

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-027387**Date Inspected:** 30-Mar-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** On Site**CWI Name:** Sal Marino**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, LS-5, and LS-6:

This QA Inspector observed ABF welder Jeremy Dolman performing the grinding operation on the PJP T / corner-joint groove weld connecting the deck stiffener flange (DSF) plates to I-Rib LS-4, LS-5, and LS-6 to profile the weld in accordance with AWS D1.5-2002 Section 6.26 and Section 3.6.

The grinding operation was completed on this date and the visual inspection performed on the DSF flange plate welds on I-Rib LS-4, LS-5 and LS-6 appeared to be in compliance with AWS D1.5-2002 Section 6.26 and Section 3.6.

OBG East Line Segment 13E/14E -A- LS-4:

This QA Inspector randomly observed ABF welder Richard Garcia (Welder ID 5892) performing the fill pass weld operation on the partial-joint penetration (PJP) T / corner-joint groove weld 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.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector observed QC Inspector Sal Marino verify prior to the start of the fill pass 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.

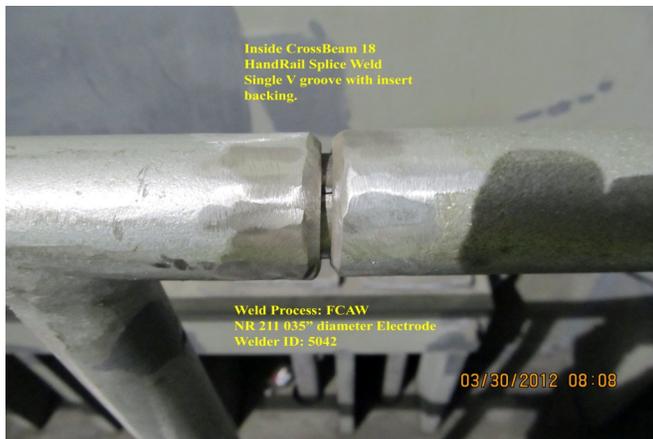
The PJP groove weld operation being performed on I-Rib LS-4 was still in-process on this date and the workmanship appeared to be in general compliance with the contract specifications.

Crossbeam (CB)18:

This QA Inspector observed ABF welder Jeremy Dolman (Welder ID 5042) performing root, fill, and cover pass weld operation on the complete-joint penetration (CJP) butt-joint groove weld connecting the handrails to make continuous in Crossbeam (CB) 18 for its full length per the Flux Cored Arc Welding (FCAW) process in the (1G) and (3G) flat and vertical positions.

This QA Inspector observed QC Inspector Steve McConnell verify prior to the start of the root, fill and cover pass weld operation, that the minimum preheat temperature as per the approved WPS was established and afterwards; verified that the welding parameters (Amps, Volts and Travel Speed) were in accordance with WPS D11-F2201 Revision 0 using NR 211 (.035") diameter electrode.

This QA Inspector observed that the root, fill and cover pass weld operation on the handrail butt-joint groove welds were still in-process at the end of this QA Inspectors' shift.



Summary of Conversations:

Only general conversations between this QA and QC 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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Peterson, Art

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer