

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-028396**Date Inspected:** 13-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** S.A.S. Job site**CWI Name:** Pat Swain**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. Structure**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 reviewing welding report submittal 1536R129, for conformance with the contract requirements. The QAI also continued reviewing welding report packages 124, 125 and 126 for comments prior to submittal. This work was in progress until the end of the shift.

The QAI returned to the skyway bikepath and spoke with the Bleyco (electrical) personnel on site. The QAI was informed that no welding is planned or was performed during the previous work shifts, and that they are only qualified for welding the conduit mounting studs. The QAI confirmed that the contractor is not welding on the bikepath skyway at the present time and relayed to the QAI Lead Bill Levell.

The QAI was tasked with monitoring the welding and repairs being performed by ABF welder Rick Clayborn, ID 2773. The QAI noted that retrofit of longitudinal stiffeners (LS) is being performed in OBG 12W at panel point (pp) 111.1, adjacent to the corner assembly splice welds. The QAI observed fitting and welding of the retrofit plate between LS1 and LS2. The QAI noted that the welding is being monitored by the Quality Control Inspector (QCI) Pat Swain. The QAI was informed that the vertical fillet welds (3F) are required to be 12mm size. The QAI noted that welding procedure specification (WPS) ABF-WPS-D15-F1200A is being utilized with an elevated preheat temperature due to the LS being grade 485W. The QAI noted that during the fitting and welding, the

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preheat and interpass temperatures were maintained and the welding parameters were within the ranges listed on the WPS. Upon completion of 2 of the 4 welds, the QAI was informed that this work will be continued during the next shift. The QAI noted that the completed welds appeared to be visually conforming to the contract requirements but the final inspection will not be performed until the required cooling time is achieved. Reference the attached photos.

While the QAI was monitoring this work, the QAI noted that another welder in the area, pp112, was not monitored by any QCI from approximately 1630 to 1900 hours. The QAI relayed this information to the QAI Danny Reyes and wrote a non-conforming incident report to document the occurrence. Reference the TL-15IR for additional information.



Summary of Conversations:

The QAI relayed the status of the document reviews, welding observations and the observation of no QCI monitoring welding at pp112 to the QAI Lead Bill Levell. The QAI was informed that, regarding submittals where Electro-Slag Welds (ESW) have been examined for the joint inspections, all reports need to be submitted or the submittal will be returned for correction / addition of the missing reports. 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 Gary Thomas, (916) 764-6027, who represents the Office of Structural Materials for your project.

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