

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-027637**Date Inspected:** 21-May-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Pier 7 Job Site**CWI Name:** Andrew Keach**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. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) 12E Corner Assembly / C.C.O. 233 at pier 7
- 2) Tower Parapet / Boom work - RFI 2830R00 - at pier 7
- 3) Document reviews

1) The QAI observed ABF personnel making preparing to weld additional stiffener plates onto the OBG 12E corner assembly / bikepath cantilever beams. The QAI researched the work and identified that this is part of Contract Change Order (CCO) 233. The QAI observed that paint has been removed from the base metals on the cantilever beam. The QAI spoke with the worker, Kevin Kananen, and was informed that he will be performing the welding of the components. The QAI confirmed that Mr. Kananen has been approved by the Engineer for welding. The QAI noted that the by the end of the shift, fit-up of the East stiffener on Cantilever at Panel Point (PP) 113. The QAI noted that the Quality Control Inspector (QCI) Andrew Keach is monitoring this work. See the attached photos.

2) The QAI observed ABF personnel working on the East and West tower parapets. The QAI noted that this work is per Request for Information (RFI) 2830R00. The QAI noted that the tower boom hinge pins are still in the process of removal and the work was not completed by the end of the shift.

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3) The QAI reviewed contract documents at pier 7. The QAI used approved weekly welding report submittals and cross referenced the welding and inspection status as reported with QA records to identify the overall weld status. The QAI continued reviewing the informal welding report package #114 for conformance with the contract requirements. This review was in progress at the end of the shift.



Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed the general observations and status of work to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations or observations.

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:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
