

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-026640**Date Inspected:** 05-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** John Pagliero**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 on this date were:

OBG Deck Plate Lifting Lug Holes (LLH) on Segment 11W:

This QA Inspector randomly observed ABF welder Mr. Jorge Lopez (Welder ID 6149) performing the fit-up operation of LLH insert plate #1 and insert plate #3 on the exterior side of OBG 11W at Panel Point (PP) 104 LLH insert plate #1 and insert plate #3 (11WPP104W4-LLH-1 and 11WPP104W4-LLH-3). The thickness of the LLH insert plates were 20 mm. Afterwards, this QA Inspector observed ABF QC Inspector Mr. John Pagliero perform the offset measurement and root-gap measurement after ABF welder Mr. Lopez completed the fit-up operation on the LLH insert plates of LLH #1 and LLH #3. The offset and root gap inspection results were in compliance with the contract specifications and WPS-1050A-CU.

Afterwards, this QA Inspector observed ABF welder Mr. Lopez perform the root, fill and cover pass weld operation per the Shielded Metal Arc Welding (SMAW) process in the (1G) flat position on LLH insert plate #1. This QA Inspector observed QC Inspector Mr. Pagliero verify prior to the start of the root pass weld operation that the welding parameters (Amps, Volts and Travel Speed) and the preheat temperature were in accordance with WPS-1050A-CU.

This QA Inspector observed that ABF welder Mr. Lopez completed the root, fill and cover pass weld operation on the exterior side only of LLH insert plate #1 and completed the root pass weld operation on the exterior side only of LLH insert plate #3. On LLH insert plate #1 the interior side welding will be performed at a later date.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

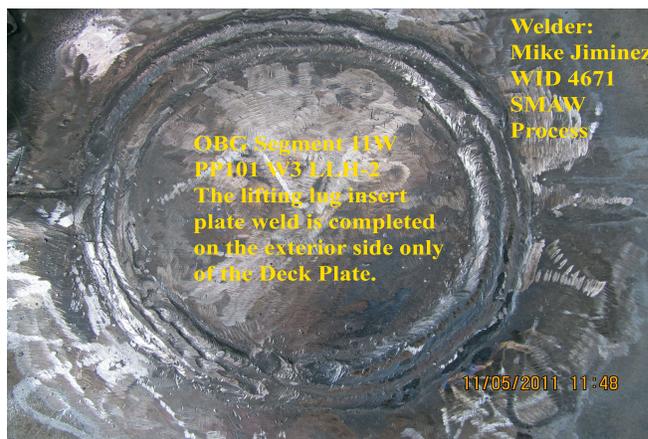
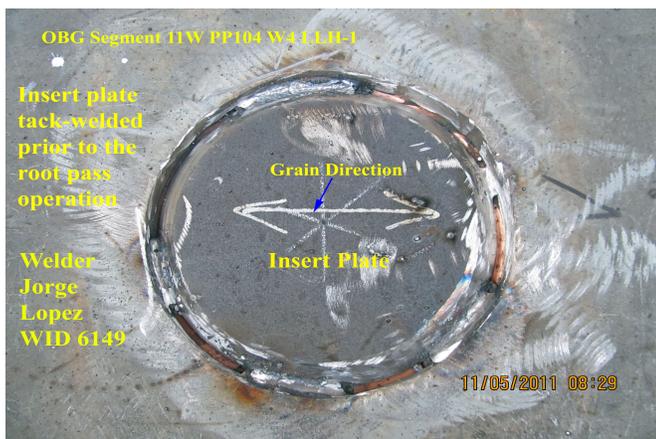
OBG Deck Plate Lifting Lug Holes (LLH) on Segment 11W:

This QA Inspector randomly observed ABF welder Mr. Mike Jiminez (Welder ID 4671) performing the fit-up operation of LLH insert plate #2 and insert plate #4 on the exterior side of OBG 11W at Panel Point (PP) 101 LLH insert plate #2 and insert plate #4 (11WPP101W3-LLH-2 and 11WPP101W3-LLH-4). The thickness of the LLH insert plates were 20 mm. Afterwards, this QA Inspector observed ABF QC Inspector Mr. John Pagliero perform the offset measurement and root-gap measurement after ABF welder Mr. Jiminez completed the fit-up operation on the LLH insert plates of LLH #2 and LLH #4. The offset and root gap inspection results were in compliance with the contract specifications and WPS-1050A-CU.

Afterwards, this QA Inspector observed ABF welder Mr. Jiminez perform the root, fill and cover pass weld operation per the Shielded Metal Arc Welding (SMAW) process in the (1G) flat position on LLH insert plate #2. This QA Inspector observed QC Inspector Mr. Pagliero verify prior to the start of the root pass weld operation that the welding parameters (Amps, Volts and Travel Speed) and the preheat temperature were in accordance with WPS-1050A-CU.

This QA Inspector observed that ABF welder Mr. Jiminez completed the root, fill and cover pass weld operation on the exterior side only of LLH insert plate #2 and completed the root pass weld operation on the exterior side only of LLH insert plate #4. On LLH insert plate #2, the interior side welding will be performed at a later date.

The welding operation observed on this date appeared to be in general compliance with WPS-1050A-CU 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