

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-027868
Date Inspected: 30-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: 1530
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).

Doug Frey-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).

Rob DeArmond-Tower/Shear Plates (Ultrasonic testing of ESW).

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

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

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Doug Frey-OBG E12 Corner Drop-In Assembly (Observation of Welding, Fit-up and QC inspection).

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, Rob DeArmond, 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.

Tower/Shear Plates ESW, Ultrasonic Testing

After assignment of QA personnel to selected areas to the Orthotropic Box Girders (OBG) identified as E12 and W13 this QA Lead Inspector reported to the Tower to perform Ultrasonic Testing of the shear plate Electro-Slag Welds (ESW) in a joint effort with the contractor's Quality Control personnel. There were four (4) joint venture teams selected and consisted of the following QA/QC personnel: Rodney Patterson/John Pagliero, Rob DeArmond/Scott Kortum, Scott Croff/Andrew Keech and this QALI/ Jesse Cayabyab. Mr. Cayabyab also performed the QC inspection of the excavation at the ESW identified as "E" but later in the shift was replaced by Bernie Docena. At approximately 1230 this QALI and Mr. Cayabyab commence testing of the ESW joint identified as "R". The testing of this ESW was not completed during this shift. This QALI generated a UT report identified as TL-6027. Also, this QA Lead Inspector attended a field meeting to address, review and discuss a sixth revision of the Supplemental Ultrasonic Procedure regarding the sizing of planar indications. The meeting was conducted by Leonard Cross, QC Level III and Robert Mertz QA Level III.

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