

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-027454**Date Inspected:** 13-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**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:** Bike Path Panel on Skyway Portion**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 existing bike path box panel 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 welder Jason Collins (Welder ID 8128) performing the root, fill, and cover pass weld operation on a partial-joint-penetration (PJP) groove weld per the Shielded Metal Arc Welding (SMAW) process in the (2G) horizontal position connecting the new end plate "F1" to the existing soffit plate of the bike path box panel at the expansion joint hinge "AE" as per ABF Submittal no. 2549R2 of Contract Change Order (CCO) 193.

This QA Inspector observed QC Inspector Sal Marino verify prior to the start of the root, fill, and cover pass weld operation that the preheat temperature of 150 degrees F was established and afterwards verified that the welding parameters (Amps and Travel Speed) were in accordance with ABF-WPS F1200A using the E7018 (1/8") diameter electrode.

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The root, fill, and cover pass weld operation connecting the new end plate "F1" to the existing bike path box panel's soffit plate was in-process at the end of this QA Inspector's shift.

At the Expansion Joint Hinge "AE", this QA Inspector previously observed ABF personnel cut back the existing bike path box panels' top, side, stiffener, and diaphragm plates for a distance of (616) mm using an oxyacetylene cutting torch on a track system and the existing bike path box panels' soffit plate for a distance of (600) mm on the existing bottom soffit plate of the bike path panel.

The cut back distances were detailed on ABF Submittal number 2549R2 ABN-404 sheet 4 of 6.



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