

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-027493**Date Inspected:** 25-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:** Job Site

CWI Name:	As noted below		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A
Component:	SAS OBG		

Bridge No: 34-0006**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:

FW Spencer Pipe Welding

This QA Inspector observed F.W. Spencer welder Damian Llanos ID# (6645) performing SMAW in all positions on 4" schedule 80 pipe, located at 5E PP35.5 E5. 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 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.

Deck Panel SA3214A (East)

This QA Inspector made random observations of ABF welding personnel performing SMAW on Deck Panel SA3214A East on the exterior of the OBG. This QA Inspector randomly observed ABF welder Mike Jimenez utilizing 3.2mm E7018-H4R electrodes in the 1G flat position at 13E PP 122.2 @ 8600mm. The welder was observed cleaning the start/stop edges of the work by employing a die grinder with a conical tipped bit. QC

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Inspector William Sherwood was present to monitor the welding and the parameters as they pertained to ABF-WPS-D1.5-1040C-Revision 1. On a subsequent observation, the welder was observed continuing his work in the same manner and was noted that the work is in progress. This QA Inspector made random observations of ABF welder Salvador Sandoval (ID 2202) performing the SMAW process in the 1G flat position on a B-U2a Complete Joint Penetration (CJP) joint on 13E-E2.8 @ 11970mm. The welder was observed utilizing 3.2mm E7018-H4R electrodes drawing amperage of 119. Prior to welding, Mr. Sandoval was observed pre-heating the joint to 150°F and was verified by this QA Inspector utilizing a 150°F Tempilstik. QC Inspector William Sherwood was present to monitor the welding and the parameters as they pertained to ABF-WPS-D1.5-1040C-Revision 1. On a subsequent observation, the welder was observed cleaning the work utilizing a small disc grinder to grind and blend the weld for a smooth transition. It was noted that the work at this location was in progress. This QA Inspector randomly observed ABF welder Khit Lounechaney (ID 4985) performing SMAW in the 1G flat position located at 13E-E2.1 @ 2500mm. QC Inspector William Sherwood was present to monitor the welding and the parameters as they pertained to ABF-WPS-D1.5-1040C-Revision 1. The welder utilized 3.2mm E7018-H4R electrodes and this QA Inspector verified that they were obtained from a baking oven set at the correct temperature of 250°F. The welder was observed cleaning the work between passes and it was noted that the work at this location was in progress. This QA Inspector randomly observed ABF welder Edward Brown (ID 9331) performing the SMAW process in the 1G flat position on a B-U2a CJP joint located at 13E-E2.2 @ PP124.5. QC Inspector William Sherwood was present to monitor the welding and the parameters as they pertained to ABF-WPS-D1.5-1040C-Revision 1. The welder was observed cleaning the work between passes and utilized 3.2mm E7018-H4R electrodes and drew amperage of 123. The work at this location was noted as being in progress and this QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work at these locations is in progress and appeared to be in general conformance with the contract documents.

Summary of Conversations:

There were no pertinent conversations 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.

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Inspected By:	Frey,Doug	Quality Assurance Inspector
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Reviewed By:	Levell,Bill	QA Reviewer
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