DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

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

Report No: WIR-027205
Date Inspected: 10-Feb-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: 1730
Location: Job Site

CWI Name: Salvador Mereno

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:
The QA Inspector randomly observed the following work in progress:

Quality Assurance Inspector (QA) Rene Hernandez was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:
West Line

This QA observed, at random intervals, ABF/JV qualified welder Mike Jimenez #4671 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1050A-CU. This was a Complete Joint Penetration (CJP) weld on a 20mm plate insert at the “A” deck to close the lifting lug deck penetration holes. This work was located at 13W-PP122.5-W4-LLH#2 was performed in the flat position from the inside of the “A” deck plate.

During welding, ABF Quality Control (QC) Salvador Moreno was noted monitoring the welding parameters. Welding parameters were recorded.

This QA observed, at random intervals, ABF/JV qualified welder Eric Sparks #3040 performing fit-up of round cut plates per Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1050A-CU. This was a Complete Joint Penetration (CJP) weld on a 20mm plate insert at the “A” deck to close the lifting lug deck penetration holes. This work was located at 13W-PP118.5-W4-LLH-1 & 2.

WELDING INSPECTION REPORT

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This QA observed, at random intervals, ABF/JV qualified welder Richard Garcia #5892 performing Flux Cored Arc Welding (FCAW) with .045" diameter E71T-1M electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3110-4. This was a Complete Joint Penetration (PJP) weld connecting 13W to 14W side plate to side plate CJP weld E2. This work was located at West line connection joint 13W to 14W.

During welding, ABF Quality Control (QC) Salvador Mereno was noted monitoring the welding parameters. Welding parameters were recorded as (Voltage 24.1V / Amperage 230A).

During welding, ABF Quality Control (QC) Salvador Mereno was noted monitoring the welding parameters. Welding parameters were recorded.

This QA verbally informed QA SPCM Lead, Daniel Reyes, of the issues noted in this report for compliance. For further details of issues of significance see QA SPCM Lead, Daniel Reyes, “Daily Inspection Report” (TL-6031) submitted for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Pertinent conversations are in the body of this report

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:	Hernandez,Rene	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer