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 #: 99.28

WELDING INSPECTION REPORT

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

Report No: WIR-027225
Date Inspected: 22-Feb-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 Chimney 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 on the fabrication of tower chimney parapet walls. 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 Heads

East Tower Chimney Parapet:

This QA Inspector randomly observed L & M welder Bradford Schroyer (Welder ID #16) performing the fillet weld operation per the Flux Cored Arc Welding (FCAW-G) gas shielding process in the (2F) horizontal position connecting stiffener plate- (A11e) and stiffener plate- (A11f) to wall plate- (A11b) and the (3F) vertical position connecting stiffener plate- (A11e) and stiffener plate- (A11f) to base plate- (A11a) and to top plate- (A11d) of the East Tower Head Chimney parapet wall. 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 afterwords; 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 welding operation was completed at this location and the workmanship appeared to be in general compliance with the contract specifications.

West Tower Chimney Parapet:

This QA Inspector randomly observed L & M welder Jake Schuld (Welder ID #17) performing the fillet weld operation per the Flux Cored Arc Welding (FCAW-G) gas shielding process in the (2F) horizontal position connecting stiffener plate- (A11e) and stiffener plate- (A11f) to wall plate- (A11b) and the (3F) vertical position connecting stiffener plate- (A11e) and stiffener plate- (A11f) to base plate- (A11a) and to top plate- (A11d) of the West Tower Head Chimney parapet wall. 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 afterwords; 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 welding operation was completed at this location and the workmanship appeared to be in general compliance with the contract specifications.

East Tower Chimney Parapet:

This QA Inspector randomly observed L & M welder Bradford Schroyer (Welder ID #16) performing the fillet weld and partial-joint penetration (PJP) corner-joint weld operation per the Flux Cored Arc Welding (FCAW-G) gas shielding process in the (3F-internal side) and (3G -external side) vertical positions connecting top plate- (A11d) to wall plate- (A11b) of the East Tower Head Chimney parapet wall. This QA Inspector observed QC Inspector Tom Dreyer verify prior to the start of the fillet and PJP weld operation, that the minimum preheat temperature as per the approved WPS was established and afterwords; verified that the welding parameters (Amps, Volts and Travel Speed) were in accordance with WPS-D1.5-FC-002-3F and WPS D1.5-FC-TC-P4-GF-3G using Hobart Excel Arc E71T-1 (.052") diameter electrode.
The welding operation was completed at this location and the workmanship appeared to be in general compliance with the contract specifications.

West Tower Chimney Parapet:

This QA Inspector randomly observed L & M welder Jake Schuld (Welder ID #17) performing the fillet weld and partial-joint penetration (PJP) corner-joint weld operation per the Flux Cored Arc Welding (FCAW-G) gas shielding process in the (3F-internal side) and (3G -external side) vertical positions connecting top plate- (A11d) to wall plate- (A11b) of the West Tower Head Chimney parapet wall. This QA Inspector observed QC Inspector Tom Dreyer verify prior to the start of the fillet and PJP weld operation, that the minimum preheat temperature as per the approved WPS was established and afterwords; verified that the welding parameters (Amps, Volts and Travel Speed) were in accordance with WPS-D1.5-FC-002-3F and WPS D1.5-FC-TC-P4-GF-3G using Hobart Excel Arc E71T-1 (.052") diameter electrode.
The welding operation was completed at this location and the workmanship appeared to be in general compliance with the contract specifications.

WELDING INSPECTION REPORT

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Summary of Conversations:

Only general conversations between QA and QC 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