

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-026797**Date Inspected:** 02-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**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:

- 14W/PP125.2/W5 Vent Hole (Exterior)
- 14W/PP126.2/W2.4 Vent Hole (Interior)
- 14W/PP126.7/W2.5 Vent Hole (Interior)

Orthotropic Box Girder (OBG) section: The QC Documents observed being used by this QA Inspector for the following weld joints appeared to be designated as Seismic Performance Critical Members (SPCM).

- 14W/PP125.2/W5 Vent Hole (Exterior)

This QA Inspector randomly observed QC Inspector Sal Merino measure the pre-heat temperature of the B-U-4a Complete Joint Penetration (CJP) weld on vent hole 14W/PP125.2/W5. This QA Inspector observed ABF welder Jorge Lopez perform the Shielded Metal Arc Welding (SMAW) process utilizing E7018-H4R electrodes in the (1G) flat position. This QA Inspector observed the QC Inspector monitor the welding and the parameters to ensure conformance with ABF-WPS-D15-1050A-CU. This QA Inspector made periodic observations to monitor quality and noted that the work was completed on this date and appeared to be in general conformance with the contract specifications.

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Tower Survey

This QA Inspector performed a progress survey of the exterior and interior Electro-Slag Welding (ESW) on the Tower at the 9 m level and the 13 m level as directed by QA Lead Inspector, Daniel Reyes.

Magnetic Particle Testing (QC)

This QA Inspector randomly observed QC Inspector Sal Merino perform a final Magnetic Particle (MT) inspection of the completed weld area on OBG "A" deck vent hole section 14W/PP126.2/W2.6. This QA Inspector observed that Mr. Merino found no rejectable indications and the work appeared to be in general conformance with the contract specifications.

Ultrasonic Testing (QA)

This QA Inspector performed Ultrasonic Testing (UT) on approximately 50% of the lifting lug hole welds at 14W/PP128/W3-W1, W2 and W4. These welds were previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. This QA observed no rejectable indications at the time of testing. This QA generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

2. 14W/PP126.2/W2.4 Vent Hole (Interior)

This QA Inspector randomly observed ABF welder Mike Jimenez (ID 4671) perform back-gouge operations on face "B" of the vent hole located at 14W/PP126.2/W2.4 on the interior of the OBG. This QA Inspector observed QC Inspector Sal Merino perform Magnetic Particle Testing (MT) testing on the back gouge to ensure the soundness of the metal. This QA Inspector randomly observed the welder perform SMAW in the (4G) overhead position with the QC Inspector monitoring the welding to ensure the parameters were in accordance with ABF-WPS-D15-1110A-Revision 1. This Q 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 accordance with the contract documents.

3. 14W/PP126.7/W2.5 Vent Hole (Interior)

This QA Inspector observed QC Inspector Sal Merino perform Magnetic Particle Testing (MT) testing on the back gouge of face "B" on vent hole 14W/PP126.7/W2.5 to ensure the soundness of the metal. This QA Inspector randomly observed ABF welder Mike Jimenez perform SMAW in the (4G) overhead position utilizing 3.8mm E7018-H4R electrodes. This QA Inspector observed the QC Inspector monitoring the welding to ensure the parameters were in accordance with ABF-WPS-D15-1110A-Revision 1. This Q 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 accordance with the contract documents.

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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

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
