

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027535**Date Inspected:** 01-May-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:** Pier 7 Job Site**CWI Name:** Steve Jensen**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:** S.A.S. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI witnessed work in progress related to Contract Change Order (CCO) 179. The QAI noted that the shielded metal arc welding (SMAW) fillet welding is being performed by Jason Collins, ID 8128. At each access gate location, 2 retainer arms and 2 stoppers are being fit-up and welded. The QAI noted that the Quality Control Inspector (QCI) Steve Jensen is monitoring this work. The QAI was informed that the welding procedure specification (WPS) being used is ABF-WPS-D15-F1200A Rev.2. During this shift, the QAI made random observations of the work in progress. The QAI noted that the welding appeared to be within the requirements of the WPS and the work appeared to follow the CCO details. The QAI noted that access gate 21 and 24 have been installed and the work at access gate 25 was in progress at the end of the shift. The QAI was informed that several of the gates have not been installed due to the elevation and height of surrounding hand railing. The QAI was informed that the contractor will inquire if the gates should be raised to match the hand rails but there has been no determination at this time. See the attached photo.

The QAI witnessed work in progress in the warehouse at pier 7. The QAI met with F.W. Spencer personnel and the contractors' Quality Control Manager Chuck Kanapicki. The QAI was informed that there will be welding of dehumidification duct supports onto the SAS main cable saddle shrouds, and that this work was originally scheduled to be done at the ZPMC welding facility. The QAI was informed that a question regarding welding qualifications, as the F.W. Spencer personnel are only qualified to AWS D1.1 requirements and not AWS D1.5. The QAI noted that a Request For Information (RFI) would be submitted to clarify the welder qualification

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requirements. The QAI noted that SMAW fillet welding of the duct supports was started and being performed by Damien Llanos, ID 6845. The QAI noted that the QCI Steve Jensen is monitoring this welding. The QAI noted that the West Deviation Saddle Housing (WDSH) East, parts 7-14 have been laid out and the work is being performed on them. The QAI was informed that the WDSH West parts will be welded after these are complete. See the attached photo.

The QAI reviewed contract documents at pier 7. The QAI used approved weekly welding report submittals and cross referenced the welding and inspection status as reported with QA records to identify the overall weld status. The QAI assisted in reviewing blue tag issues that are pending completion by the contractor. There were discussions between the QAI, the QAI Art Peterson, the QAI Lead Bill Levell and the Assistant Structural Materials Representative (ASMR) Parinaz Aghili, regarding the status of items. The QAI was tasked to continue reviewing an outstanding Request For Information (RFI) that originated from Team China (TC). The QAI reviewed TC-RFI-348R9 and noted that previous inspections of the pending work indicated that this item has not been completed. The QAI will follow up with another on-site examination of the parts tomorrow.



Summary of Conversations:

The QAI relayed the status of the CCO 179 work, WDSH cover / duct support welding and document reviews to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations.

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: Croff, Scott

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer
