

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-027302**Date Inspected:** 12-Mar-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:	Jesse Cayabyab		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	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:** 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:

9W PP84.5 W2 TS (Interior)

This QA Inspector randomly observed ABF welder Mike Jimenez (ID 4671) performing the Shielded Metal Arc Welding (SMAW) process in the 3G vertical position on the transverse stiffener (TS) of the deck access hole (DAH) plate located at 9W PP84.5 W2 on the interior of the OBG. Prior to the start of welding, Mr. Jimenez was observed pre-heating the B-U3b complete penetration joint (CJP) to 10° C by utilizing a propane burner, this QA Inspector verified the temperature by employing a 50° F (10° C) Tempilstik. QC Inspector Steve Jensen monitored the welding and the parameters to ensure the work conformed to ABF-WPS-D1.5-1010-Revision 1. This QA Inspector observed the use of E7018-H4R electrodes secured from a remote baking oven in the vicinity and upon completion of face "A", the welder performed back-gouging operations on face "B" of the joint. QC Inspector Jesse Cayabyab tested the back-gouge by the Magnetic Particle (MT) method to ensure soundness of the metal and it was noted that Mr. Cayabyab found no rejectable indications. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress.

9E PP84.5 E5 Deck Access Hole (Exterior)

This QA Inspector randomly observed ABF welder Salvador Sandoval (ID 2202) perform on-going beveling

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operations on "A" deck as part of the fit-up operations on the DAH at 9E PP84.5 E5 on the exterior of the OBG. Mr. Sandoval and ABF welding personnel were observed placing the plate into place by guide tabs and tack welding to complete the fit-up process. Mr. Sandoval initiated the SMAW process on the root drawing 136 amperes utilizing 3.2mm E7018-H4R electrodes. QC Inspector Steve McConnell monitored the welding and the parameters pertaining to ABF-WPS-D1.5-1010 Revision 1. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was in progress.

This QA noted above items observed appear to comply with the contract documents.

Summary of Conversations:

As noted above.



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

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Reviewed By: Levell,Bill

QA Reviewer