

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-027462
Date Inspected: 18-Apr-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
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 and QC inspection of stiffener plates), 13 Meter El. (Observation the welding and QC inspection of the perimeter channels and diaphragm plates) and QA/MPT verification.

Danny Smith-Bike Path-CCO193 (Observation of QC inspection and testing of end plate to bike path panel) and Guard Rail #19, East Bound CCO179 (Observation of welding and QC inspection and testing).

Craig Hager-OBG E6(Observation of the welding and inspection of the deck access hole and longitudinal stiffeners), OBG E12 (Observation of welding and QC inspection of the deck access hole) and Mechanical Piping at OBG E11 (Observation of welding and inspection of compressed air/utility water systems).

Doug Frey-OBG W12 (Observation of welding and QC inspection of the deck access hole), OBG W8 (Observation of QC inspection and testing of the longitudinal and transverse stiffeners) and QA/MPT verification.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

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

Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, Craig Hager and Doug Frey 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 Shear Plates

This QAI observed the excavation of the Electro-Slag Weld (ESW) joint (shear plate) identified as "L" and "M". The QC inspector, Jesse Cayabyab, performed a Visual and Magnetic Particle Test (VT and MPT) of the excavations and at the conclusion of the QC inspection no rejectable indications were noted. At this time, the 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 details, regarding the excavations, inspection and test results, via cell phone and e-mail in regards to verbal approval to proceed.

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.

QAI, Craig Hager, inquired of the as built root opening of 20 mm regarding the Deck Access Hole (DAH) identified as 12E-PP109.5-E2 of the OBG E12. This QALI informed Mr. Hager that the contractor would correct the root opening by welding utilizing the Shielded Metal Arc Welding (SMAW) process as per Chapter 3, para. 3.3.4 of AWS D1.5-2002.

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
Reviewed By:	Levell, Bill	QA Reviewer
