

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-027443**Date Inspected:** 12-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 the 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 observed welder Jason Collins (Welder ID 8128) performing the partial-joint penetration groove welding per the Flux Cored Arc Welding (FCAW) process in the (3G) vertical position connecting the bike path side plates to the new end plate at the expansion joint Hinge "AE" 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 D15-2160-3 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

WELDING INSPECTION REPORT

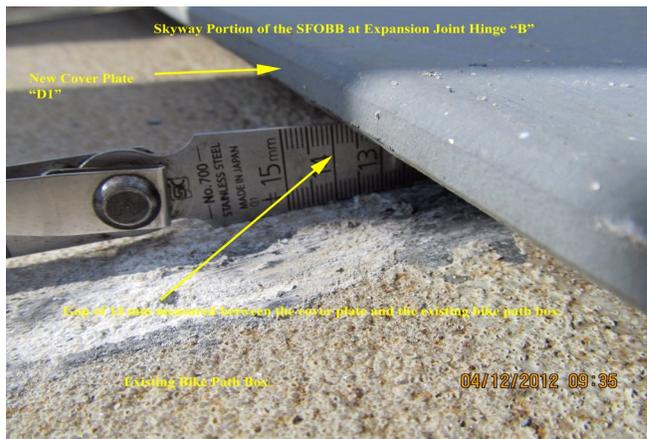
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still in process at the end of this QA Inspectors' shift.

Expansion Joint Hinge "B", Hinge "C", and Hinge "D":

This QA Inspector also observed ABF personnel installing the new cover plate "D1" at Expansion Joint Hinge "B", Expansion Joint Hinge "C" and Expansion Joint Hinge "D" using the 7/8" Stainless Steel flat head cap screws. The installation of the 7/8" flat head cap screws were not installed in all (66) locations at this time. The installation was for information only to see how the new cover plate "D1" fit at Expansion Joints Hinge "B", Hinge "C", and Hinge "D" on the Skyway portion of the SFOBB.

This QA Inspector observed at Expansion Joint Hinge "B" that the new cover plate "D1" did not fit flush to the existing bike path box. This QA Inspector measured using a taper gauge a gap of 14 mm between the new cover plate "D1" and the existing bike path box. This QA Inspector notified Lead Inspector Bill Levell whom notified Caltrans OSM METS SMR Aaron Prchlik who met this QA Inspector at Expansion Joint Hinge "B" to observed the existing condition of the gaps observed between the new cover plate "D1" and the existing bike path box.



Summary of Conversations:

Only general conversations between this QAI and the QC Inspector 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