

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-027438**Date Inspected:** 10-Apr-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:** On Site**CWI Name:** Sal Marino and Steve Jensen**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 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:

Segment 12E PP 109.5:

This QA Inspector observed ABF welder Kit Lounechaney (Welder ID 4985) performing the fillet weld operation per the Shielded Metal Arc Welding (SMAW) process in the (3G) vertical position connecting the transverse stiffener (A709 Grade 345) to longitudinal stiffeners LS4 and LS5 (A709 Grade 485 HPS) between grid E4 and grid E5 on Segment 12AE at Panel Point PP 109.5.

This QA Inspector observed QC Inspector Sal Marino verify prior to the start of the fillet 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 F1200A Revision 0 using E7018 three (3) mm diameter electrode.

This QA Inspector observed that the fillet weld operation connecting the transverse stiffener to longitudinal stiffeners LS4 and LS5 were still in-process at the end of this QA Inspectors' shift.

FW Spencer - On site:

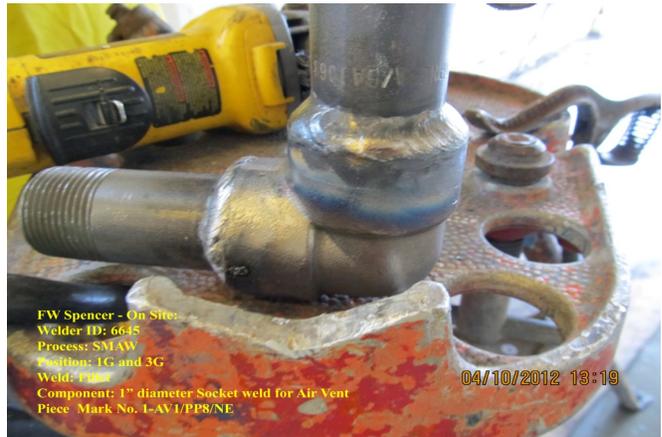
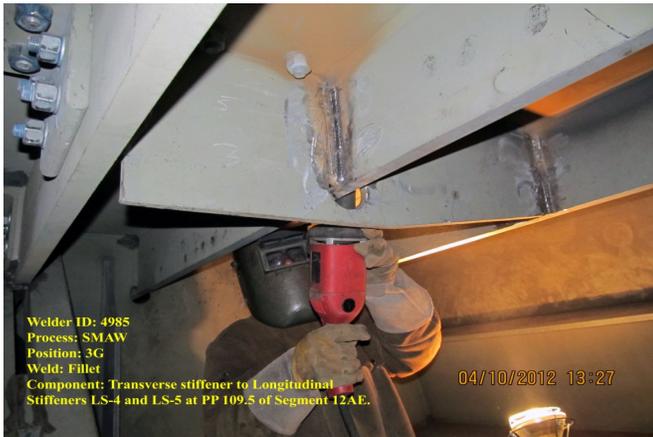
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This QA Inspector observed ABF welder Damien Llanos (Welder ID 6645) performing the fillet weld operation per the Shielded Metal Arc Welding (SMAW) process in the (1G) and (3G) flat and vertical positions on one (1") diameter socket welds for an air vent line identified as 1-AV1/PP8/NE.

This QA Inspector observed QC Inspector Steve Jensen verify prior to the start of the fillet 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 FWS Fillets Murex SFOBB Revision 1 using E7018 3/32" diameter electrode.

This QA Inspector observed that the fillet weld operation on the one (1") diameter socket welds were still in-process at the end of this QA Inspectors' shift.



Summary of Conversations:

Only general conversations between this QAI 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.

Inspected By: Peterson, Art

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer
