

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-027943**Date Inspected:** 12-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**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:** Tower Component**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford 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:

This QA compiled a current status sheet for tower Electroslag Welds (ESW) and Orthotropic Box Girder (OBG) drop-ins. This QA emailed a copy of the current status sheet to Task Leader Bill Levell, Structural Materials Representative (SMR) Aaron Prchlik, and SMR Bahjat Dagher.

Tower/OBG Status (07/12/12)

Tower

ESW B - 100% QA/QC complete

ESW C - 100% QA/QC complete

ESW F - 100% QA/QC complete

ESW H - (QA completed Face B 100%, Face A 0mm~6000mm), QC technician unavailable, Hager/Keech

ESW L - Testing started 07/11, DeArmond/Cayabyab

ESW M - 100% QA/QC complete

ESW R - 100% QA/QC complete

ESW S - 100% QA/QC complete

ESW G - 95% complete (4000mm~6000mm, Face B, In-progress) Patterson/Kortum

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East OBG Drop In Panel

13E PP121.2 - 100% QA
13E PP122.2 - 100% QA
13E/14E A0 - 100% QA
13E/14E A1 - 100% QA
13E PP120.6-LS1 - 100% QA
13E PP121.E2.3-BW1 - 100% QA
13E PP123-E2.1-BW1 - 100% QA
13E PP123-E2.1-BF1 - 100% QA
13E PP123-E2.1-BF2 - 100% QA
13E PP123-E2.1-BF3 - 100% QA

West OBG Drop In Panel

13W PP123.6 - 100% QA
13W/14W A2.1 - 100% QA

East Corner Drop In

Initial Welding In Progress

West Corner Drop In

Initial Welding In Progress

Orthotropic Box Girder - 13E

This QA randomly observed ABF/JV qualified welder Richard Garcia #5892 performing Shielded Metal Arc Welding (SMAW) with 3.2mm" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1040C-CU. The joint being welded was 12E-E2.1.

During welding, ABF Quality Control (QC) Salvador Moreno was noted monitoring the welding parameters.

This QA observed, at random intervals, ABF/JV qualified welder Jeremy Dolman #5042 performing Flux Core Arc Welding (FCAW) implementing Caltrans approved Welding Procedure Specification Specification (WPS) ABF-WPS-D15-3040A-1. The joint being welded was 12E-E2.1.

During welding, ABF Quality Control (QC) Salvador Moreno was noted monitoring the welding parameters.

Orthotropic Box Girder - 13W

This QA randomly observed ABF/JV qualified welder Richard Garcia #5892 performing Shielded Metal Arc Welding (SMAW) with 3.2mm" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1040C-CU. The joint being welded was 12W Corner Drop-In.

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters.

This QA observed, at random intervals, ABF/JV qualified welder Xiao Jian Wan #9677 performing Flux Core Arc Welding (FCAW) implementing Caltrans approved Welding Procedure Specification Specification (WPS) ABF-WPS-D15-3040A-1. The joint being welded was 12W Corner Drop-In.

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversations were relevant to work in progress.

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 SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William	Quality Assurance Inspector
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Reviewed By:	Levell, Bill	QA Reviewer
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