

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-027498**Date Inspected:** 18-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:	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

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:

12W PP109.5 W5-DAH (Interior)

This QA Inspector randomly observed ABF welder Khit Lounechaney (ID 4985) employing small disc grinders, brushes and compressed air to remove excessive metal and reinforcement from the interior side of the Deck Access Hole (DAH) at 12W PP109.5 W5. This QA Inspector at random intervals, observed the welder conducting clean-up operations on the excessive weld reinforcement and on a subsequent observation this QA Inspector randomly observed the welder grinding and blending the excessive reinforcement of the weld utilizing a small disc grinder and the Carbon Air Arc method to remove the metal to a near flush surface condition, it was noted that no welding commenced on this date at this location. This QA Inspector made random observations of Shielded Metal Arc Welding (SMAW) on the DAH on the interior of the OBG at 12W PP109.5 W2. ABF welder Steve Davis (ID 7889) was observed utilizing E7018-H4R electrodes and this QA Inspector verified that the electrodes were recently obtained from a baking oven. QC Inspector Steve Jensen was observed measuring the inter-pass temperatures by employing an infra-red temperature gun as well as monitoring the welding and the parameters. It was noted that the welder was drawing amperage of 125 utilizing 3.2mm electrodes. The welder was observed grinding the start/stop edges of the work utilizing a small disc grinder and cleaning excess debris with compressed air. The welder was observed running multiple pass stringers while adhering to ABF-WPS-D1. 5-1010-1. On a subsequent observation, the welder was observed continuing work on the B-U2a Complete

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penetration Joint (CJP) and was employing the Carbon Air Arc technique to remove metal previously placed that Mr. Davis considered unacceptable. 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 with the contract specifications.

8W PP70.5 W2-LSW (Interior)

This QA Inspector randomly observed QC Inspector John Pagliero performing MT inspection on the East Longitudinal Stiffener (LSE), the LSW and the Transverse Stiffener of the DAH located at 8W PP70.5 W2 on the interior of the OBG. Mr. Pagliero found no rejectable indications and found the testing to be satisfactory. Upon completion of the MT testing, Mr. Pagliero performed an Ultrasonic Inspection of the three (3) Stiffeners. It was noted that Mr. Pagliero found no rejectable indications and this QA Inspector performed MT testing on the Stiffeners. This QA Inspector performed the MT method utilizing the AC yoke in conformance with ASTM E 709 and the standard of acceptance with D1.5 section 6.26. This QA Inspector noted that no rejectable indications were found at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work at this location appeared to be in general conformance with the contract specifications.

This QA Inspector conducted a Deck Access Hole Survey to track progress and schedule required testing and inspections as instructed by the Lead QA Inspector. This QA Inspector reviewed tracking and NDT logs.

Summary of Conversations:

There were general conversations with Quality Control Inspector, Jesse Cayabyab 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: Frey,Doug

Quality Assurance Inspector

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Reviewed By: Levell,Bill

QA Reviewer