

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 #: 99.28**WELDING INSPECTION REPORT**

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027116
Date Inspected: 31-Jan-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: L & M Industrial Fabricators

OSM Arrival Time: 700
OSM Departure Time: 1530
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	

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 and the NDT inspection on the fabrication of chimney parapet walls to the Tower Head Top Plate. 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 Head

North Tower Chimney Parapet:

This QA Inspector randomly observed L & M welder Jake Schuld (Welder ID #17) performing the fillet weld pass operation per the Flux Cored Arc Welding (FCAW-G) gas shielding process in the (2F) horizontal position connecting a flat plate-(A6i) to stiffener plates (A6g and A6h) that were previously welded to the internal side of parapet wall plate-(A6b) of the North Tower Chimney Head. This QA Inspector observed QC Inspector Tom Dreyer verify prior to the start of the fillet weld operation that the minimum preheat temperature as per the approved WPS was established and afterwards verified that the welding parameters (Amps, Volts and Travel Speed) were in accordance with WPS-D1.5-FC-006-2F using Hobart Excel Arc E71T-1 (.052") diameter electrode.

The fillet weld operation was completed at the end of this QA Inspectors' shift.

South Tower Chimney Parapet:

WELDING INSPECTION REPORT

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This QA Inspector randomly observed L & M welder Otis Smith (Welder ID #19) performing the repair weld operation per the Flux Cored Arc Welding (FCAW-G) gas shielding process in the (3G) vertical position on the partial-joint penetration (PJP) existing corner-joint weld connecting the Tower Head Top plate to Tower Head Skin Plate E of the South Tower Head Chimney. The QC NDT Inspector performed magnetic particle test inspection adjacent to the existing PJP weld and observed two (2) rejectable longitudinal linear indications at "Y" Locations (99~107) mm and (1342~1350) mm. The prepared U groove dimension after grinding out the rejectable indications were at "Y" Locations (18~280) mm and (1135~1415) and both were at a depth of (16) mm and widths varied from (16~18) mm.

This QA Inspector observed QC Inspector Tom Dreyer verify prior to the start of the repair weld operation that the minimum preheat temperature as per the approved repair WPS was established and afterwards verified that the welding parameters (Amps and Volts) were in accordance with WPS-LM-FC-01 Repair using Hobart Excel Arc E71T-1 (.052") diameter electrode.

The repair weld operation was completed at the end of this QA Inspectors shift.



Summary of Conversations:

No significant conversations were reportable 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
Reviewed By:	Levell, Bill	QA Reviewer
