

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-027433
Date Inspected: 11-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:	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.

Longitudinal Stiffener plate:

The QA inspector performed the required 10% Magnetic Particle Test (MT) and Ultra Sonic (UT) and found no relevant indication at this time on this date at the following locations: 8E-PP70.5-E5-LSW/E and 8E-PP70.5-E2-LSW/E

The QA Inspector at random intervals, observed ABF welder Steve Davis (ID 7889) perform the Shielded Metal Arc Welding (SMAW) process in the 3G vertical position on face "B" of the longitudinal stiffener plate 6W-PP46.5-W2-LSE on the interior of the OBG. The welder was observed utilizing 3.2mm E9018-H4R electrodes obtained from a baking oven and drawing amperage of 125. QC Inspector was on hand to monitor the welding, parameters and measure the inter-pass temperatures as they apply to ABF-WPS-D1.5-101231. On subsequent observations the welder was observed cleaning the work between passes by employing a small disc grinder, brushes and compressed air. The QA Inspector noted the welder performed the post weld heat treatment (PWHT) after welding using the same preheat temperature and heating machine and held it for three hours as required. The QA Inspector noted the welding at this location completed at this time on this date. The QA Inspector noted the welding at this location not to be complete on this date.

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The QA Inspector at random intervals, observed ABF welder Tod Jackson (ID 4639) perform the Shielded Metal Arc Welding (SMAW) process in the 3G vertical position on face “B” of the longitudinal stiffener plate 8E-PP61.5-E5-LSE on the interior of the OBG. The welder was observed utilizing 3.2mm E9018-H4R electrodes obtained from a baking oven and drawing amperage of 115. QC Inspector was on hand to monitor the welding, parameters and measure the inter-pass temperatures as they apply to ABF-WPS-D1.5-1012-3. On subsequent observations the welder was observed cleaning the work between passes by employing a small disc grinder, brushes and compressed air. The QA Inspector noted the welding at this location completed at this time on this date.

Later in the shift the QA Inspector at random intervals, observed ABF welder Tod Jackson (ID 4639) perform the Shielded Metal Arc Welding (SMAW) process in the 3G vertical position on face “A” of the longitudinal stiffener plate 8E-PP61.5-E5-LSW on the interior of the OBG. The welder was observed utilizing 3.2mm E9018-H4R electrodes obtained from a baking oven and drawing amperage of 115. QC Inspector was on hand to monitor the welding, parameters and measure the inter-pass temperatures as they apply to ABF-WPS-D1.5-1012-3. The QA Inspector noted the work at this location not completed at this location on this date.

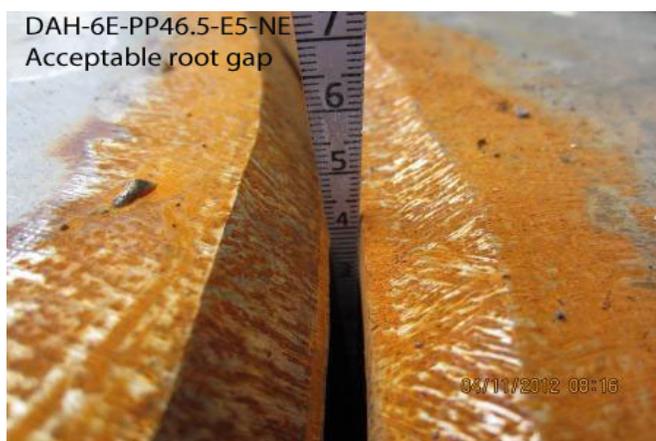
Interior Deck Access Hole:

The QA Inspector at random intervals, observed ABF welder Mike Jiminez (ID 4671) perform the Shielded Metal Arc Welding (SMAW) process in the 3G vertical position on face “A” of the transverse stiffener at DAH-5W-PP36.5-W2-TS on the interior of the OBG. The welder was observed utilizing 3.2mm E7018-H4R electrodes obtained from a baking oven and drawing amperage of 128. QC Inspector was on hand to monitor the welding, parameters and measure the inter-pass temperatures as they apply to ABF-WPS-D1.5-1010-1. On subsequent observations the welder was observed cleaning the work between passes by employing a small disc grinder, brushes and compressed air. The QA Inspector noted the welding at this location not completed at this time on this date.

Exterior Deck Access Hole:

The QA Inspector verified the root gap opening and found it to be acceptable at location DAH-6E-PP46.5-E5-NE.

Work performed appears to be in general compliance with contract documents.



Summary of Conversations:

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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
