

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-028140
Date Inspected: 31-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: 1730
Location: jobsite

CWI Name:	See Body of Report	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:

This QAI observed Welder Xiao Juan Wan (ID#9677) using a rosebud torch to preheat Stiffener FS-13-WJ to a QC recorded, QA verified temperature of 250F. Preheat temperature was measured using a Tempil Stick. This QAI noted QC Tony Sherwood recording preheat temperature whenever there was a stop in work.

After the proper preheat temperature was achieved, Xiao Hua Luo (ID#1291) began welding the plates together utilizing the Shield Metal Arc Welding Process to the parameters in the Approved Welding Procedure Specification ABF-WPS-D15-1040-C1 for the 3G, and 4G position. The welder is exhibiting good workmanship practices performing inter pass cleaning of in process welds. This QAI observed QA Technician Steve Jensen performing in process inspection to assure compliance with the applicable Welding Procedure Specification.

This QAI reported to the American Bridge Warehouse on the Jobsite Pier Area to observe the welding of grip plates on the following 21 cover plates that will form the Tower saddle Housing:

TSH 15a, 15g, 15b, 15f, 15c, 15e, 15d, 28a, 28g, 28b, 28f, 28c, 28e, 28d, 2a, 2g, 2b, 2f, 2c, 2e, 2d.

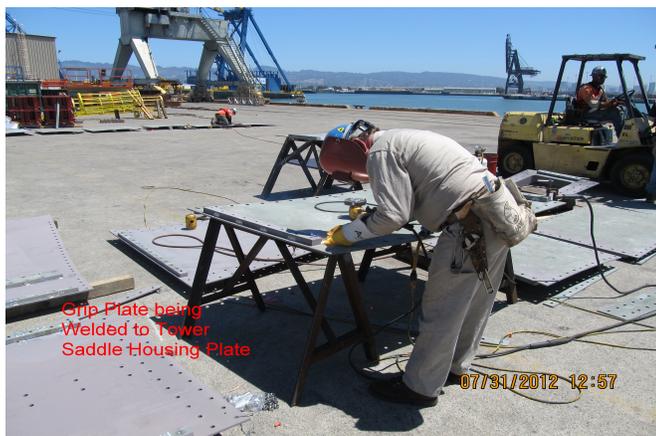
This QAI observed Welder Kevin Kananen (6521) preheating the above-mentioned plates utilizing a rosebud torch in preparation for welding. This QAI noted QC Technician Fred Michels recording preheat temperature

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throughout the day.

Per RFI ABF-RFI-002943R00 (CCO93) the grip and cover plates were to be joined by 25mm long, 3mm minimum in size stitch fillet welds on a 200mm center spacing. The welding was 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 Steve Jensen, 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.

Inspected By: Daggett, Matt

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer