

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-027539
Date Inspected: 24-Apr-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Job Site

CWI Name:	See Below	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:	OBG/Tower	

Summary of Items Observed:

At the start of the shift this Quality Assurance Lead Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Joselito Lizardo-Tower, 13 Meter El. (Observed the welding and QC inspection of diaphragm plates and shear plate to diaphragm plate), Tower Base (Observation of welding and QC inspection of bearing stiffener) and 9 Meter El.(Observed welding and QC Inspection of doubler plate to shear plate).

Doug Frey-OBG W8 (Observation of QC inspection and testing of the deck access hole), FW Spencer (Observation of welding and QC inspection of mechanical piping) and OBG E12 (Observation of welding and QC inspection of deck access hole).

Art Peterson-OBG E12 (Observation of welding and QC inspection of deck access hole) and East Drop-In Plates (Observation of welding of temporary attachments, alignment of plate members and QC inspection).

Issue #1: U-Ribs at East Drop-In. See QALI response below.

Craig Hager-Tower Base (Observation of welding and QC inspection of bearing stiffener plates), ESW

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(Observation of QC inspection and testing), 13 Meter El. (Observed the welding and QC inspection of diaphragm plates and shear plate to diaphragm plate), Tower Base (Observation of welding and QC inspection of bearing stiffener) and 9 Meter El. (Observed welding and QC Inspection of doubler plate to shear plate) and QA/MPT verification.

Danny Smith-Skyway (Observation of welding and QC inspection of guard rail brackets at gates #9, #10 and #11.

NOTE: See QA Daily Weld Inspection Reports (WIR) and NDE reports for additional information and details.

Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, Art Peterson Danny Smith, Craig Hager and Doug Frey monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and no issues were noted.

This QALI continued the daily review of field inspection reports and update of the field document control tracking records regarding the Orthotropic Box Girders (OBG, Longitudinal and Transverse "A" Deck Stiffeners, Deck Access Holes and the Tower Shear plates).

At the request of William Levell, this QALI assisted Structures Representative, Paul Jefferson, with the measuring of welds located at the west OBG identified as W13. This task encompassed the verification of the weld size of the vertical leg of a bolted splice plate connection to verify if there was possibility of the weld interfering with bolting of the splice plate.

Issue # 1-This QALI was also informed by QAI, Art Peterson of the cutting of three (3) U-Ribs to for the purpose of installing the copper backing plate at the east drop-in panel field splice identified as 13E-PP122.2. This situation occurs at six (6) places, that is two (2) cuts per U-Rib. This QALI instructed Mr. Peterson to draft and submit an Incident Report (IR) in regards to this issue.

Later in the shift, this QALI met with Structural Materials Representative (SMR), Bahjat Dahger, to confirm the as built condition of the U-Ribs.

Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

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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:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
