

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-027448**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:** 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 at random intervals, observed ABF welder Steve Davis (ID 7889) cut off the run off tabs and grind the welds down to a smooth finish. The QA Inspector noted the welder performed the post weld heat treatment (PWHT) after welding the previous work day on 4-11-12 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 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 108. 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. 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

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

this location completed at this time 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 4G overhead position on face "B" of the transverse stiffener at DAH-5W-PP36.5-W2-NE 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 124. 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.

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



Summary of Conversations:

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
