

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-027350
Date Inspected: 23-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: 1730
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-DAH (Interior)

This QA Inspector at random intervals, observed ABF welder Salvador Sandoval (ID 2202) perform the Shielded Metal Arc Welding (SMAW) process in the 4G overhead position on face "B" of the Deck Access Hole (DAH) located at 9E PP84.5 E5 on the interior of the OBG. The welder was observed utilizing 3.2mm E7018-H4R electrodes obtained from a baking oven and drawing amperage of 123. QC Inspector Steve McConnell was on hand to monitor the welding, parameters and measure the inter-pass temperatures as they apply to ABF-WPS-D1. 5-1010-1. On subsequent observations the welder was observed cleaning the work between passes by employing a small disc grinder, brushes and compressed air. This QA Inspector noted that Mr. Sandoval completed the welding on the interior side of the DAH and was relocated to the DAH located at 12E PP109.5 E5. ABF welder Todd Jackson (ID 4639) was tasked to continue the work on the Longitudinal Stiffeners at this location and on subsequent observations by this QA Inspector it was noted that no welding had commenced by the end of the shift.

8W PP70.5 W2-DAH (Interior)

This QA Inspector made random observations of SMAW on the DAH located at 8W PP70.5 W2 on the interior of the OBG. ABF welder Eric Sparks (ID 3040) was observed welding in the 4G overhead position

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utilizing 3.2mm E7018-H4R electrodes that were obtained from a remote baking oven verified by this QA Inspector. QC Inspector Steve Jensen was present to monitor the welding and the parameters to ensure compliance with ABF-WPS-D1.5-1010-Revision 1. The welder was observed cleaning the work between passes and employed a small disc grinder to blend the start/stop edges for a smooth transition, as the QC Inspector measured the inter-pass temperatures. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work at this location is in progress and appeared to be in general conformance with the contract specifications.

9W PP84.5 W2-DAH (Exterior)

This QA Inspector randomly observed ABF Quality Control Inspectors Jesse Cayabyab performing Magnetic Particle (MT) inspection and QC Inspector John Pagliero perform Ultrasonic Testing (UT) inspection on the DAH located at 9W PP84.5 W2 on the exterior of the OBG. This QA Inspector observed that no rejectable MT indications were found. Mr. Pagliero observed and recorded six (6) rejectable ultrasonic indications listed below. The weld area scanned was 20mm thick.

y+100mm: 30mm in length and 8mm deep.
y+445mm: 30mm in length and 7mm deep.
y+545mm: 50mm in length and 7mm deep.
y+1065mm: 30mm in length and 15mm deep.
y+1685mm: 30mm in length and 12mm deep.
y+2020mm: 30mm in length and 17mm deep.

Punch list Items; 3470, 3479, 3480, 3502.

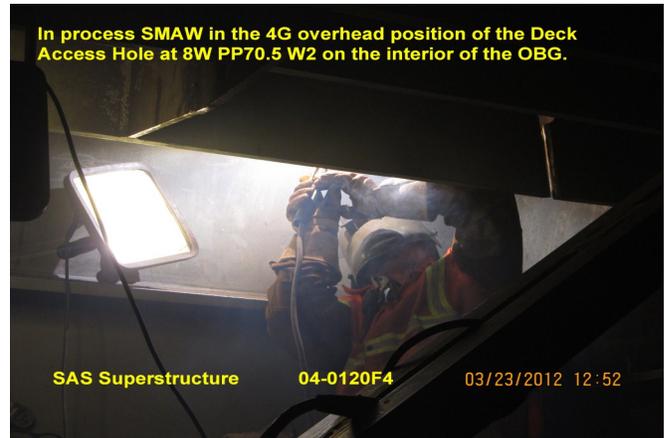
This QA Inspector observed QC Inspectors Sal Merino and Steve McConnell performing Visual welding Inspections (VT) of type 25A, 27C and 27E Pipe Sleeves installed in flame cut holes in floor beams for the punch list items listed above (See photo below). This QA Inspector observed QC identify indications of cold lap, undercut in base metal, undercut in pipe, inadequate fusion; overlap and underfill in and on each of the items inspected and was annotated for repair instructions.

Summary of Conversations:

As noted above.

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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