

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-027226
Date Inspected: 22-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: Jobsite

CWI Name:	As noted below	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:	SAS OBG		

Summary of Items Observed:

Quality Assurance Inspector (QA) Douglas Frey 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:

FW Spencer Pipe Welding (Exterior)

This QA Inspector observed F.W. Spencer welder Damian LLanos ID# (6645) performing Shielded Metal Arc Welding (SMAW) in all positions on schedule 80 4" domestic water pipe and 2.5" compressed air pipe outlets at the locations listed below. This QA Inspector verified the fit up of the joints and found it to be satisfactory and randomly observed QC Inspector Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed utilizing 6010 electrodes in the root pass with the balance using 7018 electrodes. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general conformance with the contract documents.

1/DW1/64/NW, 1/CA2/64/NW
1/DW1/66/NW, 1/CA2/66/NW

13E PP118.7 E5 Vent Hole (Exterior)

This QA Inspector randomly observed QC Inspector Fred Von Hoff perform fit-up operations on vent hole 13E PP118.7 E5. The QC Inspector was observed utilizing a Bridge Cam Gauge to measure the planar offset to be

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within + or – 1 mm from “A” deck. The welder was then observed employing a propane burner to heat the joint and this QA Inspector verified the fit-up as acceptable and employed a 66°C Tempilstik to ensure the minimum pre-heat temperature had been achieved. This QA Inspector randomly observed ABF welder Salvador Sandoval (welder ID 2202) performing the SMAW process in the (1G) flat position and observed the QC Inspector verify the welding parameters were in accordance with ABF-WPS-D15-1050A-CU. The welder was observed grinding and blending the edges of each pass and kept the work sanitary throughout the joints depth. The QC Inspector was observed monitoring the welding and measured the inter-pass temperatures between passes. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was completed on this date and appeared to be in general compliance with the approved WPS and the contract specifications.

8E PP71 E2 Deck Access Hole (Exterior)

This QA Inspector at random intervals, observed the fit up of the deck access plate located at 8E PP71 at grid line E2. ABF welder Jason Collins was observed utilizing alignment aids and temporary attachment templates to achieve a uniform root gap along the plate’s perimeter. QC Inspector Chuck Storer measured the joint configuration and found it to be acceptable and the welder was observed implementing 3.2mm E7018-H4R electrodes to tack the plate in place. Upon completion of the fit-up, the welder utilized the SMAW process in the 1G flat position and the QC Inspector was observed monitoring the welding and the parameters to ensure conformance with ABF-WPS-D1.5-1010-Revision 1. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance with the contract specifications.

Summary of Conversations:

The were no pertinent conversations to report.



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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:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
