

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-028016
Date Inspected: 19-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: | 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:

13W/14W Drop-In

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 observed Rick Clayborn making the following excavations utilizing Carbon Arc Gouging from Stiffener 120.6 LS-1 LS-2:

Y=375mm D=10mm W=17mm L=90mm

Y=2490mm D=10mm W=15mm L=100mm

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Y=2650mm D=8mm W=12mm L=80mm

QAI witnessed William Sherwood Quality Control Technician perform Magnetic Particle Testing to the above listed excavation of weld 13W-120.6 LS-1, LS-2. Mr. Sherwood performed testing at a frequency of 100%, this QAI performed a QA verification Magnetic Particle Test at a frequency of 10%. See the Magnetic Particle Testing report dated 7/18/12 for more information.

This QAI observed Tran Chau welding the above listed repair excavations utilizing the Shield Metal Arc Welding to the parameters set forth in the approved Welding Procedure Specification using E9018 consumable electrode. During welding operations a 350F preheat was maintained using induction heating blankets. At the conclusion of welding operations post heat was initiated at 450F for four hours.

12W Corner OBG Drop-In

This QAI observed Welder Mike Jiminez using a rosebud torch to preheat stiffener splice 12W-13W 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 12W-13W LS-3 by welder Mike Jiminez 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 Jiminez was observed using the stringer method and good workmanship practices in regard to interpass cleaning.



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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 |
|---------------------|--------------|-------------|