

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-028035
Date Inspected: 22-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: 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:

QA Incident Report

This QA submitted an Incident report for improper back gouge surface of drop-in field splice at 12W-W2.1-C.1. The excavation was not carbon arc excavated and ground to acceptable profile per applicable contract documents.

Applicable reference:

AWS D1.5-2002 Chapter 3 Section 3.3 / Para. 3.3.10 J- and U-grooves may be prepared before or after assembly. Second-side grooves may be prepared by air carbon arc gouging and grinding after welding the first side. Before welding, the J- or U-groove shall conform to the provisions of this section.

AWS D1.5-2002, Chapter 3 Section 3.3 / Para. 3.3.5 Groove preparations produced by gouging shall be substantially in conformance with groove profile dimensions as described in Figures 2.4 and 2.5.

AWS D1.5-2002, Chapter 3, Section 3.3 / Para. 3.2.6-Where any carbon arc gouging or cutting is involved, proper arc gouging procedures shall be used to avoid the retention of carbon deposits and material or dross in the areas which are to be welded. Air carbon arc gouged surfaces shall be ground to bright metal.

Please see photographs submitted with this report for more information.

In Process Visual Inspection

WELDING INSPECTION REPORT

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This QA randomly observed ABF/JV qualified welder Roby Smith #1037 performing Shielded Metal Arc Welding (SMAW) with 3.2mm" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1010-R1. The joint being welded was DAH-5W-PP13.5-W2. During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters.

This QA randomly observed ABF/JV qualified welder Xiao Hua Luo #1291 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-W2-PP115-117. During welding, ABF Quality Control (QC) Steve Jensen was noted monitoring the welding parameters.

This QA randomly observed ABF/JV qualified welder Wai Kit Lai #2953 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-W2-PP114-115. During welding, ABF Quality Control (QC) Steve Jensen was noted monitoring the welding parameters.

This QA randomly observed ABF/JV qualified welder Jimmy Zhang #6001 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/13W-C1.1 (external).

During welding, ABF Quality Control (QC) Steve Jensen was noted monitoring the welding parameters.

This QA randomly observed ABF/JV qualified welder Steven Davis #7889 performing Shielded Metal Arc Welding (SMAW) with 3.2mm" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1100-1. The joint being welded was 13W-PP123-W2.8-BF1. During welding, ABF Quality Control (QC) Steve Jensen was noted monitoring the welding parameters.

This QA randomly observed ABF/JV qualified welder Steven Davis #7889 performing Shielded Metal Arc Welding (SMAW) with 3.2mm" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1100-1. The joint being welded was 13W-PP123-W2.1-BW1. During welding, ABF Quality Control (QC) Steve Jensen was noted monitoring the welding parameters.

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

WELDING INSPECTION REPORT

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Summary of Conversations:

Conversations were relevant to testing performed.

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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