

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-027592
Date Inspected: 10-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: 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. (Observation of welding and QC inspection of W102), Tower 9 Meter El. (Observation of welding and QC inspection of perimeter channel) and QA/MPT verification.

Doug Frey-OBG E13 and W13 (Observation of welding and QC inspection of drop-in plate splices) FW Spencer (Welding of mechanical piping at the 53 Meter Tower El. of the West Shaft) and E11 Suspender Bracket Modifications (Observation of Welding and QC inspection of new stiffener plates).

Issue 1- Back gouge concerns of OBG E13 drop-in plates. See QALI response below.

David Gray-Skyway (Observation of welding and QC inspection of electrical conduit to bike path per CCO-179) and OBG W13 Drop-In Plates (Observation of welding and QC inspection of field splices).

Matt Daggett-Skyway (Observation of welding and QC inspection of electrical conduit to bike path per CCO-179).

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Will Clifford-Tower, Shear Plate ESW (Observation of the repair welding, QC inspection and testing of excavations identified as WN: E-045 ("F"), 9 Meter El. (Observation of welding and QC inspection of perimeter channels) 9 & 13 Meter El. (Observation of welding and QC inspection of shear tabs to shear plates) and QA/VT & MPT verification.

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, Doug Frey, Will Clifford, David Gray and Matt Daggett 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). Also, this QALI performed survey and prepared update documentation of the East and West OBG.

Issue # 1-

This QALI was informed by QAI, Doug Frey, that the back gouging of the "B" face of the drop-in field splices appeared not to be deep enough. Upon further review of this QALI the back gouging appears to be flush with base metal with some areas approximately 2 mm deep. This QALI informed Mr. Frey that the work was still in progress at this time.

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.

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Inspected By: Reyes,Danny

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer