

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 #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026898**Date Inspected:** 16-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernie Docena**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:** Bike Path**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Art Peterson arrived on the jobsite between the times noted above to randomly observe Quality Control (QC) personnel monitor the welding operations performed by American Bridge Fluor (ABF) personnel on the Skyway portion of the SFOBB and perform a survey of the temporary brackets removed from the counterweights on the SAS portion of the SFOBB. The following observations made were for extra work being performed to the following contract change orders:

Skyway Portion of the SFOBB:

CCO: 193 - Description: Modify the existing bikepath panels at the expansion joints of the Skyway portion of the SFOBB East Span Seismic Safety Program.

This QA Inspector randomly observed ABF welder Mr. Jason Collins (Welder ID 8128) performing the root pass weld operation on a partial-joint-penetration (PJP) groove weld per the Flux Cored Arc Welding (FCAW-S) self shielding process in the (1G) flat position connecting the new end plate to the existing top plate of the bike path panel at the expansion joint Hinge "D" as per ABF Submittal no. 2549R1 of Contract Change Order (CCO) 193. This QA Inspector observed QC Inspector Mr. Bernie Docena verify prior to the start of the root pass weld operation that the preheat temperature of 150 degrees F was established and afterwards verified that the welding parameters (Amps, Volts and Travel Speed) were in accordance with ABF-WPS-D15-2160-1 using the E71T8 NR232 electrode - (.072") diameter electrode.

At the Expansion Joint Hinge "D" This QA Inspector previously observed ABF personnel cut back the top and side skin plate and diaphragm plate using an oxyacetylene cutting torch on a track system and also observed the

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ABF personnel use a mechanical cutting blade on the existing soffit plate of the bike path panel. The cut back distance was measured at 116 mm as per Contract plan sheet number 1164S7 and ABF Submittal number 2549R1.

SAS Portion of the SFOBB: Light Pipe Installation.

CCO: 182 Removal of Brackets for future light pipes.

This QA Inspector along with QA METS Inspector Mr. JoJo Lizardo performed a survey inspection for the status of the temporary mounting brackets that were previously removed by ABF personnel on the counter weights located on the "W" line of the SAS Superstructure.

This QA Inspector observed at (2) panel point locations of the where the safety "tag" line was installed across the suspender brackets that the temporary mounting brackets were removed and an epoxy zinc rich Interzinc 52 coating was applied to the areas that were ground flush to the base metal of where the temporary mounting brackets were removed.

The survey of the status of the removal of the mounting brackets was performed from PP 11 to PP 106 on this date, and due to limited access and safety reasons no visual inspection and magnetic particle inspection was performed on the bracket removal area on the "W" line.

This QA Inspector met with QA Lead Inspector Mr. Danny Reyes who was aware of the safety concerns and once the ABF personnel prepare the safety tag lines across the suspender brackets and prepare the staging for QA to perform the visual and magnetic particle inspection, Mr. Reyes will inform this QA Inspector on the date to perform the visual and magnetic particle inspection.



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Summary of Conversations:

See significant conversations reported regarding CCO 182 on this date.

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:	Peterson, Art	Quality Assurance Inspector
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Reviewed By:	Levell, Bill	QA Reviewer
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