

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-027223**Date Inspected:** 21-Feb-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Salvador Merino**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:** OBG**Summary of Items Observed:**

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 randomly being 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 PP119.5 W3 2 was performed in the flat position from the topside of the "A" deck plate. During welding, ABF Quality Control (QC) Salvador Merino was noted monitoring the welding parameters. Welding parameters were recorded. Also verified that CU backup strip was secured from top and under deck.

This QA inspector observed ABF QC personnel performing UT weld inspection in accordance with section 6 of AWS D1.5. All work was being performed by certified personnel performing UT testing to level II requirements. Weld inspection was observed at 13W/14W weld # A3 and A4.

This QA inspector observed ABF QC personnel performing MT weld inspection in accordance with section 6 of AWS D1.5. All work was being performed by certified personnel performing MT testing to level II requirements. Weld inspection was observed at 13W/14W weld # A3

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA inspector observed that during fitup of 20mm thick cover plate weld identified as 11W PP109.5 W5 SW had an excessive root gap around the entire circumference of the weld. QC personnel has stopped further work from occurring until a decision by ABF's engineer has been reached and a repair procedure has been recommended.



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