

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-027536**Date Inspected:** 02-May-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**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 25, 27 and 28 have been installed and welded during this shift. The QAI noted that gate 1, 22, 23 and 26 have not had any work performed while gates 4, 10 and 12 have been partially completed at this time. The QAI noted that these are resulting from the previously reported elevation differences.

The QAI witnessed work in progress in the warehouse at pier 7. The QAI observed welding of dehumidification duct supports onto the SAS main cable saddle shrouds. The QAI noted that a Request For Information (RFI) to clarify the welder qualification requirements has not been approved at this time and the welding continued, as directed by the contractor. The QAI noted that SMAW fillet welding of the duct supports is being performed by F. W. Spencer welder 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 have been completed and the West parts are being prepared for welding.

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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. 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 attempted to make field observations of the items listed in the TC-RFI. The QAI noted that there is insufficient access and lighting to examine the areas of interest. The QAI will relay this to the Assistant Structural Materials Representative (ASMR) Parinaz Aghili.

Summary of Conversations:

The QAI relayed the status of the CCO 179 work, dehumidification 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
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Reviewed By:	Levell,Bill	QA Reviewer
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