

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-027994**Date Inspected:** 17-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**Contractor:** American Bridge/Fluor Enterprises, a JV**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:

This QAI observed Welder Jeremy Doleman using a rosebud torch to preheat stiffener splice 122.2 LS-3 to a QC recorded, QA verified temperature of 200F. Preheat temperature was measured using a Tempil Stick. This QAI noted QC William Sherwood recording preheat temperature whenever there was a stop in work.

QAI witnessed the welding of stiffener splice 122.2 LS-3 by welder Jeremy Doleman (ID#5042) utilizing the Shield Metal Arc Welding Process in the 3G position using E9018 consumable electrodes. The QC recorded and this QAI verified that the weld metal was being deposited to the parameters of the applicable Welding Procedure Specification. Welder Doleman was observed using the stringer method and good workmanship practices in regard to interpass cleaning.

This QAI witnessed Damian LLamos of Spencer Mechanical welding a pipe support on to an angle that had previously been welded to the bridge deck plate at PP119.5-E5. Welder LLamos was performing the welding utilizing the Shield Metal Arc Welding Process with E7018 consumable electrodes to the parameters listed in the approved Welding Procedure Specification. This QAI observed QC Inspector Steve Jensen recording the welding operations at the standard intervals throughout the day. At the conclusion of welding operations this QAI performed a Visual Weld Inspection and found no rejectable discontinuities.

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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.

Inspected By: Daggett, Matt

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer