

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-027522**Date Inspected:** 30-Apr-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** On Site**CWI Name:** Bernie Docena**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 13E Grid Line E2.8 Deck Plate Drop-in Section Longitudinal Field Weld Splice

This QA Inspector observed ABF Welder Mike Jimenez (Welder ID 4671) performing the root pass weld operation per the Shielded Metal Arc Welding (SMAW) process in the (1G) flat position on the (top side) of the Deck Plate Drop-in Section Longitudinal Field Weld Splice on Segment 13E along Grid Line E2.8.

This QA Inspector observed QC Inspector Bernie Docena verify prior to the start of the root pass 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 D1.5-1040C-CU Revision 0 using E7018 (1/8") and (5/32") diameter electrode.

This QA Inspector observed that ABF welder Mike Jimenez was in-process on the root pass weld operation on the Deck Plate Drop-in section Longitudinal Field Weld Splice along Grid E2.8 at the end of this QA Inspectors' shift.

Segment 13E/14E Deck Plate Drop-in Section Transverse Field Weld Splice

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector observed ABF welder Salvador Sandoval (Welder ID 2202) performing the root pass weld operation per the Shielded Metal Arc Welding (SMAW) process in the (1G) flat position on the (top side) of the Deck Plate Drop-in Section Transverse Field Weld Splice on Segment 13E/14E.

This QA Inspector observed QC Inspector Bernie Docena verify prior to the start of the root pass 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 D1.5-1040C-CU Revision 0 using E7018 (1/8") diameter electrode.

This QA Inspector observed that ABF welder Salvador Sandoval was in-process on the root pass weld operation on the Deck Plate Drop-in section Transverse Field Weld Splice along 13E/14E at the end of this QA Inspectors' shift.

Segment 13E Panel Point (PP) 122.2 - Deck Plate Drop-in Section Transverse Field Weld Splice

This QA Inspector observed ABF Welder Steve Davis (Welder ID 7889) performing the root pass weld operation per the Shielded Metal Arc Welding (SMAW) process in the (1G) flat position on the (top side) of the Deck Plate Drop-in Section Transverse Field Weld Splice on Segment 13E along PP 122.2.

This QA Inspector observed QC Inspector Bernie Docena verify prior to the start of the root pass 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 D1.5-1040C-CU Revision 0 using E7018 (1/8") diameter electrode.

This QA Inspector observed that ABF welder Steve Davis was in-process on the root pass weld operation on the Deck Plate Drop-in section Transverse Field Weld Splice along PP 122.2 at the end of this QA Inspectors' shift.



Summary of Conversations:

Only general conversations between this QAI and the QC Inspector 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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

your project.

Inspected By: Peterson, Art

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer