

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-027477**Date Inspected:** 20-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:** 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:** SAS OBG Components**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Art Peterson arrived on site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and monitor the welding operations performed by American Bridge Fluor (ABF) welding personnel. The following observations were:

Segment 12W between PP109 and PP109.5 W5 Line - Deck Access Hole LS East:

This QA Inspector observed ABF welder Kit Lounechany (Welder ID 4985) performing the complete-joint penetration (CJP) groove weld operation (2nd side) per the Shielded Metal Arc Welding (SMAW) process in the (3G) vertical position connecting the Deck Access Hole (DAH) insert plate Longitudinal Stiffener (LS) East to the Deck "A" plate LS between panel point PP109 and PP109.5 along Grid line W5.

This QA Inspector observed QC Inspector Sal Marino verify prior to the start of the CJP groove weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterwards verified that the welding parameters (Amps and Travel Speed) were in accordance with WPS 1012-3 Revision 0 using E9018 (1/8") diameter electrode.

This QA Inspector observed ABF welder Kit Lounechany was still in-process welding the (2nd side) of the CJP groove weld at the end of this QA Inspectors' shift.

Segment 12W between PP109 and PP109.5 W2 Line - Deck Access Hole LS West:

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This QA Inspector observed ABF welder Steve Davis (Welder ID 7889) performing the complete-joint penetration (CJP) groove weld operation (1st side) per the Shielded Metal Arc Welding (SMAW) process in the (3G) vertical position connecting the Deck Access Hole (DAH) insert plate Longitudinal Stiffener (LS) West to the Deck "A" plate LS between panel point PP109 and PP109.5 along Grid line W2.

This QA Inspector observed QC Inspector Sal Marino verify prior to the start of the CJP groove weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterwards verified that the welding parameters (Amps and Travel Speed) were in accordance with WPS 1012-3 Revision 0 using E9018 (1/8") diameter electrode.

This QA Inspector observed ABF welder Steve Davis was still in-process welding the (1st side) of the CJP groove weld at the end of this QA Inspectors' shift.

Segment 12E between PP109 and PP109.5 E5 Line - Deck Access Hole LS West:

This QA Inspector observed ABF welder Todd Jackson (Welder ID 4639) performing the complete-joint penetration (CJP) groove weld operation (1st side and 2nd side) per the Shielded Metal Arc Welding (SMAW) process in the (3G) vertical position connecting the Deck Access Hole (DAH) insert plate Longitudinal Stiffener (LS) East to the Deck "A" plate LS between panel point PP109 and PP109.5 along Grid line E5.

This QA Inspector observed QC Inspector Steve Jensen verify prior to the start of the CJP groove weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterwards verified that the welding parameters (Amps and Travel Speed) were in accordance with WPS 1012-3 Revision 0 using E9018 (1/8") diameter electrode.

This QA Inspector observed ABF welder Todd Jackson completed the welding of the (1st side and 2nd side) of the CJP groove weld at the end of this QA Inspectors' shift.

Segment 12E between PP109 and PP109.5 E2 Line - Deck Access Hole:

This QA Inspector observed ABF welder Salvador Sandoval (Welder ID 2202) performing the complete-joint penetration (CJP) groove weld operation (top side) per the Flux Cored Arc Welding (FCAW) gas shielded process in the (1G) flat position connecting the Deck Access Hole (DAH) insert plate to the Deck "A" plate between panel point PP109 and PP109.5 along Grid line E2.

This QA Inspector observed QC Inspector Steve Jensen verify prior to the start of the CJP groove weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterwards verified that the welding parameters (Amps, Volts, and Travel Speed) were in accordance with WPS 3040A-1 using E71T1 (.072") diameter electrode.

This QA Inspector observed ABF welder Salvador Sandoval was still in-process welding the (top side) of the CJP groove weld at the end of this QA Inspectors' shift.

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Segment 12E between PP109 and PP109.5 E5 Line - Deck Access Hole:

This QA Inspector observed ABF welder Eddie Brown (Welder ID 9331) performing the non-critical repair weld operation of a complete-joint penetration groove weld per the Shielded Metal Arc Welding (SMAW) process in the (4G) overhead position after the repair areas (2) locations were gouged to sound metal to remove the ultrasonic rejectable indications on the Deck Access Hole (DAH) insert plate welded to the Deck "A" plate between panel point PP109 and PP109.5 along Grid Line E5.

This QA Inspector observed QC Inspector Steve Jensen verify prior to the start of the repair weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterwards verified that the welding parameters (Amps and Travel Speed) were in accordance with WPS 1000 Repair Revision 2 using E7018 (1/8") diameter electrode.

This QA Inspector observed that the non-critical repair weld operation of the DAH insert plate at the aforementioned location was completed at the end of this QA Inspectors' shift.



Summary of Conversations:

Only general conversations between this QAI and QC 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