DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-028603
Date Inspected: 12-Oct-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:

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☐ Yes	☑ No	
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ 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:

Quality Assurance Inspector (QAI) Matthew Daggett was at the American Bridge/Fluor (ABF) job site at the San Francisco/Oakland Bay Bridge in California between the times noted above in order to perform clerical support tasks in the office, and to monitor Quality Control functions and the in process work being performed by ABF personnel:

This QAI performed various tracking and organizational fuctions in the office. These functions included but were not limited to: Filing, updating tracking logs, and support activities for field inspectors. The QAI utilized his computer and prior experience to complete task in a timely manner.

This QAI sporadically observed the welder Chris Bowles (9317) grinding to a bright clean metal condition the bike path hand rail tube, and the galvanized gate bracket preparing both to receive weld at the following locations: Skyway Bike Path PP E42, and PP E46
The welder spent part of the shift depositing the root passes and fill passes with approximately 100% being completed at the end of the shift. QC inspector S. Merino was noted to be present in order to monitor the progress and ensure the welding was within the established Welding Procedure Specification (WPS) noted as ABF-WPS-D15-1001 Rev 0 and supporting Procedure Qualification Records (PQR). Prior to and during the welding at this location the QC inspector observed the preheat temperature using a Raytek non-contact Thermometer, was sufficient and compliant to the above-mentioned WPS. Using a Tempil Stick, (temperature indicating crayon) the pre-heat was then verified by this QA inspector to be greater than specified. Using a Fluke brand Tong style meter, the parameters were verified to be 127 amps. See photo attached to body of report.

WELDING INSPECTION REPORT

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This QAI from time to time observed welder Kevin Kananen reworking Stanchion Assembly Kilo Post 13.2/13.9 (as shown on shop drawing #A825-Sheets 1 of 3, 2 of 3, 3 of 3). Angle MM2 and connection plate PSLA were miss located on post. Mr. Kananen removed the angle and plate by grinding and located them per the shop drawing.

After tack welding the angle and plate in the detailed position, the welder spent part of the shift depositing the root passes and fill passes with approximately 100% being completed at the end of the shift. QC inspector S. Merino was noted to be present in order to monitor the progress and ensure the welding was within the established Welding Procedure Specification (WPS) noted as ABF-WPS-D11-1190 Rev 0/ABF-WPS-D11-F1200A Rev 0 and supporting Procedure Qualification Records (PQR). Prior to and during the welding at this location the QC inspector observed the preheat temperature using a Raytek non-contact Thermometer, was sufficient and compliant to the above-mentioned WPS. Using a Tempil Stick, (temperature indicating crayon) the pre-heat was then verified by this QA inspector to be greater than specified. Using a Fluke brand Tong style meter, the parameters were verified to be 125 amps. See photo attached to body of report.

Summary of Conversations:

See body of report.

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:	Daggett,Matt	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer