DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027919
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: 1930
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:

W12 Corner Drop-In

QAI observed the preheating of weld joint W12 Corner Drop-In W2.1 by Welder Jeremy Doleman ID#5042, utilizing the use of a rosebud torch. The joint was preheated to a Quality Control Recorded; Quality Assurance verified temperature of 150F. This QAI observed QC inspector Fred Michaels take multiple temperature readings along the length of the weld joint prior to the start of welding operations, and after work stoppages randomly throughout the day. Inspector Michaels was using an Infrared non-contact heat gun to record preheat temperature, this QAI verified readings using a Tempil Stick at random intervals throughout the day.

This QAI observed Jeremy Doleman utilizing the Shield Metal Arc Welding Process to the following parameter 132 amperes, which fall within the range of the governing Welding Procedure Specification. This QAI observed Quality Control Inspector Fred Michaels recording welding parameters at various times throughout the shift and this QAI verified parameters at random intervals.

QAI observed the preheating of weld joint W12 Corner Drop-In W2.1 by Welder Rich Garcia ID#5892, utilizing the use of a rosebud torch. The joint was preheated to a Quality Control Recorded; Quality Assurance verified temperature of 150F. This QAI observed QC inspector Fred Michaels take multiple temperature readings along

the length of the weld joint prior to the start of welding operations, and after work stoppages randomly throughout the day. Inspector Michaels was using an Infrared non-contact heat gun to record preheat temperature, this QAI verified readings using a Tempil Stick at random intervals throughout the day.

This QAI observed Welder Rich Garcia utilizing the Shield Metal Arc Welding Process to the following parameter 175 amperes,(5/32") which fall within the range of the governing Welding Procedure Specification. This QAI observed Quality Control Inspector Fred Michaels recording welding parameters at various times throughout the shift and this QAI verified parameters at random intervals.

This QAI observed the welding of W12 West Corner Drop-In W2.1 deck splice by Welder Dan Ieraci (ID#3232) utilizing the Submerged Arc Welding Process in the 1G position to the following parameters Amps: 550, Volts: 32. 4 Wire Feed Speed: 381 which fall within the range dictated by the applicable Welding Procedure Specification.

This QAI observed Quality Control Inspector Fred Michaels recording welding parameters at various times throughout the shift and this QAI verified parameters at random intervals.

13W-14W OBG Drop-In

This QAI observed Welder Tran Chau using a rosebud torch to preheat floor beam splice PP124-W2.8-BW-1 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 PP124-W2.8-BW-1 by welder Tran Chau 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 Welding Procedure Specification ABF-WPS-D15-1100. Welder Chau was observed using the stringer method and good workmanship practices in regard to interpass cleaning.

This QAI observed Welder Steve Davis (ID#7889) using a rosebud torch to preheat floor beam splice PP122.5-W2. 1-BW-1 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 PP122.5-W2.1-BW-1 by welder Tran Chau 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 Welding Procedure Specification ABF-WPS-D15-1100. Welder Chau was observed using the stringer method and good workmanship practices in regard to interpass cleaning.

WELDING INSPECTION REPORT

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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