

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-026928**Date Inspected:** 19-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**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 Box Panel - Skyway**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 bike path box panels of the Skyway 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 bike path box 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, fill, and cover 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) and (3G) flat and vertical position connecting the new end plate to the existing top plate of the bike path panel at 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, fill and cover 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 and ABF-WPS-D15-2160-3 using the E71T8 NR232 electrode - (.072") diameter electrode. The welding operation will be completed during this QA Inspectors' next inspection visit at expansion joint Hinge "D".

The welding observed on this date appeared to be in general compliance with the weld procedure specifications and the work observed appeared to be in general compliance with contract change order (CCO) 193.

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Note: 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 ABF personnel use a mechanical cutting blade on the existing soffit plate of the bike path box panel. The cut back distance was measured at 116 mm as per Contract plan sheet number 1164S7 and ABF Submittal number 2549R1. The new end plate has been fit-up and the welding operation is being performed on this date as mentioned above.



Summary of Conversations:

No significant conversations were reported on this date. Only general conversations between this QA Inspector and the Contractors' QC Inspector.

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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