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 #: 1.28

WELDING INSPECTION REPORT

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

Report No: WIR-027620
Date Inspected: 11-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: 1530
Location: jobsite

CWI Name:	Steve Jensen			**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: skyway

Summary of Items Observed:

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

Skyway:

This QA observed work being performed at the rail divider panels 173-184, as part of Contract Change Order (CCO)179. The work consisted of installing a conduit pipe sleeve through the base plate and bike path deck shown on page 5 of 7 on CCO drawings. The welding was being performed using the Flux Cored Arc Welding Process (FCAW), E71T-11 by the welding personnel Jason Collins, ID-8128, in accordance with the Welding Procedure Specification identified as AFB-WPS-D1.1-2201, Rev. 0. The QC welding inspector, Steve Jensen, utilized the WPS to monitor the and verify the welding parameters which appeared to comply with the contract documents. The welding and the QC weld inspection was observed and verified by this QAI at random intervals during this shift which appeared to comply documents.

This QA inspector observed the QC activities and the welding performed as per the CCO 179 utilizing the WPS as noted above, which appeared to be posted at the weld station. The welding parameters and surface temperatures were verified by the QC inspectors utilizing a Fluke 337 clamp meter for the electrical welding parameters and a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. The Lincoln consumable, which were utilized, appeared to comply with the AWS Specification and Classification. The QC inspection and welding performed on this shift appeared to be in general compliance with the contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

There were general conversations with Quality Control Inspector, Steve Jensen, 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:	Daggett,Matt	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer