

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-027326**Date Inspected:** 13-Mar-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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:

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

This QA Inspector randomly observed ABF welder Salvador Sandoval (ID 2202) employ a propane burner to pre-heat the B-U3b complete penetration joint (CJP) prior to performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on the deck access hole (DAH) at 9E PP84.5 E5 on the exterior of the OBG. The welder was observed utilizing 3.2mm E7018-H4R electrodes procured from a baking oven, which drew amperage of 119. QC Inspector Steve Jensen monitored the welding and the parameters and measured the inter-pass temperatures between passes while Mr. Sandoval cleaned the start/stop edges of the work utilizing a small disc grinder. This QA Inspector made subsequent observations throughout the shift and noted that the work is in progress and appeared to be in general conformance with ABF-WPS-D1.5-1110A-Revision 1.

9W PP84.5 W2-LSW (Interior)

This QA Inspector at random intervals, observed ABF welder Mike Jimenez (ID 4671) perform the SMAW process in the 3G vertical position on the west longitudinal stiffener of the DAH at 9W PP84.5 W2 on the interior of the OBG. Mr. Jimenez was observed employing pre-heat to the joint prior to welding and made several passes

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utilizing E9018-H4R electrodes. QC Inspector Steve Jensen monitored the welding and the parameters and recorded the amperes as 127.4 and verified that the work was in compliance with ABF-WPS-D1.

5-1012-3-Revision 0. Upon completion of face "A" the welder back-gouged the bottom of the root performing the Carbon Air Arc method from face "B". QC Inspector Sal Merino initiated a Magnetic Particle (MT) inspection to ensure soundness of the metal. It was noted that Mr. Merino found no rejectable indications. This QA Inspector observed the welder begin to weld face "B" of the joint and noted that the work was in progress and appeared to be in general conformance with the contract specifications.

8W PP70.5 W2 DAH (Interior)

This QA Inspector randomly observed ABF welder Eric Sparks perform back-gouging operations on the DAH at 8W PP70.5 W2 on the interior of the OBG. The welder was observed performing the Carbon Air Arc method and utilized a small disc and a die grinder to clean the joint to clean shiny metal prior to MT testing and inspection. This QA Inspector made subsequent observations throughout the shift and noted that the work is in progress.

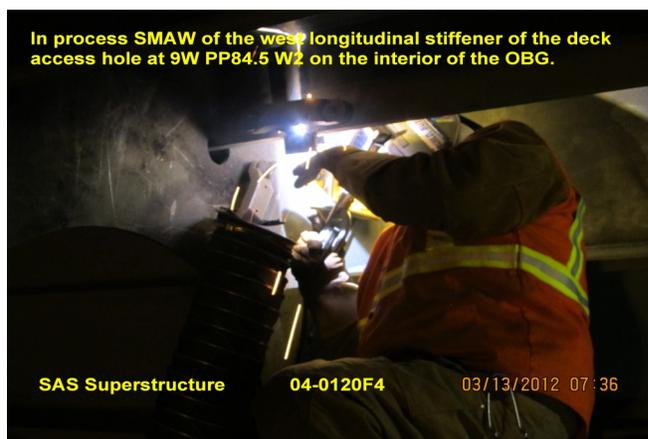
5W PP29.5 W2-LSE Repair (Interior)

This QA Inspector randomly observed ABF welder Rick Clayborn performing the back-gouge operation of ultrasonic rejectable indications on the DAH East Longitudinal Stiffener at 5W PP29.5 W2. The excavations were located at y+55 mm: (50 mm in length, 22mm wide and 10mm deep), y+130mm: (80mm in length, 20mm wide and 11 mm deep). This QA Inspector observed QC Inspector Jesse Cayabyab perform a Magnetic Particle Inspection (MT) of the excavation to determine the soundness of the metal. Upon completion of the testing this QA Inspector observed that no rejectable indications were present.

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.

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