

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 #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026630**Date Inspected:** 03-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Pat Swain**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 Segments**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 by this QA Inspector were:

OBG Bottom Plate Section "D2" on Segment 13W ~ 14W:

This QA Inspector randomly observed ABF welder Mr. James Zhen (Welder ID 6001) performing the fill and cover pass weld operation per the Submerged Arc Welding (SAW) process in the (1G) position on the inside of OBG Bottom Plate "D2" plate section. This QA Inspector observed QC Inspector Mr. Pat Swain verify prior to the start of welding that the welding parameters and preheat temperature were in accordance with WPS-4042B-1. This QA Inspector also verified that the preheat temperature of the groove weld and surrounding base metal were at the minimum preheat temperature of 200 degrees F. The fill and cover pass weld operation was completed at the end of this QA Inspectors' shift on the inside of OBG Bottom Plate "D2" section approximately between "Y" location 1830 mm to approximately "Y" location 6670 mm at the field splice location of OBG Segment 13W ~ 14W. Afterwards, ABF personnel removed the bolted angle plate stiffeners between the I-Ribs across "D2" field weld splice so ABF welder Mr. James Zhen (Welder ID 6001) could proceed to set-up the SAW tracks and welding equipment in preparation to perform the SAW process in the (1G) position approximately between "Y" location 525 mm to approximately 1830 mm. This QA Inspector observed at 1530 hours that Mr. James Zhen started the fill and cover pass weld operation per the SAW process in the 1G position. This QA Inspector observed QC Inspector Mr. Pat Swain re-verify that the welding parameters and preheat temperature were in accordance with WPS-4042B-1 prior to the start of the welding operation. The fill pass weld operation was still in-process at the

WELDING INSPECTION REPORT

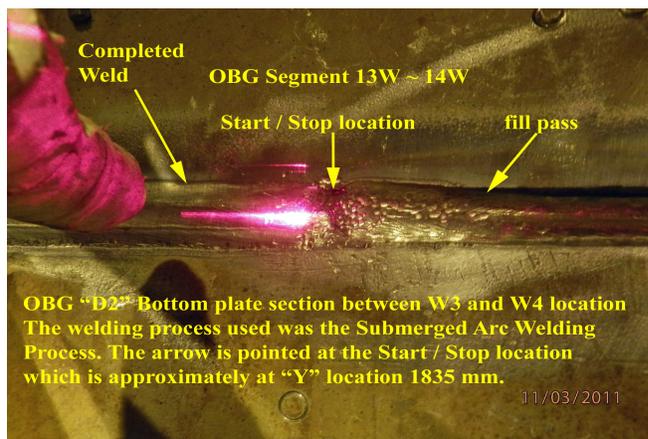
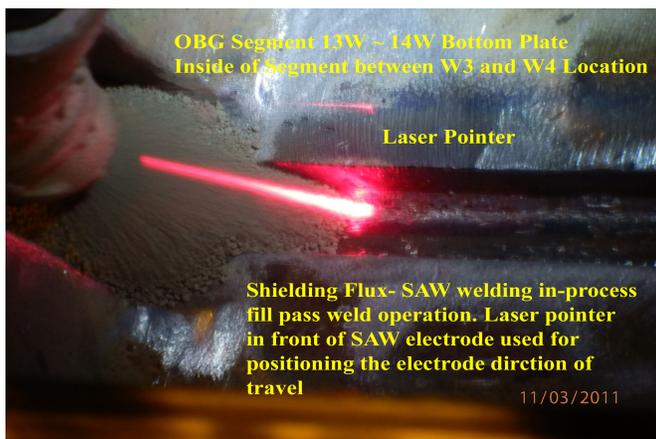
(Continued Page 2 of 2)

end of this QA Inspectors' shift.

OBG Deck Plate Section "A2 ~ A5" on Segment 13W ~ 14W:

This QA Inspector randomly observed ABF welders' Mr. Xiao Jian Wan (Welder ID 9667) and Mr. Wai Kitlai (Welder ID 2953) performing the Flux Cored Arc Welding (FCAW) process root pass "seal" weld operation in the (1G) flat position on OBG Deck "A2 ~ A5" field weld splice location. This QA Inspector observed QC Inspector Mr. Pat Swain verify prior to the start of the welding operation that the welding parameters for the aforementioned welders were in accordance with WPS-3200-2. This QA Inspector verified prior to the start the root pass operation that the preheat temperature of the groove weld and surrounding base metal were at the minimum preheat temperature of 150 degrees F and the welding parameters (Amps, Volts, and Travel Speed) were in accordance with the aforementioned WPS. The root pass weld operation was completed on this date and both of the ABF welders' were directed to move to a different work location by ABF Welding Superintendent Mr. Dan Ieraci.

The welding performed at the locations noted above appeared to be in general compliance with the applicable WPS and the contract specifications.



Summary of Conversations:

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