations throughout the shift to monitor quality and the QA inspector noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

The QA inspector observed ABF welder Jorge Lopez ID# 6149 performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on Lifting Lug Hole (LLH) #1 located at 11W PP100 W4. The QA inspector monitored and verified the fit up of the joint and found it to be satisfactory. The QA inspector observed the QC inspector identified as Pat Swain monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU.

The parameters were recorded as (Amperes=134).

The QA inspector made subsequent observations throughout the shift to monitor quality and the QA inspector noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

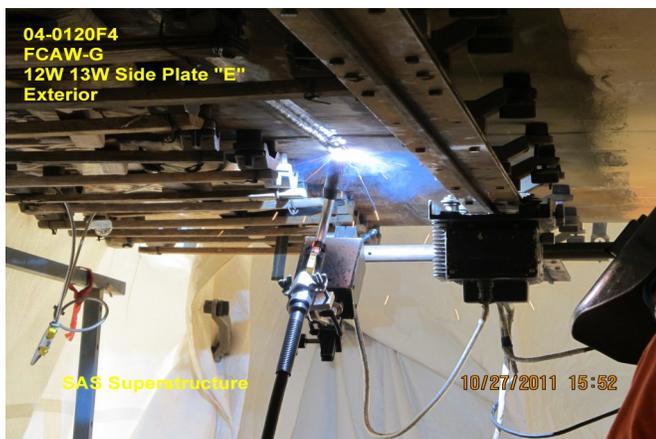
Note: The QAI reviewed the observations and inspection with QA Lead Inspector, Daniel Reyes, written in this report. No issues were noted by the QAI and the QA Lead Inspector concurs with the QA report.

Summary of Conversations:

At the beginning the shift the QA inspector met with QC inspector John Pagliero and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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