

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-026702**Date Inspected:** 13-Nov-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See 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:** OBG**Summary of Items Observed:**

At the start of the shift this Quality Assurance Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Douglas Frey-OBG W12/W13-F1(Repair Welding), W13/W14("D1" Bottom & "I" Vertical Plates-SPCM).

Joselito Lizardo-OBG E13/E14 ("D1" Bottom & "I" Plates-SPCM), OBG E12/E13(Excavation & Repair Welding) & MPT of F1 Edge Plate @ OBG E12/E13.

Joe Lanz- OBG E14 & W14(Lifting Lug & Ventilation Holes-SPCM), QC/UT & QA/UT Verification @ OBG E14(Lifting Lug & Ventilation Holes-SPCM).

Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, Douglas Frey and Art Peterson monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in

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regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and no issues were noted on this date. For additional information see Summary of Conversations on page xxxxx of this report.

For additional detailed information see the individual, submitted and approved, QA TL-6031 Weld Inspection Reports (WIR) and QA TL-6027 Ultrasonic Test Reports (UTR).

This QA Inspector continued the daily review of field inspection reports and update of the field document control tracking records regarding the Orthotropic Box Girders (OBG, Longitudinal and Transverse "A" Deck Stiffeners, Deck Access Holes and the Tower Shear plates).

Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

The QAI, Joe Lanz, contacted this QALI in regards to the grinding of excavations utilizing the Air Carbon Arc (ACA) method. Evidently the repair welding personnel was not aware that all excavations require the grinding of the gouged surface to a bright metal. This QALI informed Mr. Lanz to remind the ABF welding personnel that they need to contact the QC inspector assigned to this area to acquire this information. QALI Note: The approved WPS (ABF-WPS-D1.5-1000 Repair, Rev. 2) utilized also states that grinding of excavations shall be performed prior to MPT which is also a requirement per the contract document AWS D1.5-2002, Chapter 3, Para. 3.2.6.

Later in the shift this QALI had a conversation with the QC inspector in regards to this issue. The QC inspector informed and presented the repair WPS utilized during the repair welding. The QC inspector informed this QALI that the contents of the WPS noted above in regards to the grinding issue was being utilized during the repair welding. The on-site corrective action taken by the QC inspector appeared to be satisfactory.

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:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
