

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-026943**Date Inspected:** 10-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:** 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 Field Splice W13/W14 (Observation of QC/UT and QA Verification Plate "I"), OBG Field Splice W12/W13 (Observation and QA Verification of Plate "F1") and OBG Field Splice W13/W14 (Observation of Repair Welding and QC Inspection of Plate "D1").

Joselito Lizardo-OBG E14 (Observed the Welding and Inspection of the Ventilation Holes), OBG W14 & OBG E13/E14 Field Splice (QA VT/MPT Verification).

Art Peterson-CCO: 179-Observed the installation of the pipe sleeve at the south rail divider panels and replacement of existing bike path panel shims and modification of existing emergency gates.

William Clifford-OBG W14 (QA/UT Verification of Ventilation and Lifting Lug Holes), OBG Field Splice 13E/E14 (QA/UT Verification of Segment A2.2) and OBG W14 (Observations of QC/UT on Ventilation and Lifting Lug Holes).

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Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Douglas Frey, Art Peterson, 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.

Issue

This QALI inadvertently omitted a verbal conversation with QAI Douglas Frey regarding the repair welding on the bottom plate identified as weld "D1" of the OBG field splice identified as 13W-14W. Mr. Frey informed this QALI that the excavations and MPT were completed and were setting up equipment to commence the repair welding. This QALI informed Mr. Frey that one of the repairs (length is equal to approximate length of 1100mm) exceeds the maximum allowable length permitted by the contract specifications (AWS D1.5-2002). At this time this QALI informed the QC Lead Inspector, Bonifacio Daquinag, Jr., of this issue and Mr. Daquinag response was that this issue would be submitted to the Welding Quality Control Manager (WQCM). Note: In regards to this issue an Incident Report (IR) will be generated.

QA Note: This reports supersedes the previous Weld Inspection Report (WIR) dated 12/10/11.

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
