

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-027663**Date Inspected:** 24-May-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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 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. The QAI was given report packages #115 and #116 to review for conformance with the contract requirements. This work was in progress until the end of shift.

The QAI noted that ABF personnel are fitting and welding stiffener plates onto the OBG 12E corner assembly / bikepath cantilever beams for part of Contract Change Order (CCO) 233. The QAI noted that the Quality Control Inspector (QCI) Andrew Keach is monitoring the work. The QAI met with the QCI at the work area and was informed that the ABF crew will be moving to work on other items, unrelated to the CCO. The QAI and the QCI made observations of the partially completed welds and noted that the box assembly that has been fit onto the inboard cantilever at Panel Point (PP) 117 does not have the required fit-up tolerances for the detailed fillet weld size. The QCI stated that he would inform the welder, Kevin Kananen. The QAI and the QCI also observed several minor areas of stiffener welds that need additional grinding. The QAI was later informed that the welding crew did not perform any work at this location and the work would resume at a later time, to be determined by ABF.

The QAI witnessed work in progress related to Contract Change Order (CCO) 193. The QAI noted that outer

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traveler rail is being modified and welded. The QAI noted that the welding is being performed by Jason Collins, ID 8128. The QAI was informed that there were modifications to weld details approved in submittal 2549 R03. The QAI noted that the QCI Steve Jensen is monitoring this work. The QAI Matt Daggett was tasked with monitoring this work. Mr. Daggett was given a copy of the approved submittal details for welding.

The QAI noted that work related to Request for Information (RFI) 2830R00 has been in progress. The QAI went to the work area and noted that the tower booms have been removed from the East and West tower heads. The QAI also noted that the stainless and self-lubricated bronze pads have been removed from the tower booms. The QAI noted that the bolt access cuts in the tower parapets do not appear to be ground smooth, as directed in the RFI.

The QAI was not able to locate the work crew to determine the status or location of the plates that have been removed. The QAI did not observe any work here during this shift.

Summary of Conversations:

The QAI relayed the status of the document reviews, RFI (tower parapet work) and CCO status to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations.

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
