

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-026847**Date Inspected:** 07-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**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 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 W14 (Observations of the Welding and Repair Welding on the Lifting Lug and Ventilation Holes) and OBG Field Splice W13/W14 (Observation of the Repair Welding of the "I" Plate).

Craig Hager-FW Spencer South Tower Shaft (Observation of the Welding of the Utility Piping Systems) OBG E13/E14 (Observation of the Repair Welding of "D1", "I" Plates and and Fit-up of Side Plate "E1" and "E2"). For additional information see Summary of Conversation.

Joselito Lizardo-OBG E14 (Observation of the Welding and Repair Welding of Lifting Lug and Ventilation Holes), E13/E14 (Observation of the Excavation and Repair Welding on the "A2.2" Plate) and OBG W14 (QA VT/MPT Verification of the Ventilation Holes) and OBG Field Splice E13/E14 (QA VT/MPT of "H" Plate).

Art Peterson-Observations of the modification work of Bike Path Traveler and Belvederes of the following Contract Change Order: CCO:178 and welding of the pipe sleeve at the south rail divider panels in reference to CCO: 179.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

William Clifford-OBG W14 (QA/UT Verification of Ventilation Holes). Assisted QA Ultrasonic Level III Robert Mertz and performed UT (information only) to investigate indications at Deck Ventilation Holes 14W-PP126.2-E2.6 and 14W-PP126.7-W2.5.

Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Douglas Frey, Art Peterson, Craig Hager, William Clifford and Joselito Lizardo 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 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.

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.

QAI, Craig Hager, informed this QALI of the second time repair on the OBG field splice identified as 13E-14E-D1 R1 located at a the Y dimension 6170 mm. In regards to the QAI review of this reject he informed this QALI that upon the second time excavation the depth appeared to be greater than 65% (23 mm deep) and informed the QC Lead Inspector, Bonifacio Daquinag, that the work to be terminated at this time and a request to proceed with the repair welding would require the Engineer's approval.

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
