

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-027315
Date Inspected: 03-Mar-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: Pier 7 Job Site

CWI Name: Fred Von Hoff
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
Component: S.A.S. Components

Bridge No: 34-0006**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

1) 13M Diaphragm Welding

The QAI observed ABF personnel making a partial joint penetration (PJP) weld at the 13M diaphragm to the North tower shaft (weld #120). The QAI noted that ABF foreman / welder Dan Ieraci, ID 3232, is operating the Submerged Arc Welding (SAW) machine. The QAI noted that the Quality Control Inspector (QCI) Fred Von Hoff is monitoring this welding. At the start of shift, the QAI noted that the weld had previously been fit up and the root was welded. The QAI spoke with the QCI and was informed that there have been difficulties maintaining the preheat temperature and the weld has just gotten to the required 325°F. The QAI verified that the preheat temperature was conforming to the welding procedure specification (WPS) ABF-WPS-D15-4062-1. As the welding progressed, the QCI informed the QAI that the welding parameters were conforming to the WPS. The QAI made random observations of the work in progress during this shift. The QAI noted that fill and cover passes were being made. The QAI observed that the weld has incomplete ends and the QAI was informed that the ends will not be welded at this time. The QAI noted that after the center portion of the weld was completed, it was given 3 hours of post weld heating at 325°F. See the attached photos.

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Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed the general observations and status of work to the QAI Lead Bill Levell and the QAI Danny Reyes. Except as described above, there were no other notable conversations or observations.

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: Croff, Scott

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer