

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-027683**Date Inspected:** 24-May-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** William Sherwood**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**Summary of Items Observed:**

At the start of the shift this Quality Assurance Inspector (QA) 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:

OBG Drop-in Splice 13W/14W:

QA witnessed the welding of the back side of weld W13-W14-A0 on the deck splices of the West Drop-In Splice 13W-14W. The weld was being performed by qualified welder Michael Jiminez ID#4671 using the Shield Metal Arc Welding (SMAW) Process utilizing filler metal 7018H4R, in the 4g overhead position, at 130 Amps, preheat was verified at 200F by use of a tempil sticks.

QA observed the grinding of the above mentioned backgouged area. The contour of the weld joint after backgouging makes it very difficult to weld, the contractor is following the code requirement to grind the weld joint to bright shiny metal condition.

QC William Sherwood was observed performing the in process weld inspection and QC verification. This QA observed and verified the welding and QC inspection at random intervals.

QA observed numerous tacks and hammer/work marks that need to be addressed in the Splice 13W-14W West Drop-In area prior to final Non-Destructive Tests being performed to the deck splice welds. Numerous tacks were left in place during the copper backing bar removal.

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OBG Drop-in 13E/14E

QA did a turn over with Doug Frey for tomorrow. Mr. Frey is taking a vacation day and QA will be covering the deck splice repairs on the East and West Drop In Splice 13E-14E tomorrow 5/25/12. QA was shown the location and scope of work that needs to be performed.

QA spent time reviewing AWS D1.5 Section 12 with the upcoming deck splice repairs the QA wanted refamilurize himself with the part of the chapter dealing with repairs. QA also reviewed the CALTRANS standard specification and job specific specification for anything that differs from the requirements in AWS D1.5.

Summary of Conversations:

There were general conversations with Quality Control Inspector William Sherwood, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

Discussed work being performed tomorrow on the East Drop In, QA will be covering the work in this location due to Doug Frey's absence.

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: | Daggett,Matt | Quality Assurance Inspector |
| Reviewed By: | Levell,Bill | QA Reviewer |
