

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-027256
Date Inspected: 29-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: 1530
Location: Job Site

CWI Name:	Salvador Merino/Fred Von Hoff	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 Components		

Summary of Items Observed:

On this date, Quality Assurance Inspector (QAI) Kenneth Riley was present at the San Francisco Oakland Bay Bridge job site at Yerba Buena Island to observe erection and welding activities for the San Francisco Oakland Bay Bridge (SFOBB) project. This Quality Assurance Inspector (QAI) observed the following work performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below:

Plate Stiffeners

This QAI observed the contractor preparing plate stiffeners to be installed at 12W/13W @ LS 3-5. The material being prepped is Gr 485 plate stiffeners (ID X3847D-H & J and X4879D-H & J) the dimensions of the plate stiffeners are 18mm x 125 & 130mm x 1500mm Gr 485W. This QAI was informed by QC that a WPS was sent through on WQCP addendum 37; this QAI contacted the SMR Mr. Bahjat Dagher who verified the addendum to the WQCP and confirmed that ABF-WPS-D15-1162-4 had been approved by the department. This QAI spoke with the field lead QC and informed him that the WPS was approved and that no Non-Conformance Report (TL-15) would be generated. This QAI observed welder's Rory Hogan and Jeremy Dolman preparing the area at 12W/13W @ LS 3-5, for the plate stiffeners, the welders are using a section of flat bar to hold the plates in place while they perform the fit up and welding process. At this time the paint was being removed using a grinder on the LS stiffeners and Plate stiffeners where they would receive the Partial Joint Penetration weld (PJP). The location will be heated to a temperature of 100 degrees Celsius by thermocouples'. The welding position for this location will be in the overhead 4G position. The QC for this location is Salvador Merino who was observed as documenting the fit up progress.

Tower Diaphragm 13M elevation.

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This QAI inspector has noted that the contractor did not perform welding at this location today due to the inclement weather in the area.

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
