

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-028972
Date Inspected: 10-Jan-2013

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: See Body of Report
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A
Component: OBG

Bridge No: 34-0006**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 observed the welder Mike Jiminez grinding to a bright clean metal condition base metal gouges, in the Deck Plate at the following locations:

PP123.5-E2.9

PP124.5-E3.0

PP124.5-E3.1

PP124-E3.2

PP124.3-E3.45

Prior to welding, Quality Control Technician Sal Merino, performed Visual and Magnetic Particle Testing on the above base metal gouges. This Quality Assurance Inspector verified the results of the test. No indications were noted.

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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 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-D15-1001R 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 150F. Using a Fluke brand Tong style meter, the parameters were verified to be 115 amps.

RWR 201301-019 that addresses these repairs is in the process of being reviewed. At the time of this report it is not approved.

12W-W2.1-C1

This QA inspector observed first time weld repair being performed by ABF welding personnel Michael Jiminez on OBG Splice, at the following location: (RWR-201301-020)

Y= 10330mm, D=4mm, W=18mm, L=30mm

This QA Inspector observed Mr. Jiminez preheating to a QC recorded, QA verified temperature of 250F prior to using the Carbon Arc Gouging process to remove defects at the above-mentioned locations on the Splice. The locations and depth of the defects had been marked on the steel by the Ultrasonic Technician at the conclusion of his testing. At the end of gouging operations Mr. Jiminez ground the excavations to a bright clean metal condition in preparation of Visual and Magnetic Particle Testing.

Prior to welding Quality Control Technician John Hayes performed Visual and Magnetic Particle Testing on the above excavation. This Quality Assurance Inspector verified the results of the test by doing duplicate testing to the excavations. No indications were noted.

The welder spent a fraction of the shift depositing the root passes and fill passes with approximately 100% being completed at the end of the shift. QC inspector Hayes 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-D15-1004R (Rev 0) and supporting Procedure Qualification Records (PQR). Prior to and after the welding at this location the QC inspector observed the preheat temperature and post heat temperature using a Raytek non-contact Thermometer, was sufficient and compliant to the above-mentioned WPS. Using a Tempil Stick, (temperature indicating crayon) the preheat, and post heat temperature was then verified by this QA inspector to be greater than 350F and 450F respectively. Using a Fluke brand Tong style meter, the parameters were verified to be 133 amps.

Summary of Conversations:

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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
