

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-027084
Date Inspected: 20-Jan-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: jobsite

CWI Name:	Bernard 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:	SAS project	

Summary of Items Observed:

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and /or monitor American Bridge/Fluor (ABF) welding operations. This Quality Assurance (QA) Inspector, Craig Hager observed the following.

Skyway Bike Path Expansion Joint Modification, Contract Change Order (CCO) 193:

This QA Inspector was informed by QC Inspector Bernard Docena work at this location had been canceled for the day due to rain. This QA Inspector had a conversation with QC Inspectors Bernard Docena and Bill Norris confirming the issuing of the Non-Conformance Reports (NCR) by QC the previous day. For further details see Welding Inspection Report (TL-6031) dated 1/19/2011. This QA Inspector notified Structural Material Representative (SMR) Nicolai Hvass of the conversation above.

Longitudinal Diaphragm Access Opening, Contract Change Order (CCO) # 202:

This QA Inspector arrived at the Warehouse at Pier #7 and observed QC Inspector Bernard Docena perform a visual inspection on Splice Plate-A, assembly #1 and #2 and Splice Plate-B, assembly #1 and #2. This QA Inspector randomly observed QC Inspector Bernard Docena perform Magnetic Particle Testing (MT) on 100% of the fillet welds on both Splice Plates A and B and both assemblies. QC Inspector Bernard Docena informed this QA Inspector he was rejecting Splice Plate-A, assembly #1 due to undercut. This QA Inspector observed several areas marked along the bottom toe of the fillet weld. This QA Inspector performed a random visual and MT

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inspection on the pieces accepted by the QC Inspector and the work appeared to comply with the contract requirements.

This QA Inspector observed ABF welding personnel Gilbert Peralta (#9453) use a sanding disk on a power grinder to clean up the areas marked during the QC inspection. This QA Inspector randomly observed as the areas were preheated and welded by ABF welding personnel Gilbert Peralta (#9453) using the Shielded Metal Arc Welding process. This QA Inspector observed as the preheat temperature was verified by QC and the following parameters verified; 137 amperes. This QA Inspector observed a 3.2 mm diameter E7018H4R electrode was being used and that the welding appeared to comply with the Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A being used by the QC Inspector. QC Inspector Bernard Docena informed this QA Inspector the final visual and MT inspection would be completed Monday (1/23/2011), after the minimum 24 hold period.

This QA Inspector spoke with Structural Material Representative (SMR) Bahjat Dagher regarding the work being performed and was informed the drawing being used for fabrication was included with the contract drawings.

This QA Inspector received the following Weekly Welding Report submittal; ABF-SUB-002561R11. This QA Inspector performed a review of the documents to determine compliance with the Welding Quality Control Plan (WQCP) submitted by the contractor, compliance with the applicable contract requirements and to determine if any Quality Control (QC) documents were missing. This QA Inspector documented the findings and informed QA Inspector Bill Levell of the findings. This QA Inspector completed a Review of Contractor's Submittal (TL-20) report for the submittal.

Summary of Conversations:

This QA Inspector had general conversations with American Bridge/Fluor (ABF) personnel, QC personnel and Caltrans personnel during this shift. Except as described above there were no notable conversations.

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:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
