

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-027897
Date Inspected: 03-Jul-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: 1930
Location: Job Site

CWI Name:	As noted 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:	SAS OBG		

Summary of Items Observed:

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

12E PP111.1 (Exterior)

This QA Inspector at random intervals observed ABF/JV qualified welder Richard Garcia #5892 placing seal weld passes using the Shielded Metal Arc Welding (SMAW) process in the 1G flat position on 12E PP111.1 on the exterior of the OBG. QC Inspector Salvador Merino was observed measuring the preheat temperature and setting the parameters to ensure compliance with the welding procedure specification (WPS) ABF-WPS-D1.5-F1200A. The welder was observed using a small disc grinder to blend the start/stop edges of the work to provide a smooth transition. The welder was observed utilizing 3.2mm E7018-H4R electrodes drawing amperage of 132. The electrodes were obtained from a baking oven verified by this QA Inspector. On a subsequent observation this QA Inspector monitored the work for quality and noted that it was in progress and appeared to be in general conformance with the contract documents.

12E-E2.1 (Exterior)

This QA Inspector made random observations of ABF/JV qualified welder Mike Jimenez performing SMAW in the 1F flat position on 12E-E2.1 on the East Drop-In Panel on the exterior of the OBG. The welder was depositing metal forming seal passes on the edges of the joint at y+29,000mm to 31,000mm. This QA Inspector observed QC

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Inspector Salvador Merino verify prior to the start of the fillet weld operation, that the minimum preheat temperature as per the approved WPS was established; and afterward's verified that the welding parameters (Amps) were in accordance with ABF-WPS-D1.5-F1200A. The welder was observed utilizing E7018-H4R electrodes and this QA Inspector verified that the electrodes were recently obtained from a baking oven. QC was observed measuring the inter-pass temperatures by employing an infra-red temperature gun as well as monitoring the welding and the parameters. It was noted that the welder was drawing amperage of 127 utilizing 3.2mm electrodes. On a subsequent observation, the welder was observed continuing work on the B-U2a Complete penetration Joint (CJP) and was employing the same routine to clean the passes. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appeared to be in general conformance with the contract specifications.

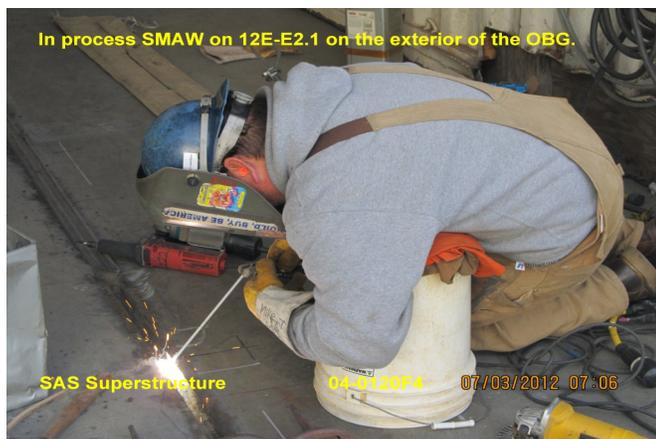
13E-A2.1 (Exterior)

This QA Inspector randomly observed QC Inspector Steve Jensen performing Ultrasonic Testing (UT) on the completed welds of 13E-A2.1 on the exterior of the OBG. The QC Inspector was observed scanning from each side of the weld and the scanning pattern as described in D1.5 6.24. The QC Inspector was noted as identifying two (2) rejectable indications located at y+590 and y+1235. This QA Inspector noted that the work at this location is ongoing and appeared to be in general conformance with the contract documents and SE-UT-D1.

5-CT-100-Revision 4.

Summary of Conversations:

Conversations were relevant to the specific locations.



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:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
