

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-027420
Date Inspected: 09-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:	Salvador Merino	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:

On this date, Quality Assurance Inspector (QAI) Kenneth Riley was present at the San Francisco Oakland Bay Bridge job site at Yerba Buena Island to observe erection and welding activities for the San Francisco Oakland Bay Bridge (SFOBB) project. This Quality Assurance Inspector (QAI) observed the following work performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below:

Deck Access Holes (DAH)

This QAI observed that the contractor had fit up the DAH at 12W PP109.5 W2. Salvador Sandoval was observed as placing the Shielded Metal Arc Welding (SMAW) root pass at this location. The electrode being used was a 3.0mm diameter E7018 for the Complete Joint Penetration (CJP) weld. The Welding Procedure Specification (WPS) used was ABF-WPS-D15-1040C with a measured welding amps of 135 F. The pre-heat for this location was measured at 65 degrees C (150 degrees F) using a weed burner which were verified using a tempstik and infrared gun by the QC. This QAI was informed that the fit up was checked and accepted on Friday the 6th of April by QC inspector Steve McConnell. The welder was also observed by this QAI as using a chipping hammer, power grinder and power wire wheel for the interpass cleaning. The QC inspector for this location was Salvador Merino and was observed verifying and documenting the welding parameters for this location, along with overseeing the welding operations. At the time of the observations no issues were noted by the QAI.

This QAI observed that the contractor had completed the weld at DAH at 12E PP109.5 E5 and in the process of grinding the weld flush for the proper weld profile to within 1 mm of flush. The welder Khit Lounechaney was observed as being in the overhead position on the interior (inside) using a power grinder. The QC inspector for this location was Salvador Merino and was observed in the area overseeing this operation being performed. Also noted

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

was location 12W PP109.5 W5 were the contractor had an apprentice performing the grinding function on the exterior (outside) of the weld for this DAH. At the time of the observations no issues were noted by the QAI.



Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI and ABF QC personnel.

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: Riley, Ken

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer
