

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-027909
Date Inspected: 04-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: 1630
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 Plate ESW (Observation of excavations, repair welding, QC inspection and testing).

Doug Frey-OBG E12, Corner Drop-In Assembly (Observations of welding, fit-up and QC inspection of the field splices).

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

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

Matt Daggett-OBG W13 (Observations of the welding and QC inspection of the structural steel members) and W13 Corner Drop-In Assembly (Observation of the welding and QC inspection of the deck field field splices).

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

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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.

This QA Lead Inspector commence the review of NDT reports, tracking of welding and developing and generating weld maps for W13 drop-in panels, E12 and W12 corner drop-in assemblies. This QA Lead Inspector also reviewed RWR documents for tracking purpose.

Summary of Conversations:

At the start of the shift, 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.

This QA Lead Inspector was asked the question by QC Lead Inspector, Mr. Daquinag, of why the QA personnel was not signing the UT reports at the end of the shift. This QA Lead Inspector responded to Mr. Daquinag inquiry that the QC personnel were not completing the UT reports until the following scheduled day shift. This QA Lead inspector also informed, Mr. Daquinag, that prior to the signing of the UT reports that the QA personnel would review the reports generated by QC to confirm the information noted on the reports. Later in the shift, Mr. Daquinag, informed this QA Lead Inspector that the QC personnel would terminate UT one (1) more hour prior to the end of the shift, which would allow them a total of three to complete the reports. This information was forwarded to QA Supervisor, William Levell, via cell phone conversation.

Also, this QA Lead Inspector was informed by QA Supervisor, William Levell, and Robert Mertz, project Level III that the QA personnel needed to correct their UT reports in regards to the testing data. This reports were rejected by Mr. Levell and returned for action to the QA personnel. Later in the shift each QA personnel was contacted and was informed of the corrections that were required prior to submitting for approval.

Also, there were pertinent conversations with QA Supervisor, William Levell, through the course of this shift in regards to scheduling of QA personnel, work progress and related structural steel and weld issues. There were no significant issues noted on this date.

There was other pertinent conversations with QA Supervisor, William Levell, through the course of this shift in regards to scheduling of QA personnel, work progress and related structural steel and welding issues. There were no significant issues noted on this date.

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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
Reviewed By:	Levell,Bill	QA Reviewer
