

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-028295
Date Inspected: 16-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: 1900
Location: Job Site

CWI Name:	See 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:	OBG and Tower		

Summary of Items Observed:

At the start of the shift this Quality Assurance Lead Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed, to observe the welding and the QC inspection of the following:

Joselito Lizardo-OBG W13/W14 Drop-In Panel (Observation of welding, QC inspection and testing of edge plate, longitudinal stiffeners deck stiffener flanges), OBG W13 Drop-In Panels (Observation of welding of vertical WT @ LD and floor beams and QA/VT, MPT verifications).

Rodney Patterson-OBG E13 Drop-In Panel (Observation of excavations, repair welding, QC inspection and testing of the deck field splices).

Fritz Belford-OBG W12 Drop-In Assembly (Observation of repair welding, production welding, QC inspection and testing of floor beams, deck stiffener flanges and deck splices) and QA/VT, MPT verification.

Matt Daggett-OBG W12& E12 (Observation of welding, QC inspection and testing of deck access hole).

William Clifford-Tower Shear Plates/ESW "G" (Observation of repair welding, QC inspection and testing) and performed QA/QC joint UT.

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Doug Frey-OBG E12 Corner Drop-In Ass'y (Observation of welding, QC inspection and testing of longitudinal stiffeners), OBG E13, Drop-In Panel (Observation of QC/MPT & UT).

Rob DeArmand-OBG W13 Drop-In Panel (Observation of welding, QC inspection and testing of floor beams, longitudinal stiffeners and repairs welding of floor beams).

Scott Croff-Tower Shear Plates/ESW "G" (Observation of repair welding, QC inspection and testing).

NOTE: See QA daily Weld Inspection Reports (WIR) and NDE reports for additional information and details.

Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, William Clifford, Rob DeArmand, Rodney Patterson, Scott Croff, Fritz Belford, Doug Frey and Matt Daggett monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and there were two (2) issues noted during this shift. See Summary of Conversations.

This QA Lead Inspector commence the review of NDT reports, tracking of welding and developing and generating weld maps for W13 drop-in panels, E12 and W12 corner drop-in assemblies. This QA Lead Inspector also reviewed RWR documents for tracking purposes.

Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

There were also, other pertinent conversations with QA Supervisor, William Levell, throughout the course of this shift in regards to scheduling of QA personnel, work progress and related structural steel and weld issues. There were two (2) significant issues noted as described below:

Issue 1

The QAI, Joselito Lizardo, informed this QALI at the request of the QC Lead Inspector, Bonifacio Daquinag, Jr. regarding the Magnetic Particle Testing of the lifting lugs remnants located at the OBG W13 and identified as 13W-PP121.5-W3 and at the conclusion of the QA/MPT verification task Mr. Lizardo noted four (4) indications. This QALI spoke with Mr. Daquinag regarding this issue and inconclusion of the discussion Mr. Daquinag said he would speak with the QCI, Bernard Docena. This QALI informed Mr. Daquinag that if this situation happens again that as Incident Report (IR) would be generated. For additional information see Mr. Lizardo's daily Weld

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Inspection Report (WIR) generated on this date.

Issue 2

This QALI was also notified by the QA inspector, Mr. Lizardo, that there was second issue regarding a weld repair. It appears that the weld identified as 13E-E2.1, repair cycle #4 will require a contractor's Request for Weld Repair (RWR). This item was observed and noted as a fourth time repair. The contractor was notified of this issue and elected to commence the excavation and repair welding prior to the engineer's approval. At the conclusion of this discussion, this QALI decided that this action by the contractor would warrant an Incident Report (IR) and directed Mr. Lizardo to generate and submit an this IR to the QA Task Leader, William Levell, for his review and disposition.

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:	Reyes,Danny	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
