

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-027978
Date Inspected: 15-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: 1530
Location: jobsite

CWI Name:	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:

12W Corner Drop-In

This QAI observed the contractor using Miller induction heating blankets to maintain a constant 200F preheat during Flux Cored Arc Welding operations. This QAI observed William Sherwood checking with an infrared thermometer and recording preheat at regular intervals during welding operations. This QAI verified the preheat temperature at numerous time through the shift.

QAI witnessed the welding of splice 12W-W2.1-C1 by welder Wai Kit Lai (ID#2953) utilizing the Flux Cored Arc welding process in the 1G position using E71-T-1M 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-D15-3040A-1. Welder Lai was observed using the stringer method and good workmanship practices in regard to interpass cleaning.

This QAI observed the contractor using Miller induction heating blankets to maintain a constant 200F preheat during Flux Cored Arc Welding operations. This QAI observed William Sherwood checking with an infrared thermometer and recording preheat at regular intervals during welding operations. This QAI verified the preheat temperature at numerous time through the shift.

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QAI witnessed the welding of splice 12W-W2.1-C1 by welder Jimmy Zhen(ID#9344) utilizing the Flux Cored Arc welding process in the 1G position using E71-T-1M 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-D15-3040A-1. Welder Lai was observed using the stringer method and good workmanship practices in regard to interpass cleaning.

Welded splice 12W-W2.1-C1 first side is complete and the joint is ready for back gouging. The back gouging will be performed on the exterior of the OBG. To gain access to the joint on the exterior of the OBG ladders and platforms have been put in place.



Summary of Conversations:

There were general conversations with Quality Control Inspector William Sherwood, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift. All observations were relayed to 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.

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Inspected By:	Daggett, Matt	Quality Assurance Inspector
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Reviewed By:	Levell, Bill	QA Reviewer
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