

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-027864**Date Inspected:** 30-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite

CWI Name:	Fred Michaels/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 Welder Tran Chau using a rosebud torch to preheat floor beam splice PP123-W2.1-BW1 to a QC recorded, QA verified temperature of 150F. Preheat temperature was measured using a Tempil Stick. This QAI noted QC Tony Sherwood recording preheat temperature whenever there was a stop in work.

QAI witnessed the welding of Floor Beam Splice PP123-W2.8-BF3 by welder Tran Chau (ID 7889) utilizing the Shield Metal Arc Welding Process in the 1G/4G position using E7018 consumable electrodes. The QC recorded and this QAI verified that the weld metal was being deposited to the parameters of Welding Procedure Specification ABF-WPS-D15-1030-1. Welder Chau was observed using the stringer method and good workmanship practices in regard to interpass cleaning.

This QAI observed Welder Wen Han Yu using a rosebud torch to preheat floor beam splice PP123-W2.1-BW1 to a QC recorded, QA verified temperature of 150F. Preheat temperature was measured using a Tempil Stick. This QAI noted QC Tony Sherwood recording preheat temperature whenever there was a stop in work.

QAI witnessed the welding of Floor Beam Splice PP121.5-W2.5-BF1 by welder Wen Han Yu (ID#6317) utilizing the Shield Metal Arc Welding Process in the 1G/4G position using E7018 consumable electrodes. The QC recorded and this QAI verified that the weld metal was being deposited to the parameters of Welding

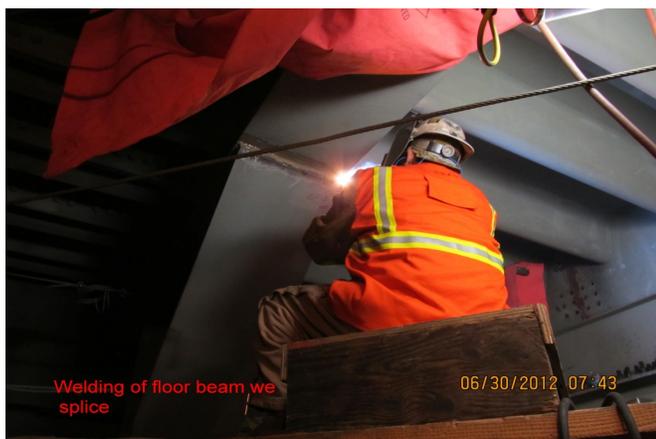
WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Procedure Specification ABF-WPS-D15-1100-1. Welder Yu was observed using the stringer method and good workmanship practices in regard to interpass cleaning.

This QAI observed Welder Eddie Brown using a rosebud torch to preheat floor beam splice PP123-W2.1-BW1 to a QC recorded, QA verified temperature of 150F. Preheat temperature was measured using a Tempil Stick. This QAI noted QC Tony Sherwood recording preheat temperature whenever there was a stop in work.

QAI witnessed the welding of Stiffener 13W-14W-LS-2 by welder Eddie Brown utilizing the Shield Metal Arc Welding Process in the 3G position using E7018 consumable electrodes. The QC recorded and this QAI verified that the weld metal was being deposited to the parameters of the applicable Welding Procedure Specification . Welder Yu was observed using the stringer method and good workmanship practices in regard to interpass cleaning.



Summary of Conversations:

There were general conversations with Quality Control Inspector Fred Michaels, 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