

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-026890**Date Inspected:** 16-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted 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 Component**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford 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:

At approximately 7:45am this QA arrived at the 14W-PP126.2-W3.7 location to perform QA Ultrasonic Testing (UT) of ventilation holes previously tested and accepted by Quality Control (QC) personnel at approximately 4:30pm on the previous shift (12/15/11). Upon arriving, this QA observed that the test areas had been painted over.

This QA then spoke to QC Lead Bonifacio Daquinag and Mr. Daquinag informed this QA that ABF personnel had been instructed to remove the paint so that QA testing could be completed. As of 2:45pm this day (12/16/11) the paint has not been removed and QA testing has not been completed. QA testing will commence when QA has been informed or observed that the paint has been removed.

West Line

This QA observed, at random intervals, ABF/JV qualified welder Mike Jiminez #4671 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110-R1. This was a Complete Joint Penetration (CJP) weld on a 14mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at 11W-PP103-W3-LLH#1,3 and was performed in the overhead position from the inside of the "A" deck plate.

During welding, ABF Quality Control (QC) Salvador Moreno was noted monitoring the welding parameters. Welding parameters were recorded as (A=126).

WELDING INSPECTION REPORT

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This QA observed, at random intervals, ABF/JV qualified welder Mike Jiminez #4671 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110-R1. This was a Complete Joint Penetration (CJP) weld on a 14mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at 11W-PP101-W3-LLH#2,4 and was performed in the overhead position from the inside of the "A" deck plate.

During welding, ABF Quality Control (QC) Salvador Moreno was noted monitoring the welding parameters. Welding parameters were recorded as (A=126).

This QA observed, at random intervals, an ABF/JV qualified welder, Richard Garcia #5892, performing Flux Cored Arc Welding (FCAW) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3040B-3. Welding was performed at the 20mm butt weld joint (B-U2-S) connecting Lift 13 and Lift 14 "A5" deck plates.

This weld is a Seismic Performance Critical Member (SPCM) member.

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters. Welding parameters were recorded as (A=212, V=23.1, T=152).

This QA observed, at random intervals, an ABF/JV qualified welder, Rory Hogan #3186, performing plasma arc back gouging at the 20mm butt weld joint (B-U2-S) connecting Lift 13 and Lift 14 "A5" deck plates.

This weld is a Seismic Performance Critical Member (SPCM) member.

This QA verbally informed QA SPCM Lead, Daniel Reyes, of the issues noted in this report for compliance. For further details of issues of significance see QA SPCM Lead, Daniel Reyes, "Daily Inspection Report" (TL-6031) submitted for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above.

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 SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford,William	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
