**DEPARTMENT OF TRANSPORTATION**
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

# WELDING INSPECTION REPORT

**Resident Engineer:** Casey, William
**Address:** 333 Burma Road
**City:** Oakland, CA 94607

**Report No:** WIR-028098
**Date Inspected:** 02-Aug-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:** Fred Michels

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| **Inspected CWI report:** | ☐ Yes | ☑ No | ☐ N/A | **CWI Present:** | ☑ Yes | ☐ No | |
| **Electrode to specification:** | ☑ Yes | ☐ No | ☐ N/A | **Rod Oven in Use:** | ☑ Yes | ☐ No | ☐ N/A |
| **Qualified Welders:** | ☑ Yes | ☐ No | ☐ N/A | **Weld Procedures Followed:** | ☑ Yes | ☐ No | ☐ N/A |
| **Approved Drawings:** | ☑ Yes | ☐ No | ☐ N/A | **Verified Joint Fit-up:** | ☑ Yes | ☐ No | ☐ N/A |
| | | | | **Approved WPS:** | ☑ Yes | ☐ No | ☐ N/A |
| | | | | **Delayed / Cancelled:** | ☐ Yes | ☑ No | ☐ N/A |

**Bridge No:** 34-0006
**Component:** OBG and Tower

**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 the fitting and tacking of PPE pipe supports in FES-A6-1W one of the four subassemblies comprising assembly ESD1-TL6-2. The fitting and tacking was being performed by qualified welder Kevin Kananen utilizing the Shield Metal Arc Welding Process to the parameters set forth in approved Welding Procedure Specification ABF-WPS-D15-F1200-A. Tacking parameters were recorded at standard intervals by QC Technician Fred Michels and verified at random intervals throughout the shift by this QAI.

This QAI observed Kevin Kananen preheating in preparation for welding. The base metal was heated to approximately 150F. QAI observed the preheat being monitored by Quality Control Technician Fred Michels at regular intervals, this QAI verified preheat at random intervals.

QAI observed the welding of PPE pipe supports in FES-A6-1W one of the four subassemblies comprising assembly ESD1-TL6-2. The welding was being performed by qualified welder Kevin Kananen utilizing the Shield Metal Arc Welding Process to the parameters set forth in approved Welding Procedure Specification ABF-WPS-D15-F1200-A. Welding parameters were recorded at standard intervals by QC Technician Fred Michels and verified at random intervals throughout the shift by this QAI.

This QAI observed the fitting and tacking of PPE pipe supports in FES-A6-1E one of the four subassemblies

comprising assembly ESD1-TL6-2. The fitting and tacking was being performed by qualified welder Kevin Kananen utilizing the Shield Metal Arc Welding Process to the parameters set forth in approved Welding Procedure Specification ABF-WPS-D15-F1200-A. Tacking parameters were recorded at standard intervals by QC Technician Fred Michels and verified at random intervals throughout the shift by this QAI.

This QAI observed Kevin Kananen preheating in preparation for welding. The base metal was heated to approximately 150F. QAI observed the preheat being monitored by Quality Control Technician Fred Michels at regular intervals, this QAI verified preheat at random intervals.

QAI observed the welding of PPE pipe supports in FES-A6-1E one of the four subassemblies comprising assembly ESD1-TL6-2. The welding was being performed by qualified welder Kevin Kananen utilizing the Shielded Metal Arc Welding Process to the parameters set forth in approved Welding Procedure Specification ABF-WPS-D15-F1200-A. Welding parameters were recorded at standard intervals by QC Technician Fred Michels and verified at random intervals throughout the shift by this QAI.

**Summary of Conversations:**

There were general conversations with Quality Control Inspector Fred Michels, 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 |
| **Reviewed By:** | Levell,Bill | QA Reviewer |