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-026618
Date Inspected: 01-Nov-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: 1530
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. 11W PP101 W4 Lifting Lug Holes #4 and 2 (Exterior)
2. 11W PP100 W3 Lifting Lug Holes #3 and 2 (Exterior)

1. 11W PP101 W4 Lifting Lug Hole #4 (Exterior)

The QA inspector observed the QC inspector identified as John Pagliero measure the planar offset of the lifting lug hole insert as well as the root gap of the joint and the QA inspector verified that both were within tolerance and in accordance with ABF-WPS-D15-1050A-CU. The QA inspector observed ABF welder Jorge Lopez ID# 6149 preheat the joint to 50°F prior to performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on Lifting Lug Hole (LLH) #4 located at 11W PP101 W4. The QA inspector observed the QC inspector 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 randomly observed the ABF welder grind and blend the start and stop areas of the weld throughout the joints depth. The QA inspector made subsequent observations throughout the shift to monitor quality and the QA inspector noted that the work on the exterior side of the LLH was completed on this date and appeared to be in general conformance

with the contract documents.

11W PP101 W4 Lifting Lug Hole #2 (Exterior)

The QA inspector observed the QC inspector identified as John Pagliero measure the planar offset of the lifting lug hole insert as well as the root gap of the joint and the QA inspector verified that both were within tolerance and in accordance with ABF-WPS-D15-1050A-CU. The QA inspector observed ABF welder Jorge Lopez ID# 6149 preheat the joint to 50°F prior to performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on Lifting Lug Hole (LLH) #2 located at 11W PP101 W4. The QA inspector observed the QC inspector 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 randomly observed the ABF welder grind and blend the start and stop areas of the weld throughout the joints depth. The QA inspector made subsequent observations throughout the shift to monitor quality and the QA inspector noted that the work on the exterior side of the LLH was completed on this date and appeared to be in general conformance with the contract documents.

2. 11W PP100 W3 Lifting Lug Hole #3 (Exterior)

The QA inspector observed the QC inspector identified as John Pagliero measure the planar offset of the lifting lug hole insert as well as the root gap of the joint and the QA inspector verified that both were within tolerance and in accordance with ABF-WPS-D15-1050A-CU. The QA inspector observed ABF welder Mike Jimenez ID# 4671 preheat the joint to 50°F prior to performing SMAW in the 1G flat position on LLH #3 located at 11W PP100 W3. The QA inspector observed the QC inspector 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 randomly observed the ABF welder grind and blend the start and stop areas of the weld throughout the joints depth. The QA inspector made subsequent observations throughout the shift to monitor quality and the QA inspector noted that the work on the exterior side of the LLH was completed on this date and appeared to be in general conformance with the contract documents.

11W PP100 W3 Lifting Lug Hole #2 (Exterior)

The QA inspector observed the QC inspector identified as John Pagliero measure the planar offset of the lifting lug hole insert as well as the root gap of the joint and the QA inspector verified that both were within tolerance and in accordance with ABF-WPS-D15-1050A-CU. The QA inspector observed ABF welder Mike Jimenez ID# 4671 preheat the joint to 50°F prior to performing SMAW in the 1G flat position on LLH #2 located at 11W PP100 W3. The QA inspector observed the QC inspector monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The parameters were recorded as (Amperes=136). The QA inspector randomly observed the ABF welder grind and blend the start and stop areas of the weld throughout the joints depth. The QA inspector made subsequent observations throughout the shift to monitor quality and the QA inspector noted that the work on the exterior side of the LLH was in progress 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.

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