

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-027819
Date Inspected: 24-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: 1530
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:

This QAI observed the excavation by Welder Eric Sparks (ID#6163) of a weld defect, in the circumference weld, discovered by Ultrasonic Testing, in Access Hole Cover 8W-PP71-W2. The location of the defect is as follows: D: 14mm, L: 60mm, W: 23mm, Y: 3800mm. At the conclusion of the carbon arc gouged excavation Welder Eric Sparks(6163) ground the excavation to a bright shiny metal condition.

When Eric Sparks concluded the grinding of the excavation Quality Control Inspector William Sherwood performed Magnetic Particle Testing on the excavation using the continuous, dry powder, visible, yoke method with no indications reported.

At the end of testing Mr.Sparks preheated the area of repair to 250F and restored the excavated area by welding utilizing the shield metal arc welding process with a 7018 consumable electrode, at 127amps. The area was then ground flush to the surrounding base metal.

OBG W13-W14 Splice West Drop-in

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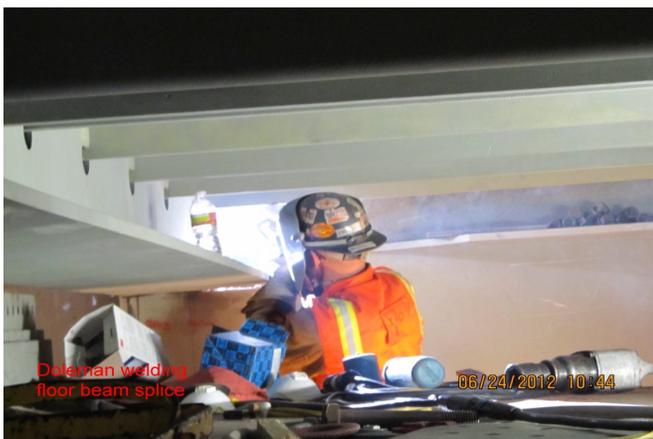
QAI observed the back welding of deck splice 13W-14W-W2.1 by welder Mike Jiminez in the 4G position utilizing the Shield Metal Arc Welding (SMAW) Process. E7018 consumable electrode was being used to the QC recorded QAI randomly verified parameters of Welding Procedure Specification ABF-WPS-D15-1040C-CV. 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 welding slag between passes.

This QAI observed the welding of the floor beam L8-5W by Welder Rory Hogan (ID#3186) in the 3G position utilizing the Shield Metal Arc Welding (SMAW) Process. E7018 consumable electrode was being used to the QC recorded QAI randomly verified parameters of the applicable Welding Procedure Specification. 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 welding slag between passes. Welding is 100% complete on the above-mentioned weld.

QAI observed Win Han Yu (ID#6317) welding deck plate splice W13-W14-W2.4 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 the applicable Welding Procedure Specification. 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 welding slag between passes. Welding is 100% complete on the above-mentioned weld.

At the completion of welding operations Mr. Yu started to grind the joint flush. Mr. Yu was using a correct grinding technique and getting the specified ground finish.

This QAI observed welder Jeremy Doleman (ID#1042) began to weld floor beam splice 13W-PP122-W2.1-BF1 in the 1G position utilizing the Shield Metal Arc Welding (SMAW) Process. E7018 consumable electrode was being used to the QC recorded QAI randomly verified parameters of the applicable Welding Procedure Specification. The welding of the joint is about 20% complete.



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

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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
