

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: 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-026747
Date Inspected: 16-Nov-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 600
OSM Departure Time: 1630
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 Lead 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-F (Repair Welding), OBG W12/W13-C1.2-C2 (QA/UT Verification) OBG W14(Welding of Ventilation Holes).

Joselito Lizardo-OBG E13/E14 ("D1" Bottom Plate), OBG W12/W13-C (QA/MPT Verification), OBG E14 (QA/MPT Verification and Welding of Ventilation Holes). For additional information See QALI Summary Art Peterson-field review of TC-RFI-0503 RO, Item 3831 and design punch list item of Submittal 964R2.

Craig Hager-OBG E14 (Lifting Lug & Ventilation Holes, field fit-up, welding and QA/NDT Verification), and FW Spencer at the South Tower Shaft (Fit-up and welding of piping).

William Clifford-OBG W13/W14 ("D1" Bottom, "H" Bottom Side Plate), OBG E14 and W14 (Lifting Lug and Ventilation Holes).

Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, Douglas Frey, Art Peterson, Craig Hager and William Clifford monitor the work performed by the QC inspectors at random intervals and also

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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 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.

Issue

Upon review, it was discovered that the welder, Todd Jackson ID-4639, had performed welding on four (4) ventilation holes identified as 14E-PP125.2-E5, 14E-PP125.2-E4.2, 14E-PP126.7-E5 and 14E-PP126.7-E4.2. Mr. Jackson is not qualified to weld on Seismic Performance Critical Members (SPCM). In conversation with the QC Lead Inspector, Bonifacio Daquinag, Jr., he commented that the QC department would generate a Non-Conformance Report (NCR). An incident report, TL-015, will follow.

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.

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
