

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027020**Date Inspected:** 11-Jan-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** L & M Industrial Fabricators**Location:** Tangent, Oregon**CWI Name:** Tom Dreyer**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:** Tower Head Parapet Wall**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Art Peterson arrived at L & M Industrial Fabricators between the times noted above to randomly observe Quality Control (QC) personnel monitor the welding operations performed by L & M personnel on the fabrication of parapet walls to the Tower Heads. The following observations for the extra work being performed to the following contract change order were:

CCO: 196 - Description: Construct parapet walls at the Tower Heads.

South Tower Head Parapet Wall:

This QA Inspector performed a random visual inspection of the fit-up and tack-weld operation previously performed and completed by L & M welding personnel on the partial-joint-penetration (PJP) groove and fillet T joints in the fabrication of the parapet wall and the parapet wall base plate fit to the top of the South Tower Head. The QC Inspector Tom Dreyer informed this QA Inspector that L & M Industrial Fabricators are prepared to start the welding operation on the South Tower Head on January 12th, 2012. L & M Industrial Fabricators Weld Quality Control Program (WQCP) addendum's - (FCAW-G) 3G position WPS has been submitted but has yet to be approved in writing by the Engineer as of this date. The WQCP that was submitted previously and approved by the Engineer in writing were for prequalified Weld Procedure Specifications (WPS's) per the SMAW process which L & M Industrial Fabricators welding personnel proceeded with the fit-up and tack-weld operation using the SMAW process on the parapet wall and the same process to fit the parapet wall to the South Tower Head.

The fit-up and tack-weld operation completed on the parapet wall and the fit-up and tack-weld operation of the

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parapet wall to the South Tower Head appeared to be in general compliance with CCO 196 and AWS D1.5-2002.

Summary of Conversations:

This QA Inspector informed QC Inspector Tom Dreyer of the results from the 2nd All-Weld-Metal(AWM) tension re-test specimen tested at PSI in Portland, OR. The 2nd AWM tension re-test specimen % elongation was recorded at 23.15. The 1st AWM tension re-test specimen tested on January 5th, 2012 and the 2nd AWM re-test tension test specimen tested on this date met the requirements of AWS D1.5-2002 Section 5.20 "Retests" and L & M Industrial Fabricators will prepare their FCAW-G WPS's for the following positions: 1G, 2G, 1F, and 2F and submit as an addendum to their WQCP as Revision 3.

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
Reviewed By:	Levell, Bill	QA Reviewer
