

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027368**Date Inspected:** 28-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:** On Site**CWI Name:** Steve McConnell**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:** OBG Components**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Art Peterson arrived on site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and monitor the welding operations performed by American Bridge Fluor (ABF) welding personnel. The following observations were:

OBG East Line Segment 12E/13E -A- LS-4:

This QA Inspector observed ABF welder Jeremy Dolman (Welder ID 5042) completed the partial-joint penetration (PJP) T / Corner-joint groove weld operation connecting the deck stiffener flange (DSF) plates to I-Rib LS-4 per the Shielded Metal Arc Welding (SMAW) process in the (4G) overhead position.

The PJP weld operation was completed on this date and afterwards a Post Heat Treatment (PHT) was performed using electric Proheat 35. The PJP weld operation and the PHT operation on this date appeared to be in general compliance with the contract specifications.

OBG East Line Segment 12E/13E - A - LS-5:

After the PHT operation was completed on I-Rib LS-4, this QA Inspector randomly observed ABF welder Jeremy Dolman performing the grinding operation on the PJP T / corner-joint groove weld connecting the DSF plates to I-Rib LS-5 to profile the weld in accordance with AWS D1.5 Section 6.26 and Section 3.6.

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The grinding operation being performed on I-Rib LS-5 was still in-process at the end of this QA Inspectors' shift.

OBG East Line Segment 13E/14E -A- LS-6:

This QA Inspector randomly observed ABF welder Richard Garcia (Welder ID 5892) performing the partial-joint penetration (PJP) T / corner-joint groove weld operation connecting the deck stiffener flange (DSF) plates to I-Rib LS-6 per the Shielded Metal Arc Welding (SMAW) process in the (4G) overhead position.

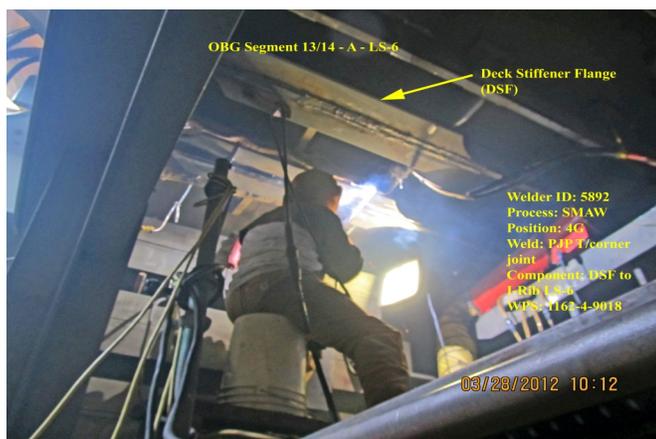
This QA Inspector observed QC Inspector John Pagliero verify prior to the start of the PJP groove weld operation, that the minimum preheat temperature as per the approved WPS was established and afterwards; verified that the welding parameters (Amps and Travel Speed) were in accordance with WPS 1162-4 Revision 0 using Lincoln E9018 (3.2 mm) diameter electrode.

The PJP groove weld operation being performed on I-Rib LS-6 was still in-process on this date and the workmanship appeared to be in general compliance with the contract specifications.

Crossbeam (CB) 18:

This QA Inspector observed ABF welder Rory Hogan (Welder ID 3186) preparing to set-up to perform the handrail splice welding to make the handrail continuous for its full length. The welding process to be utilized will be the Flux Cored Arc Welding (FCAW) process and the electrode chosen was NR 211 (.035") diameter wire. The QC Inspector Steve McConnell was in-process to locate the WPS to be utilized and also determine if ABF welder Rory Hogan was qualified to weld the handrail weld splices since the handrail is small diameter pipe and the welding will be in accordance with AWS D1.1.

This QA Inspector observed that the welder was still in-process with preparing to weld the handrail weld splices at the end of this QA Inspectors' shift.



Summary of Conversations:

Only general conversations between this QA and QC on this date.

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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:	Peterson, Art	Quality Assurance Inspector
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Reviewed By:	Levell, Bill	QA Reviewer
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