

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-027441**Date Inspected:** 11-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:** Bernie Docena**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:** Skyway portion of SFOBB**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Art Peterson arrived on the jobsite between the times noted above to randomly observe Quality Control (QC) personnel monitor the welding operations performed by American Bridge Fluor (ABF) personnel on the Skyway portion of the SFOBB. The following observations made were for extra work being performed to the following contract change order:

Skyway Portion of the SFOBB:

CCO: 193 - Description: Modify the existing bikepath panels at the expansion joints of the Skyway portion of the SFOBB East Span Seismic Safety Program.

This QA Inspector randomly observed ABF personnel Mr. Jason Collins performing the preheat operation to remove the moisture in the groove area and adjacent to the groove area of the partial-joint penetration groove weld on the top plate, side plates and bottom soffit plates prior to performing the welding of the partial-joint-penetration (PJP) groove weld.

Afterwards, this QA Inspector observed a linear indication on the bottom soffit plate where the traveler rail plate piece mark no. ab1308 is fillet welded to the bottom soffit plate. The linear indication was formed where the bottom soffit plate is fitted to the traveler rail plate mark no. ab1308 as a square-butt and only fillet welded to the exterior side of the soffit only. The traveler rail plate mark no. ab1308 was partially removed so the new end plate "F1" could be fit and welded to seal the end of the bike path at expansion joint Hinge AE.

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The disposition was to grind into the edge of the soffit plate and add weld metal to fuse the traveler rail plate mark no. ab1308 to the soffit plate to ensure sound metal prior to completing the partial-joint penetration groove weld of the new end plate "F1" to the end of the bike path.

This QA Inspector observed welder Jason Collins (Welder ID 8128) performing the partial-joint penetration groove welding per the Flux Cored Arc Welding (FCAW) process in the (1G) flat position connecting the bike path top plate to the new end plate at the expansion joint Hinge "A" as per ABF Submittal no. 2549R2 of Contract Change Order (CCO) 193.

This QA Inspector observed QC Inspector Mr. Bernie Docena verify prior to the start of the partial-joint penetration groove weld operation that the preheat temperature of 150 degrees F was established and afterwards verified that the welding parameters (Amps, Volts and Travel Speed) were in accordance with ABF-WPS D15-2160-1 using the NR232 .072" diameter electrode.

The partial-joint penetration groove welding of the new end plate "F1" to the top plate of the bike path panel was still in process at the end of this QA Inspectors' shift.



Summary of Conversations:

This QA Inspector notified Lead Inspector Danny Reyes of the indication observed at expansion joint Hinge AE regarding the traveler rail plate mark no. ab1308 and the bottom soffit plate.

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