DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1x.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027551
Date Inspected: 04-May-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: On Site

CWI Name: Tony Sherwood

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS OBG Components

Summary of Items Observed:

This Quality Assurance (QA) Inspector, Art Peterson arrived on site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and monitor the welding operations performed by American Bridge Fluor (ABF) welding personnel. The following observations were:

Segment 13E Grid Line E2.5 Deck Plate Drop-in Section Longitudinal Field Weld Splice - (4720 mm)

This QA Inspector observed ABF welder Mike Jimenez (Welder ID 4671) performing the fill pass weld operation per the Shielded Metal Arc Welding (SMAW) process in the (1G) flat position on the (top side) of the Deck Plate Drop-in Section Longitudinal Field Weld Splice on Segment 13E along Grid Line E2.5.

This QA Inspector observed QC Inspector Tony Sherwood verify prior to the start of the fill pass weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterwords verified that the welding parameters (Amps and Travel Speed) were in accordance with WPS D1.5-1040C-CU Revision 0 using E7018 (1/8"), (5/32") and (3/16") diameter electrode.

This QA Inspector observed that ABF welder Mike Jimenez was in-process on the fill pass weld operation on the Deck Plate Drop-in section Longitudinal Field Weld Splice along Grid E2.5 at the end of this QA Inspectors' shift.

Segment 13E/14E Deck Plate Drop-in Section Transverse Field Weld Splice - (1850 mm) Section A2.1

This QA Inspector observed ABF welder Salvador Sandoval (Welder ID 2202) performing the root and fill pass weld operation per the Shielded Metal Arc Welding (SMAW) process in the (1G) flat position on the (top side) of the Deck Plate Drop-in Section Transverse Field Weld Splice on Segment 13E / 14E along Section A2.1.

This QA Inspector observed QC Inspector Tony Sherwood verify prior to the start of the root and fill pass weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterwords verified that the welding parameters (Amps and Travel Speed) were in accordance with WPS D1.5-1040C-CU Revision 0 using E7018 (1/8" and 5/32") diameter electrode.

This QA Inspector observed that ABF welder Salvador Sandoval was in-process on the root and fill pass weld operation on the Deck Plate Drop-in section Transverse Field Weld Splice on Segment 13E/14E along Section A2. 1 at the end of this QA Inspectors' shift.

Segment 13E/14E Deck Plate Drop-in Section Transverse Field Weld Splice - (5500 mm) Section A1

This QA Inspector observed ABF welder Eddie Brown (Welder ID 9331) performing the root and fill pass weld operation per the Shielded Metal Arc Welding (SMAW) process in the (1G) flat position on the (top side) of the Deck Plate Drop-in Section Transverse Field Weld Splice on Segment 13E/14E along Section A1.

This QA Inspector observed QC Inspector Tony Sherwood verify prior to the start of the root and fill pass weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterwords verified that the welding parameters (Amps and Travel Speed) were in accordance with WPS D1.5-1040C-CU Revision 0 using E7018 (1/8" and 5/32") diameter electrode.

This QA Inspector observed that ABF welder Eddie Brown was in-process on the root and fill pass weld operation on the Deck Plate Drop-in section Transverse Field Weld Splice on Segment 13E/14E along Section A1 at the end of this QA Inspectors' shift.

Segment 13E PP120.6 - Deck Plate Drop-in Section Transverse Field Weld Splice - (1000 mm)

This QA Inspector observed ABF welder Jacob Stafford (Welder ID 8020) performing the root and fill pass weld operation per the Shielded Metal Arc Welding (SMAW) process in the (1G) flat position on the (top side) of the Deck Plate Drop-in Section Transverse Field Weld Splice on Segment 13E along PP 120.6.

This QA Inspector observed QC Inspector Tony Sherwood verify prior to the start of the root and fill pass weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterwords verified that the welding parameters (Amps and Travel Speed) were in accordance with WPS D1.5-1040C-CU Revision 0 using E7018 (1/8" and 5/32") diameter electrode.

This QA Inspector observed that ABF welder Jacob Stafford was in-process on the root and fill pass weld operation on the Deck Plate Drop-in section Transverse Field Weld Splice along PP120.6 at the end of this QA Inspectors' shift.

Segment 13E Grid Line E2.8 Deck Plate Drop-in Section Longitudinal Field Weld Splice - (11970 mm)

This QA Inspector observed ABF welder Ken Chappell (Welder ID 3833) performing the cover pass weld operation per the Submerged Arc Welding (SAW) process in the (1G) flat position on the (top side) of the Deck Plate Drop-in Section Longitudinal Field Weld Splice on Segment 13E along Grid Line E2.8.

This QA Inspector observed QC Inspector Tony Sherwood verify prior to the start of the cover pass weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterwords verified that the welding parameters (Amps, Volts and Travel Speed) were in accordance with WPS 4042B-1 Revision 0 using F7A6-EM12K-H8 (1/8") diameter electrode Flux 10.62.

This QA Inspector observed that ABF welder Ken Chappell completed the cover pass weld operation on the Deck Plate Drop-in section Longitudinal Field Weld Splice along Grid E2.8 at this location.

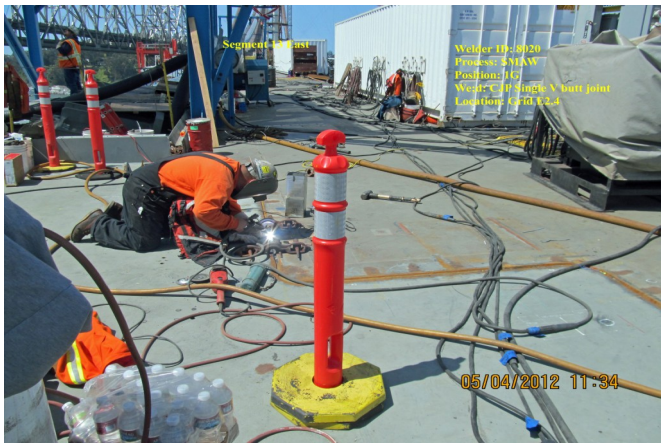
Segment 13E Grid Line E2.1 Deck Plate Drop-in Section Longitudinal Field Weld Splice - (9500 mm)

This QA Inspector observed ABF welder Ken Chappell (Welder ID 3833) performing the cover pass weld operation per the Submerged Arc Welding (SAW) process in the (1G) flat position on the (top side) of the Deck Plate Drop-in Section Longitudinal Field Weld Splice on Segment 13E along Grid Line E2.1.

This QA Inspector observed QC Inspector Tony Sherwood verify prior to the start of the cover pass weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterwords verified that the welding parameters (Amps, Volts and Travel Speed) were in accordance with WPS 4042B-1 Revision 0 using F7A6-EM12K-H8 (1/8") diameter electrode Flux 10.62.

This QA Inspector observed that ABF welder Ken Chappell completed the cover pass weld operation on the Deck Plate Drop-in section Longitudinal Field Weld Splice along Grid E2.1 at this location.

After the shift ended, This QA Inspector prepared and generated TL-6031 daily inspection reports with photos to upload into the PMIV database for review and disposition by QA Task Leader Bill Levell.



Summary of Conversations:

Only general conversations between this QAI and the QC Inspector 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.

Inspected By:	Peterson,Art	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer