

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-026701
Date Inspected: 13-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
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A
Component: SAS OBG

Bridge No: 34-0006**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. 13W/14W/D1 FCAW-G (Interior)
2. 12W/13W/F (Exterior)
3. 13W/14W/D1 SAW (Interior)

1. 13W/14W/D1 FCAW-G (Interior)

This QA Inspector randomly observed ABF welder Jeremy Dolman (Welder ID 5042) performing the Flux Core Arc Welding-Gas (FCAW-G) process in the (1G) flat position on the "D1" pick-up (transition point to D2 not accessible with SAW equipment) located at 13W/14W on the interior of the OBG. The Seismic Performance Critical Member (SPCM) joint being welded has a single V-groove butt joint with backing bar that will be removed and then back welded. This QA Inspector observed QC Inspector Steve Jensen verify that the preheat temperature was at the minimum of 93 degrees C and that the welding parameters ($A=260/V=23.7$) were in accordance with ABF-WPS-D15-3040A-1. Due to the short run of the pick-up, an accurate travel speed could not be achieved. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was completed on this date and appeared to be in general compliance with the approved WPS and the contract specifications.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

2. 12W/13W/F (Exterior)

This QA Inspector randomly observed ABF welder Fred Kaddu performing the back-gouge operation of ultrasonic rejectable indications on OBG edge plate “F” section 12W /13W located at Y= 820 mm: (25 mm wide; 90 mm length; and 14 mm in depth), Y= 1365 mm: (25 mm wide; 100 mm length; and 8 mm in depth), Y= 1495 mm: (25 mm wide; 150 mm length; and 9 mm in depth), Y= 1735 mm: (25 mm wide; 85 mm length; and 8 mm in depth).

3. 13W/14W/D1 SAW (Interior)

This QA Inspector randomly observed ABF welding operator Rory Hogan (ID3186) performing Submerged Arc Welding (SAW) on “D1” at 13W/14W of the OBG. The Seismic Performance Critical Member (SPCM) joint being welded has a single V-groove butt joint with backing bar that will be removed and then back welded. This QA Inspector observed QC Inspector Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-4042 B-1. The parameters were recorded as (A=550/V=32.5/TS=400/HI=2.68). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

13W/14W/I (Interior)

This QA Inspector observed at random intervals ABF welding personnel Rick Clayborn and Ian Murphy fit up and install a backing bar on the interior joint of edge Plate “I” at 13W/14W of the OBG. Upon completion of the installation, this QA Inspector noted that no welding was performed.

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:

The were no pertinent conversations to report.



Comments

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
