

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-028099**Date Inspected:** 03-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** Fred Michels**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 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-A6-1E one of the four subassemblies comprising assembly ESD1-TL6-2. The fitting and tacking was being performed by qualified welder Kevin Kananen utilizing the Shielded 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.

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

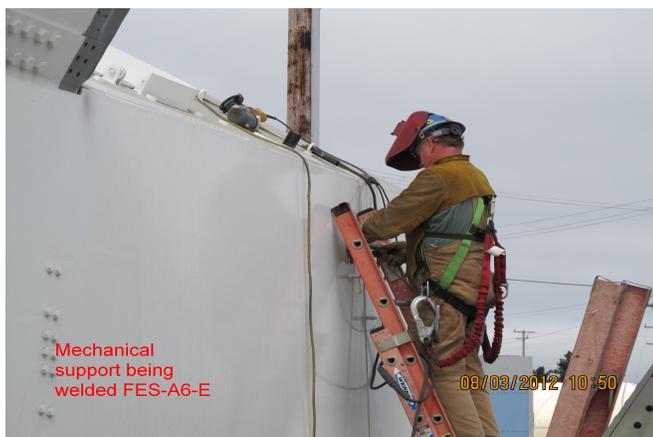
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comprising assembly ESD1-TL6-2. The fitting and tacking was being performed by qualified welder Kevin Kananen utilizing the Shield Metal Arc Welding Process to the parameters set forth in approved Welding Procedure Specification ABF-WPS-D15-F1200-A.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

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QAI observed the welding of PPE pipe supports in FES-A6-1N 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.



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.

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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
