

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-027821
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: 600
OSM Departure Time: 1830
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:

Will Clifford-Tower/Shear Plates (Continued Ultrasonic testing of ESW "G").

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 (Continued Ultrasonic testing of ESW "F").

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

Scott Croff-Tower/Shear Plates (Ultrasonic Testing of ESW "R" and "S").

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

Quality Assurance Lead Inspector (QALI) Summary

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This QA Lead Inspector (QALI) observed the QA Inspector's 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)

At approximately 0630, prior to entering the tower to perform UT of the shear plates/ESW. At approximately 0800, this QALI contacted ABF safety personnel to acquire entry access into the tower. In conclusion, this QALI was informed by the ABF safety personnel that it was clear to enter the tower.

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 "B" face of the joint between the base plate elevation and the 9M diaphragm plate elevation. The UT testing was not completed during this shift. Also, the moving of ladders hampered the testing.

Later in the shift Mr. Mertz issued to the QAI another ABF/QC report for the ESW identified as "L" and "V" which were assigned to William Clifford and this QALI accordingly. See Summary of Conversations for other information in regards to the testing of the ESW shear plates.

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.

At approximately 1000, Robert Mertz informed this QALI and Mets Representative, Jason Gramlick, that the testing frequency was reduced to 25%. Mr. Mertz also said that he was in the process of generating a spread sheet and would contact this QALI in regards to the information required.

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: Reyes,Danny

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer