

**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-028493**Date Inspected:** 25-Sep-2012**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Arrival Time:** 730**OSM Departure Time:** 2000**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 was tasked with monitoring the welding and repairs being performed by ABF welder Rick Clayborn, ID 2773. The QAI noted that repairs are in progress in the Deck Access Hole (DAH) on OBG 13W at panel point (pp) 116.5. The QAI noted that the welding is being monitored by the Quality Control Inspector (QCI) Pat Swain. The QAI noted that the Complete Joint Penetration (CJP) groove weld is being repaired from the bottom in the overhead (4G) position. The QAI also noted that this is a first time repair and the full length of the weld will be repaired using approved weld repair RWR 201208-076. The QAI noted that welding procedure specification (WPS) ABF-WPS-D15-1004-Repair is being utilized. The QAI noted that during the welding, the preheat and interpass temperatures were maintained and the welding parameters were within the ranges listed on the WPS. See the attached photo. At approximately 1130 hours, the QAI was re-assigned to review documents at pier 7.

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 package 127 and 128 for conformance with the contract requirements. This work was in progress until the end of the shift.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

The QAI relayed the observation of the welding and repairs to the QAI Danny Reyes and the QAI Lead Bill Levell.

The QAI also relayed the status of the document reviews 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 Gary Thomas, (916) 764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Croff, Scott	Quality Assurance Inspector
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<b>Reviewed By:</b>	Levell, Bill	QA Reviewer
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