

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-027342
Date Inspected: 16-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: Job Site

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:

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

This QA Inspector at random intervals, Observed ABF welder Salvador Sandoval (ID 2202) pre-heat the B-U3b Complete penetration Joint (CJP) to a minimum of 70° F 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. This QA Inspector observed the use of 3.2mm E7018-H4R electrodes and verified that the electrodes were obtained from a baking oven set at the correct temperature. The welder was observed cleaning the work between passes utilizing a small disc grinder, brushes and compressed air. QC Inspector Steve Jensen was observed monitoring the welding and was present on subsequent observations by this QA Inspector. This QA Inspector noted that the work was in progress and appeared to be in general conformance with ABF-WPS-D1. 5-1010-Revision 1 and the contract specifications.

9W PP84.5 W2 LS-E (Interior)

This QA Inspector randomly observed ABF welder Mike Jimenez performing the SMAW process in the 3G vertical position on the East Longitudinal Stiffener (LS-E) of the DAH located at 9W PP84.5 W2 on the interior of the OBG. Mr. Jimenez was observed utilizing 3.2mm E9018-H4R electrodes with amperage of 127 and this QA

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Inspector verified that they were secured from a remote baking oven in the general vicinity. It was noted that a Pro-Heat induction heating system was incorporated to provide continuous heat throughout the shift and the welder was observed grinding and blending the start/stop edges of the work with a small disc grinder and a die grinder. QC Inspector Steve Jensen was observed monitoring the welding and the parameters to ensure compliance with ABF-WPS-D1.5-1110A-Revision 0 and this QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was in progress.

8W PP70.5 W2-TS (Interior)

This QA Inspector made random observations of the Transverse Stiffener (TS) of the DAH located at 8W PP70.5 W2 on the interior of the OBG. ABF Welder Eric Sparks was observed performing the SMAW process in the 3G vertical position utilizing 3.2mm E7018-H4R electrodes drawing amperage of 117 QC Inspector Steve Jensen was noted as being present to monitor the welding and ensure the parameters and the work conformed to ABF-WPS-D1.5-1010A-Revision1. The work was noted as being in progress as this QA Inspector made subsequent visits throughout the shift and appeared to be in general conformance with the contract documents.

5W PP29.5 W2-DAH (Exterior)

This QA Inspector randomly observed ABF welder Rick Clayborn performing the back-gouge operation of ultrasonic rejectable indications on "A" Deck Access Hole 5W PP29.5 W2 on the exterior of the OBG. The locations of the excavations were recorded as; y+3260: 100mm in length, 20mm wide and 11mm deep, y+3305: 80mm in length, 20mm wide and 12 mm deep. This QA Inspector observed QC Inspector John Pagliero perform a Magnetic Particle Inspection (MT) of the excavations to determine the soundness of the metal. Upon completion of the testing this QA Inspector observed that Mr. Pagliero found no rejectable indications

This QA Inspector randomly observed ABF welder Rick Clayborn performing the repair welding operation of ultrasonic indications as per the SMAW process in the (4G) overhead position on the "A" DAH at 5W PP29.5 W2 on the exterior of the OBG. This QA Inspector observed the use of E7018-H4R electrodes and QC Inspector John Pagliero verify that the preheat temperature was at the minimum of 66 degrees C and that the welding parameters Amps=135, were in accordance with WPS D1.5-1001- Repair. The welding parameters observed at this location appeared to be in general compliance with approved WPS and the contract specifications, and it was noted by this QA Inspector that the work was completed on this date.

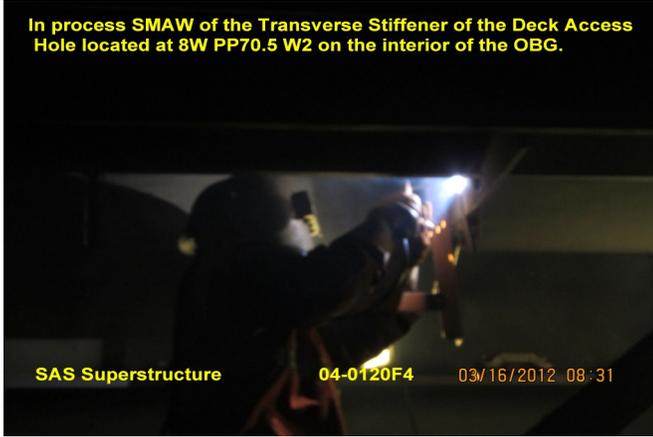
Summary of Conversations:

As noted above.

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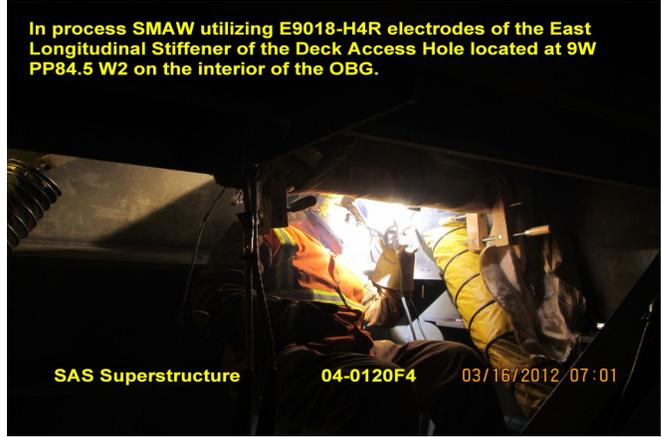
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In process SMAW of the Transverse Stiffener of the Deck Access Hole located at 8W PP70.5 W2 on the interior of the OBG.



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In process SMAW utilizing E9018-H4R electrodes of the East Longitudinal Stiffener of the Deck Access Hole located at 9W PP84.5 W2 on the interior of the OBG.



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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