

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027461**Date Inspected:** 17-Apr-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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:** OBG/Tower**Summary of Items Observed:**

At the start of the shift this Quality Assurance Lead Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Joselito Lizardo-Tower, 9 Meter El. (Observed the welding, QC inspection of diaphragm plate to shear plate, stiffener plates and perimeter channels) and PQR (Observation of welding of PQR soundness test).

Art Peterson-OBG W12 (Observation of welding, inspection and testing of deck access holes), OBG E8 (Observation of repair welding and QC inspection of deck access hole), OBG W8 and E12 (Observation of QC/NDE at deck access hole) and Bike Path-CCO193 (Observation of welding and QC inspection of end plate to bike path panel).

Scott Croff-OBG W5 (Observation of the welding and inspection of the deck access hole), OBG E6 (Observation of welding and inspection of deck access hole and longitudinal stiffeners) and Mechanical Piping at OBG E11 (Observation of welding and inspection of compressed air/utility water systems).

NOTE: See QA daily Weld Inspection Reports (WIR) and NDE reports for additional information and details.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, Scott Croff and Art Peterson monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and no issues were noted.

Tower 13 Meter El.

This QAI observed the excavation of the Electro-Slag Weld (ESW) joint (shear plate) identified as "J". The QC inspector, Jesse Cayabyab, performed a Visual and Magnetic Particle Test (VT and MPT) of the excavation and at the conclusion of the QC inspection this QAI performed the required VT, MPT and the dimensional verification. At the conclusion of the QA verification no issues were noted and QA concurs with QC assessment. At this time this QAI contacted and informed Robert Mertz of the field details of the excavation and inspection and test results, via cell phone and e-mail in regards to verbal approval to proceed. In regards to the excavation information Aaron Prchlik and William Levell was were notified by e-mail.

This QAI also observed welding personnel, Rory Hogan and Jeremy Dolman increasing the size of the weld access hole located at the tower base sump. At the conclusion of the cutting the welders proceeded the task of finishing the cut surface utilizing the grinding method.

Later in the shift this QAI observed QC Ultrasonic technician Bernard Docena performing the testing of the shear plate (ESW) identified as weld number W-042 joint "M". The QC/NDE was not completed during this shift.

Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

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:	Reyes,Danny	Quality Assurance Inspector
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Reviewed By:	Levell,Bill	QA Reviewer
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