

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-027537**Date Inspected:** 03-May-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Pier 7 Job Site**CWI Name:** Salvador Merino**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 contractor was preparing to perform shielded metal arc welding (SMAW) fillet welding at the access gates but due to inclement weather, no work was performed. The contractor's personnel started working at a different area on non-welded items. There was no welding performed on the skyway during this shift.

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 and West parts have been completed. The QAI witnessed the QCI Salvador Merino conducting Magnetic Particle Testing (MT) on the completed welds. The QAI was informed that the welds are acceptable and will be zinc primed. The QAI conducted MT verification testing and noted that the welds appeared to be conforming to AWS D1.1 requirements. See the attached photo. Reference the TL-6028 report for additional information. The QAI was informed that the Jacking Saddle Housing shroud pieces will be fit up and welded during the next shift.

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Summary of Conversations:

The QAI relayed the status of the CCO 179 work and dehumidification duct support welding 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