

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-027200
Date Inspected: 15-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.

CCO196

This QA Inspector randomly observed L & M welding personnel Bradford Schroyer (Welder ID #16) fitting and welding parapet wall assembly A14 (number 2) for Tower Head West, 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.

This QAI randomly observed that L&M personnel Otis Smith (Welder ID #19) Jake Schuld (Welder #17) Was fitting the parapet walls (A11 and A12) to the base plate and matching the distortion from the tower skin plate as outlined in the CCO196. Welder Jake Schuld was the Flux Cored Arc Welding (FCAW) process with the electrode being used as Hobart Excel Arc 71, E71T-1 to tack weld the plates in place prior to welding. The fabricator continued to perform the fit up of the parapet walls on the east tower head throughout this QAI working shift.

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Unless noted otherwise, all work observed on this date appeared to be in general compliance with the contract documents at the time of observations.



Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI and ABF QC personnel.

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:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
