

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-027814
Date Inspected: 22-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: 1730
Location: jobsite

CWI Name:	Steve Jensen, 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 12W

This QAI observed the joining by welding of a butt joint in 4" pipe elbow located at OBG 12W Panel Point 108.5 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

This QAI observed the preheating of deck splice 13W-14W-W2.8. The QC recorded and QAI verified preheat was being accomplished by utilization of a induction heating blanket. A constant preheat of 250F was randomly verified by this QAI throughout the shift.

QAI observed the back welding of deck splice 13W-14W-W2.8 by welder Jeremy Doleman in the 4G position

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utilizing the Shield Metal Arc Welding (SMAW) Process. E7018 consumable electrode was being used to the QC recorded QAI randomly verified parameters of Welding Procedure Specification ABF-WPS-D15-1040C-CV. The welder was using a stringer technique to fill in the back-gouge. A power wire brush and manual chipping hammer was being used to clean between passes. Welding is complete on the above-mentioned weld. No NDT has been performed to verify soundness.

This QAI observed the welding of the back gouged back of weld 13W-14W-W2.1 by Welder Mike Jiminez in the 4G position utilizing the Shield Metal Arc Welding (SMAW) Process. E7018 consumable electrode was being used to the QC recorded QAI randomly verified parameters of Welding Procedure Specification ABF-WPS-D15-1040C-CV. The welder was using a stringer technique to fill in the back-gouge. A power wire brush and manual chipping hammer was being used to clean between passes. Welding is 75% complete on the above-mentioned weld.

This QAI observed the preheating of deck splice 13W-14W-W2.8. The QC recorded and QAI verified preheat was being accomplished by utilization of a induction heating blanket. A preheat of 150 was randomly verified by this QAI.

QAI observed the welding of the back gouged back of weld 13W-14W-W2.3 by Welder Tran Chau (ID# 3139) utilizing the Shield Metal Arc Welding (SMAW) Process. E7018 consumable electrode was being used to the QC recorded QAI randomly verified parameters of Welding Procedure Specification ABF-WPS-D15-1040C-CV. The welder was using a stringer technique to fill in the back-gouge. A power wire brush and manual chipping hammer was being used to clean between passes. Welding is 75% complete on the above-mentioned weld.



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

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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
