

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-027836**Date Inspected:** 27-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** See body of report**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 West

This QAI observed Damian Llammos of Spencer Mechanical fitting, tacking and welding a butt splice in 2.5" pipe at PP116 West. Llammos ground a bevel on the end of the pipe using a four inch grinder, then using a shim the 1/16" root gap was set. The two pipe pieces were then tacked together to hold the prescribed root gap and proper alignment.

At the conclusion of tack weld and fitting, Mr Llammo began depositing the finished weld metal into the butt joint utilizing the Shield Metal Arc Welding Process to the Quality Control recorded Quality assurance verified parameters of Welding Procedure Specification 1-12-1. Quality Control Inspector Steve Jensen and this QAI performed a visual weld inspection on the finished joint. No rejectable indications noted.

This QAI observed Damian Llammos of Spencer Mechanical fitting, tacking and welding a butt splice in 2.5" pipe at PP118 West. Llammos ground a bevel on the end of the pipe using a four inch grinder, then using a shim the 1/16" root gap was set. The two pipe pieces were then tacked together to hold the prescribed root gap and proper alignment.

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At the conclusion of tack weld and fitting, Mr Llammo began depositing the finished weld metal into the butt joint utilizing the Shield Metal Arc Welding Process to the Quality Control recorded Quality assurance verified parameters of Welding Procedure Specification 1-12-1. Quality Control Inspector Steve Jensen and this QAI performed a visual weld inspection on the finished joint. No rejectable indications noted.

This QAI observed Damian Llammos of Spencer Mechanical fitting, tacking and welding a butt splice in 2.5" pipe at PP120 West. Llammos ground a bevel on the end of the pipe using a four inch grinder, then using a shim the 1/16" root gap was set. The two pipe pieces were then tacked together to hold the prescribed root gap and proper alignment.

At the conclusion of tack weld and fitting, Mr Llammo began depositing the finished weld metal into the butt joint utilizing the Shield Metal Arc Welding Process to the Quality Control recorded Quality assurance verified parameters of Welding Procedure Specification 1-12-1. Quality Control Inspector Steve Jensen and this QAI performed a visual weld inspection on the finished joint. No rejectable indications noted.

OBG 13W-14W West Drop-In

This QAI observed Wen Han Yu (Welder ID#6317) welding 13W-PP121-W2.4-BF1 utilizing the Shield Metal Arc Welding Process in the 1G position, using E7018 consumable electrode, to the Quality Control Recorded, Quality Assurance verified welding parameters of Welding Procedure Specification. The Welder Yu was performing the necessary between pass slag removal. No indications were noted upon random inspection.

This QAI observed Jeremy Doleman (Welder ID#5042) welding 13W-PP123-W2.8-BF1 utilizing the Shield Metal Arc Welding Process in the 1G position, using E7018 consumable electrode, to the Quality Control Recorded, Quality Assurance verified welding parameters of Welding Procedure Specification. The Welder Doleman was performing the necessary between pass slag removal. No indications were noted upon random inspection.

This QAI observed Steven Davis (Welder ID#7889) welding 13W-PP124.5-W2.2-BF1 utilizing the Shield Metal Arc Welding Process in the 1G position, using E7018 consumable electrode, to the Quality Control Recorded, Quality Assurance verified welding parameters of Welding Procedure Specification. The Welder Davis was performing the necessary between pass slag removal. No indications were noted upon random inspection.

West Corner Drop-In W12

This QAI and Quality Control Inspector William Sherwood measured the planar alignment and gap between the existing deck plate and the deck plate of the West Corner Drop-In. All measurements taken along the length of the deck splice of the planar alignment were within the specified tolerances. The root gap measurements are as follows:

W2.1

1. 5500-8500: 21mm
2. 8600-14000: 21-23mm
3. 14100-149000: 21-22mm
4. 18400-20500: 21-22 mm
5. 290000-30500: 22mm

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6. 30501-31050: 25-28mm

12W-13W A1.1

1. 1-100: 26-28mm

2. 1200-2020- 22-24MM

An IR is in the process of being generated.



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.

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