

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 #: 1.28**WELDING INSPECTION REPORT**

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027397
Date Inspected: 03-Apr-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:

12W PP109.5 W5-DAH (Exterior)

This QA Inspector randomly observed the Shielded Metal Arc Welding (SMAW) process in the 1F flat position on the Deck Access Hole (DAH) located at 12W PP109.5 W5 on the exterior of the OBG. ABF welder Salvador Sandoval (ID 2202) was observed cleaning the weld between passes utilizing a small disc grinder and compressed air to blend the start/stop edges for a smooth transition. The welder was observed utilizing E7018-H4R electrodes and this QA Inspector verified that the electrodes were recently obtained from a baking oven. QC Inspector Steve Jensen was observed measuring the inter-pass temperatures by employing an infra-red temperature gun as well as monitoring the welding and the parameters. It was noted that the welder was drawing amperage of 127 utilizing 3.2mm electrodes. The welder was observed running multiple pass stringers while adhering to ABF-WPS-D1.5-F1200A. On a subsequent observation, the welder was observed continuing work on the B-U2a Complete penetration Joint (CJP) and was employing the same routine to clean the work. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appeared to be in general conformance with the contract specifications.

12E/13E-A-LS supports (Interior)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector performed an MT Inspection on the “A” Deck Longitudinal Stiffener (LS) supports at LS#4, 5 and 6 at 12E/13E on the interior of the OBG. This QA Inspector performed the yoke method in conformance with ASTM E 709 and the standard of acceptance with D1.5 section 6.26. This QA Inspector noted that no rejectable indications were found at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work at this location appeared to be in general conformance with the contract specifications.

12E PP109.5 E5-DAH (Interior)

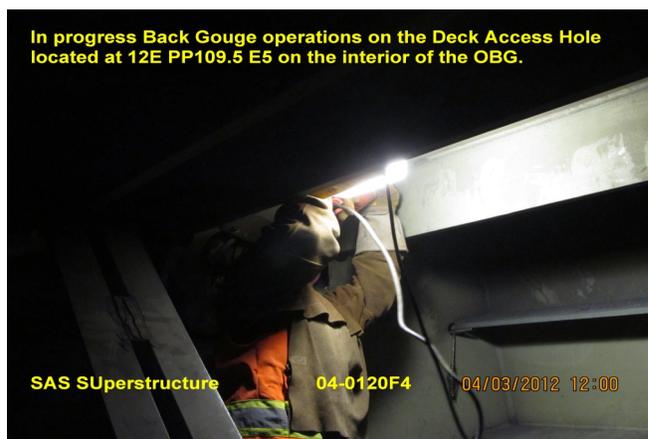
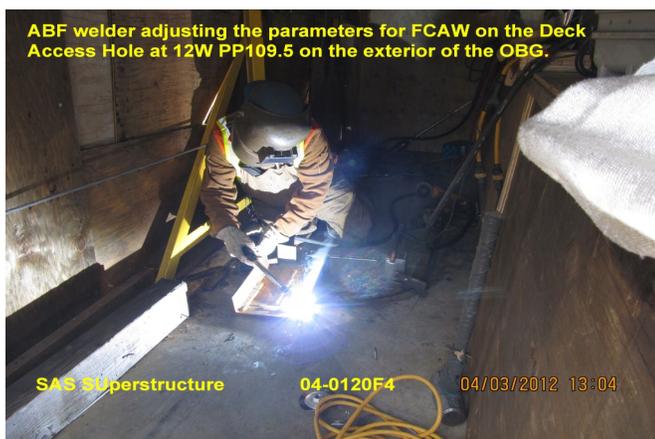
This QA Inspector made random observations of ABF welder Kit Lounechany (ID 4895) utilizing the Carbon Air Arc method to remove weld metal from the weld root side of the joint (back gouge) on the Deck Access Hole (DAH) located at 12E PP109.5 E5 on the interior of the OBG. The welder was observed cleaning the joint by employing a small disc grinder, rotary drill with grinding bit and compressed air to achieve the desired joint dimensions. On a subsequent observation, the welder was noted as continuing the back gouging process and cleaning the joint. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appeared to be in general conformance with the contract specifications.

13W PP118.5 W4-CCO19151 (Interior)

On random observations, this QA Inspector observed ABF welder Rory Hogan utilizing a cutting torch to penetrate the floor beam in the vicinity of 13W PP118.5 W4 on the interior of the OBG. The welder was observed performing the layout and cutting for the 73mm x 160mm schedule 80 pipe sleeve. CCO19151 and RFI2769RO was referenced as a time and materials project and all pertinent information was documented. ABF welding personnel was observed cleaning the penetration with a small disc grinder to smooth the edges of the hole and allow the pipe fit-up. This QA Inspector made subsequent observations and noted that the work was in progress and appeared to be in general conformance with CCO19151 and RFI2769RO.

Summary of Conversations:

This QA inspector met with QA Inspector Ken Riley to coordinate inspections required and welder assignments.



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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

your project.

Inspected By: Frey,Doug

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer