

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-028430
Date Inspected: 18-Sep-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 E13 Drop-In Panel (Observation of excavations, repair welding, QC inspection and testing of the deck plate splices identified as 13E-E2.1 & 13E-E2.4) and FW Spencer (Observation of welding of the 2.5' and 4" mechanical piping located at various areas).

Rodney Patterson-OBG W13/W14 Drop-In Panel (performed QA/UT verification at various locations).

Fritz Belford-OBG W12 Corner Drop-In Ass'y. (Observation of welding, QC inspection and testing of the floor beams and excavations, repair welding, QC inspection and testing).

Matt Daggett-OBG W13 Corner Drop-In Ass'y. (Observation of welding, QC inspection and testing of floor beams and excavations, repair welding, QC inspection and testing of floor beams).

William Clifford-OBG W12 & W13 Corner Drop-In Ass'y (Observation of excavation, repair welding, QC inspection and testing).

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Doug Frey-OBG E12 Corner Drop-In Ass'y (Observation of excavations, repair welding, production welding, QC inspection and testing of floor beams).

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

OBG E12 Corner Drop-In Ass'y.

The QALI observed the Shielded Metal Arc Welding (SMAW) of the floor beam field splice located at PP111.5 and identified as Weld Number (WN): 12E-PP111.5. The Complete Joint Penetration (CJP) groove welding was performed by welding personnel Alex Blanco ID-9650 utilizing the Welding Procedure Specification (WPS) ABF-WPS-D15-4030A-CU, Rev. 0. The WPS was also used by the AB/F Quality Control (QC) inspector Sal Merino and QA inspector Doug Frey as a reference when performing QC/QA verification. The groove joint appeared to comply with the AWS joint designation identified as B-U2a. The QC inspector also monitored the minimum preheat temperature of 20 degrees Celsius and the maximum interpass temperature of 230 degrees Celsius. This QALI performed at random observations during the shift and the work performed by Mr. Frey appeared to comply with the contract specifications.

Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, William Clifford, Rodney Patterson, 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. There were no issues noted during this shift.

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 received the Request for Weld Repair (RWR) 201209-101 and the latest RWR Spread Sheet. All documents were received via e-mail.

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 no issues noted during this shift.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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 Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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