

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: 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-027784
Date Inspected: 18-Jun-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: 1630
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: | 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 12E

This QAI observed the joining by welding of 90 degree pipe elbow to 4.5" pipe located at OBG 12E Panel Point 112.5 by welder Damian Llanos utilizing the Shield Metal Arc (SMAW) Process. The welding was being accomplished using E6010 for the root and hot pass; and E7018 for the cap or final pass.

Welding Parameters were being monitored by QC Inspector Steve Jensen and verified by this QAI at random intervals. All parameters verified by this QAI met the requirements of Welding Procedure Specification 1-12-1.

QAI observed the welding of a butt joint in 4.5" pipe at OBG12E Panel Point 109.5 by welder Damian Llanos utilizing the Shield Metal Arc (SMAW) Process. The welding was being accomplished using E6010 for the root and hot pass; and E7018 for the cap or final pass.

Welding Parameters were being monitored by QC Inspector Steve Jensen and verified by this QAI at random intervals. All parameters verified by this QAI met the requirements of Welding Procedure Specification 1-12-1.

OBG W13-W14 Splice West Drop-in

WELDING INSPECTION REPORT

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QAI observed the grinding and wire brushing in preparation of welding deck splice 13W-14W-W2.8 by welder Jeremy Doleman. Mr. Doleman was smoothing the interior of the back gouged groove and cleaning it to a bright metal condition.



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. All observations were relayed to Danny Reyes and Bill Levell.

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