

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-028798
Date Inspected: 13-Nov-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: Job Site

CWI Name:	As noted 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	

Summary of Items Observed:

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

In Process Visual Inspection

RWR201210-013

This QA observed, at random intervals, an ABF/JV welder, Mike Jiminez #4671, performing Shielded Metal Arc Welding (SMAW) with 4.0mm diameter E7018-MH4-R electrode and implementing Welding Procedure Specification (WPS) ABF-WPS-D15-1000-R. Welding was performed on the longitudinal seam location designated as 12E-E2.1-C1.

This weld portion is a Seismic Performance Critical Member (SPCM) member.

Y= 4500mm~6500mm. (internal)

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters.

RWR201210-016

This QA observed, at random intervals, an ABF/JV welder, Chris Bruce #8901, performing Shielded Metal Arc Welding (SMAW) with 4.0mm diameter E7018-MH4-R electrode and implementing Welding Procedure Specification (WPS) ABF-WPS-D15-1000-R. Welding was performed on the longitudinal seam location designated as 12E-E2.1-C1.

This weld portion is not a Seismic Performance Critical Member (SPCM) member.

Y= 22500mm~23500mm.

WELDING INSPECTION REPORT

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During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters.

RWR201210-016

This QA observed, at random intervals, an ABF/JV welder, Richard Chounard #8959, performing Shielded Metal Arc Welding (SMAW) with 4.0mm diameter E7018-MH4-R electrode and implementing Welding Procedure Specification (WPS) ABF-WPS-D15-1004-R. Welding was performed on the longitudinal seam location designated as 12E-E2.1-C1.

This weld is a Seismic Performance Critical Member (SPCM) member.

Y= 29500mm~30500mm.

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters.

Note:

This QA received the MIC 20 UCI (Ultrasonic Contact Impedance) hardness tester for testing at future locations on the Orthotropic Box Girder. This QA used portions of the shift not dedicated to random observation of Quality Control and welding personnel to gain familiarity with the test probe. This QA reviewed supplied documentation and calibration procedures for the MIC 20.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversation was relevant to welding performed during this shift.

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:	Clifford,William	Quality Assurance Inspector
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Reviewed By:	Reyes,Danny	QA Reviewer
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