

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-027820
Date Inspected: 23-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: 1930
Location: Job Site

CWI Name:	See Below	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/Tower	

Summary of Items Observed:

At the start of the shift this Quality Assurance Lead Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Joselito Lizardo-Tower/Shear Plates (Observation of excavations repair welding, QC inspection and testing of ESW).

Will Clifford-Tower/Shear Plates (Ultrasonic testing of ESW "H" & "G" and compiling information regarding the investigative excavation of transverse and longitudinal indications found during UT for Mazen Wahbeh).

Doug Frey-OBG E12 Corner Drop-In (Observation of welding, QC inspection and testing) and OBG E13, Drop-In Panels (Observations of repair welding of drop-in field splices).

Rodney Patterson-Tower/Shear Plates (Ultrasonic testing of ESW "F").

Matt Daggett-OBG W13 (Observations of welding and QC inspection of deck field splices).

NOTE: See QA daily Weld Inspection Reports (WIR) and NDE reports for additional information and details.

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Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, William Clifford, Doug Frey, Rodney Patterson and Matt Daggett monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and no issues were noted.

UT Verification of Tower Shear Plates (ESW)

This QALI, Rodney Patterson and William Clifford performed Ultrasonic Testing (UT) of selective Electro-Slag Welds (ESW) under the directive of QAI Supervisor, William Levell, to perform the testing at a 100% frequency as per Structural Material Representatives (SMR) Mazen Wahbeh and Aaron Prchlik. The information, ABF/QC UT reports, the selected welds to be tested were forwarded to the QA inspector's by Mets personnel, Robert Mertz, which were identified as ESW "F", "H", "R" and "S". The testing was performed to verify QC documentation in regards to transverse and longitudinal indications pertaining to recordable indications but not limited to. These welds were tested and performed in accordance with the contract specifications.

This QAI performed UT on the ESW shear plate identified as "H" and found various number of recordable indications not noted by QC. Testing was performed on the "A" and "B" faces of the joint between the 9M elevation and 13M elevation. The UT testing was not completed during this shift.

Later in the shift Mr. Mertz issued to the QAI another ABF/QC report for the ESW identified as "G" which was assigned to William Clifford by this QALI.

Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

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: Reyes,Danny

Quality Assurance Inspector

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Reviewed By: Levell,Bill

QA Reviewer