

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-027487
Date Inspected: 24-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:	As noted 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:	SAS OBG		

Summary of Items Observed:

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

6E PP46.5 E5-DAH (Interior)

This QA Inspector made random observations of the in process Shielded metal Arc Welding (SMAW) of the Deck Access Hole (DAH) at 6E PP46.5 E5 on the interior of the OBG. ABF welder Mike Jimenez (ID 4671) was observed welding in the 4G overhead position utilizing 3.2mm E7018-H4R electrodes drawing amperage of 131. QC Inspector Sal Merino was observed monitoring the welding and the parameters to ensure compliance to ABF-WPS-D1.5-1110A-Revision 1 and measuring the inter-pass temperatures between passes. On a subsequent observation, the welder was observed grinding and blending the edges of the work utilizing a small disc grinder and brushes. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appeared to be in general conformance to the contract specifications.

FW Spencer Pipe Welding

This QA Inspector observed F.W. Spencer welder Damian Llanos ID# (6645) performing SMAW in all positions on schedule 80 pipe, weld #20/2.5/41/NE, and Weld # 1/DW1/34/NE. This QA Inspector verified the fit up of the joints and found it to be satisfactory and randomly observed QC Inspector Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The

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welder was observed utilizing 6010 electrodes in the root pass with the balance using 7018 electrodes and cleaning the weld after each pass utilizing a wire wheel on a small disc grinder. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appeared to be in general conformance with the contract documents.

12E PP109.5 E2-DAH (Interior)

This QA Inspector randomly observed ABF welder Edward Brown (ID 9331) perform the SMAW process in the 4G overhead position on the DAH located at 12E PP109.5 E2 on the interior of the OBG. Prior to welding Mr. Brown was observed pre-heating the B-U2a CJP joint to a minimum temperature of 20°C which was verified by the QC Inspector. This QA Inspector randomly observed the welder employing 3.2mm E7018-H4R electrodes drawing amperage of 119. QC Inspector Sal Merino was observed monitoring the welding to insure the parameters were in accordance with ABF-WPS-D15-1110A-Revision 1. The welder was also observed cleaning the work utilizing a small disc grinder, brushes and compressed air to clean to shiny metal so as to not introduce additional indications. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appeared to be in general accordance with the contract documents.

8W PP61.5 W2-DAH (Exterior)

This QA Inspector randomly observed Quality Control Inspector John Pagliero conducting Ultrasonic Inspection and Testing (UT) on the DAH located at 8W PP61.5 W2 on the exterior of the OBG. It was noted that Mr. Pagliero had identified nine (9) rejectable indications listed below.

y+ 560mm: 40mm in length and 9mm deep.
y+1855mm: 50mm in length and 14mm deep.
y+1865mm; 20mm in length and 12mm deep.
y+2000mm; 90mm in length and 18mm deep.
y+2440mm; 30mm in length and 13mm deep.
y+2685mm; 30mm in length and 12mm deep.
y+2775mm; 30mm in length and 13mm deep.
y+2875mm; 40mm in length and 12mm deep.
y+3365mm; 30mm in length and 11mm deep.

Deck Panel SA3214A (West)

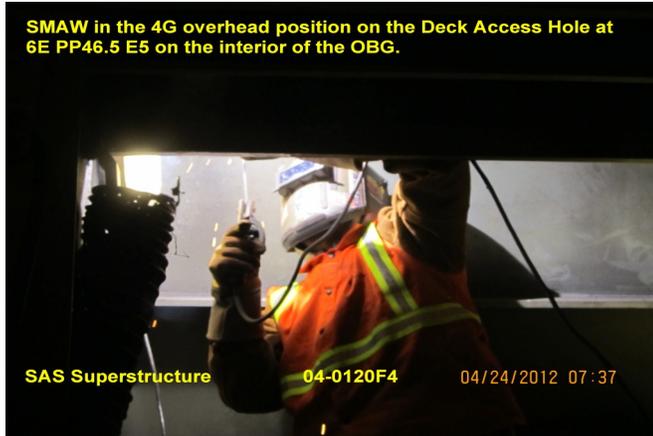
This QA Inspector randomly observed ABF personnel using the 4100 Ringer Crane, lift deck panel SA3214A from a storage barge, and place it on the OBG deck. The workers used bolts and pins to temporarily secure it in place. It was noted that the welding of the temporary attachment alignment fit-up gear did not commence on this date. Submittal ABF-SUB-002652R00 was reference during this QA Inspectors observation.

Summary of Conversations:

There were no pertinent conversations on this date..

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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: Frey,Doug

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer