

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-027184
Date Inspected: 14-Feb-2012

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

OSM Arrival Time: 730
OSM Departure Time: 1600
Location: Tangent, OR

CWI Name:	Thomas 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:	CCO 196 and 203	

Summary of Items Observed:

On this date, Quality Assurance Inspector (QAI) Kenneth Riley 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 chimney parapet walls to the Tower Heads and Elevator brackets installed. The observations for the extra work being performed are under contract change orders CCO196 and CCO203 as stated below.

CCO203

The QAI performed a QA review using the Magnetic particle (MT) testing for the interior (A4) and exterior (B4) elevator brackets and found no rejectable indications at the time of the review. This QAI performed a percentage of the Lot. For further information please see TL-6028 dated for today.

CCO196

This QA Inspector randomly observed L & M welding personnel Bradford Schroyer (Welder ID #16) fitting and welding parapet wall assembly A14 for Tower Head East, under Welding Procedure Specification (WPS) D1. 5-FC-005-2F (Fillet) and D1.5-FC-TC-P4-GF-1&2G (Joint TC-P4-GF [PJP]). The welder was observed using the Flux Cored Arc Welding (FCAW) process with the electrode being used as Hobart Excel Arc 71, E71T-1; the welding is in the horizontal and flat positions placing fillet welds and Partial Joint Penetration (PJP) welds. The welding parameters checked by the QC inspector appeared to be within the specified WPS. This QAI observed QC inspector Tom Dreyer observing the work in process.

Performed report reviews for upcoming green tag release for paint. Fabricator provided NDT reports generated

