

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-027383**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:** job site**CWI Name:** See 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:** Tower**Summary of Items Observed:**

Quality Assurance (QA) Inspector Danny Smith arrived at the new San Francisco Oakland Bay Bridge to observe, document and perform a general visual verification and NDT. Upon arrival as noted above the QA Inspector observed Quality Control (QC) on site performing welding inspection.

FW Spencer-Mechanical Piping:

The shift the QA Inspector observed the following: At location Panel Point 10W-PP92 at grid line W2, weld I.D. numbers 1-CA2-100-NW and 1-DW1-100-NW the QA randomly observed FW Spencer qualified welder Damian Llanos perform Complete Joint Penetration (CJP) 6G (all position) using Shielded Metal Arc Welding (SMAW) on the root pass and cover passes on the 1" weld-o-let to the 2 1/2" diameter air and domestic water lines respectively. The air and water line systems being welded are field welds along the grid line of W2 of the OBG. The welder was noted welding the root pass with 3/32" diameter E6010 electrode and followed by fill pass to cover pass using 3/32" diameter E7018H4R electrode implementing Caltrans approved procedure FW Spencer WPS 1-12-1. The welder was noted preheating and removing the moisture of the joint using a portable torch prior welding. During welding, ABF QC Steve Jensen was noted monitoring the parameters of the welder. At the end of the shift, one drain on each line was completed and was visually accepted by QC.

Tower at 13mm:

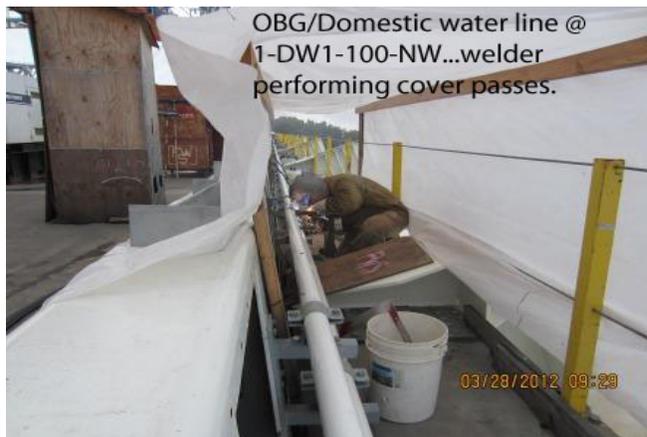
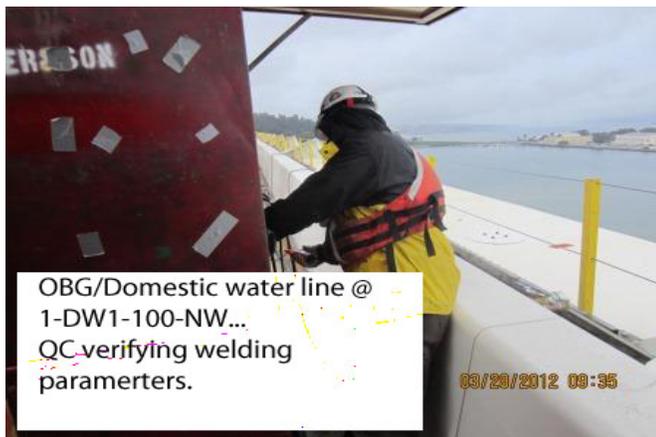
At Tower Base 13 meters diaphragm:

ABF welding personnel relayed to the QA Inspector no welding work was taking place until later at 1200. Later in the shift the QA Inspector returned this location to find no work being performed at this time on this date.

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Work appears to be in general compliance with contract documents.



Summary of Conversations:

Conversations included welding work being performed on this date.

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: Smith,Danny

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer