

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-027546**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:** 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:

Robert DeArmond-E13 Drop-In Panels (Observation of welding and QC inspection of panels) and Tower ESW (QA/UT verification and documentation of UT recordable indications).

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

Doug Frey-OBG W13 Drop-In Panels (Observation of fit-up, utilizing fitting gear, and tack welding) and QA/MPT & UT verification.

Scott Croff-(Observation of welding and QC inspection of guard rails, CCO-179), FW Spencer (Welding of dehumidification duct supports to cable shrouds) and review of punchlist items.

Art Peterson-E13 Drop-In Panels (Observation of welding and QC inspection of panels).

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Issue #1-Regarding planar misalignment. See QALI response below.

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, Robert DeArmond 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).

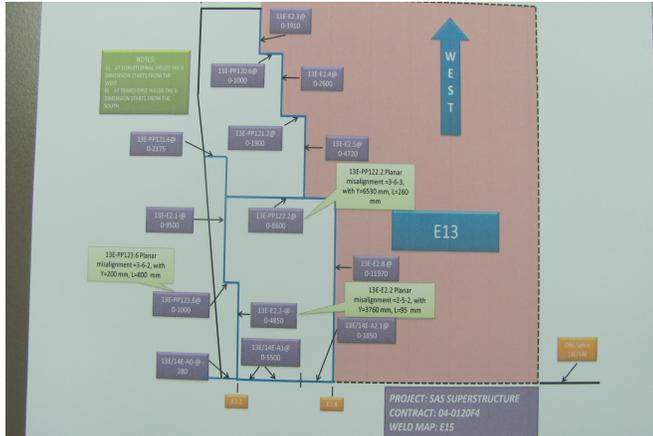
Issue # 1, E13 Drop-In Panels-This QAI, with the assistance of QAI Art Peterson observed the planar misalignment of three (3) areas of which had been previously approved to proceed with the welding. The planar misalignment dimensions were recorded as 6 mm maximum and 2 mm minimum. This issue occurred at the following areas and are identified as weld numbers: 13E-PP122.2, 13E-PP123.6 and 13E-E2.2. It appears that the welding personnel were removing the key plates prior to completing the welding. This information was forwarded to QA Supervisor William Levell and Structural Materials Representative (SMR) Bahjat Dahger.

Later this QALI informed QAI personnel Art Peterson, Doug Frey, Joselito Lizardo and Robert DeArmond to continually monitor and verify the planar alignments during the welding process.

The digital photograph below illustrates the areas of planar misalignment of OBG E13 Drop-In Panel on page three (3) of this report.

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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.

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
