

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-027853
Date Inspected: 27-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: 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)

Doug Frey-OBG E5, Deck Access Hole (Observation of welding and QC inspection) and OBG E12, Corner Drop-In Assembly (Observations of welding and QC inspection of the field splices) and QA/MPT and UT verification.

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

Matt Daggett-OBG W13 (Observations of welding and QC inspection of deck field splices) and FW Spencer (Observation of welding and QC inspection of mechanical piping).

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Scott Croff-Tower/Shear Plates(Ultrasonic testing of ESW).

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

Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, William Clifford, Doug Frey, Rodney Patterson, Scott Croff 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 during this shift.

Also attended pre-plan meeting at the Pier 7 office conference room to discuss the Ultrasonic Testing (UT) of the Electro-Slag Welds (ESW) of the Tower shear plates. The meeting facilitator, Mazen Wahbeh and also inform the QA inspectors that a joint effort to work with QC technicians was to be implemented as to expedite the information for review by the design engineers.

This QA Lead inspector also received from Structural Materials Representative (SMR) Bahjat Dagher regarding the deck field splice of the OBG E12 corner drop-in assembly has been approved for the contractor to proceed with the welding. This approval was received via electronic mail.

Also, this QA Lead Inspector performed a planar alignment survey as requested by QC Lead Inspector, Bonifacio Daquinag, Jr. The survey was performed on the deck plate field splice identified as OBG E12 corner drop-in assembly with QC inspector William Sherwood. The maximum planar alignment was 2 mm and appeared to comply with the contract specifications. This QA Lead Inspector also noted the excessive root opening (28 mm) of the longitudinal seam of the W12 corner drop-in assembly. The QC inspector concurs with the QA Lead Inspector. An Incident Report (IR) was generated on this date.

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.

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Inspected By: Reyes,Danny

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer