

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-028139**Date Inspected:** 07-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:** Job Site**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:** S.A.S. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI reviewed contract documents at pier 7. The QAI used approved weekly welding report submittals and cross referenced the welding and inspection status as reported with QA records to identify the overall weld status. The QAI continued filing the welding report submittals that were reviewed during the previous week. This work was in progress until the end of the shift.

The QAI was present at the Skyway Bikepath and witnessed a horizontal stud welding procedure qualification record (PQR) with Bleyco worker Sam Benton operating the stud welding machine. The QAI noted that 1/4" diameter, 1 1/4" threaded stainless steel studs are being / will be used to attach the electrical conduit piping onto the skyway bikepath panels where modifications have been made for Contract Change Order (CCO) 179. The QAI noted that 2 procedures for flat position and overhead position have been previously qualified, (Stud Welding Procedure Specification (WPS) S001 and S002). At this time, the QAI also witnessed Bleyco worker Carlos Garcia performing the production testing for the overhead studs that will be welded during this shift. The QAI noted that the testing and welding is being monitored by the Quality Control Inspector (QCI) Fred Michels. The QAI was informed that the torque testing of the production testing and PQR testing is acceptable. The QAI examined the stud welds and noted that they appeared to be visually conforming to the contract requirements. The QAI made further observations of the work being performed during this shift and noted that the work appeared to be conforming to the contract requirements. See the TL-6032 report for the PQR information and the attached photos.

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The QAI made observations of welding in progress at Pier 7. The QAI noted that ABF workers Kevin Kananen, ID 6521, and Chris Bruce, ID 8901, are making Shielded Metal Arc Weld (SMAW) fillets, attaching pipe supports onto the tower head cover assembly. The QAI noted that the QCI Fred Michels is monitoring this welding. The QAI reviewed the available drawings / details for the pipe penetrations and noted that the work also includes welding of the dehumidification duct attachments to the tower head cover assembly. The QAI noted that the work is using ABF-WPS-D1.5-F1200A. The QAI made random observations of the work during this shift and noted that the welding appeared to be visually conforming to the contract requirements. The QAI noted that the work was less than 50% complete at the end of the shift. The QAI also noted that the contractor will conduct Magnetic Particle Testing (MT) of the welds when they are completed. See the attached photos.



Summary of Conversations:

The QAI relayed the status of the document reviews and welding observations to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations.

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:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
