

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-027540**Date Inspected:** 24-Apr-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** Listed 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:** S.A.S. Structure**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA) David R Gray was at the American Bridge Fluor (ABF) job site between times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

The QA Inspector met with QA inspectors Danny Reyes and Douglas Frey. The QA inspectors met with the Quality Control (QC) personnel and there was an orientation of the jobsite. The QA Inspector also reviewed work being done to date.

F.W. Spencer Pipe Welding

This QA Inspector observed F.W. Spencer welder Damian Llanos ID# 6645 performing Shielded Metal Arc Welding (SMAW) in all positions on a schedule 80 2.5" compressed air line fitting Weld numbers 20/2.5/41/NE, 1/DW1/34/NE. This QA Inspector verified fit-up of the joints and appeared to be satisfactory. The QC Inspector Steve Jensen was observed monitoring the welding parameters for compliance to Welding Procedure Specification (WPS)-1-12-1 Revision 2 (1.12). The welder was observed utilizing E6010 electrodes for the root pass and E7018 electrodes for fill and cover passes cleaning each pass with a power wire wheel brush. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general accordance with plans and specifications.

6E PP46.5 E5-DAH (Interior)

This QA Inspector observed A.B.F. welder Mike Jimenez ID# 4671 welding in the 4F overhead position using 3.2mm E7018-H4R electrodes with an average of 130amps. This welding was in progress during the entire shift. QC

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Inspector Salvador Merino was observed monitoring the welding parameters for compliance to ABF-WPS-D1. 5-1110A-Revision 1 and measuring inter-pass temperatures between passes. During subsequent observations it was noted that the welder was using a power disc grinder at weld starts and stops as needed and was cleaning between weld passes with power wire wheel brushes. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general accordance with the project plans and specifications.

Summary of Conversations:

Except as noted above no significant conversations were held 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 your project.

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| Inspected By: | Gray,David | Quality Assurance Inspector |
| Reviewed By: | Levell,Bill | QA Reviewer |
