

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-029016
Date Inspected: 21-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:				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 (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 updated the spread sheets used to track RWR's. The spread sheet will be used not only for tracking purposes but as a guide for the inspection team to more readily access the RWR's for inspection purposes.

The QAI also updated the spreadsheet tracking the status of Non-Destructive Testing (NDT) on the project, and filed a hard copy of the NDT reports in the proper binder. The updated spreadsheet was forwarded to the inspection team for their use.

This QAI spent time maintaining the binder and spreadsheet tracking RWR's by weld joint number. Due to the amount of RWR correspondence, this task is on going. The tracking system, and filing system is in place now for organization by weld joint number so this should be a maintenance activity from now on.

This QAI continues closing out RWR's upon receipt of the QA Non-Destructive Testing Reports. When the QA NDT reports are received this QAI stamps the corresponding RWR "Completed" and files them in a three ring binder for future reference.

This QAI monitored the ABF Warehouse and Pier area for fabrication activity that requires QA Inspection. This

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QAI also stayed in contact with the ABF Quality Control Team to keep abreast of any up-coming work.

13E-PP119 (CCO238)

This QAI observed the welder Mike Jiminez preparing stiffeners at the above-mentioned location for welding. It was noted that areas to receive weld was ground to a smooth bright clean metal condition.

The welder spent part of the shift depositing the root passes and fill passes with approximately 20% being completed at the end of the shift. QC inspector Fred Michaels 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-D15-2170-3 Rev 0 and supporting Procedure Qualification Records (PQR) for the Partial Joint Penetration (PQR)welds and ABF-WPS-D15-F2200-2 and supporting Procedure Qualification Records (PQR) for the fillet cap welds. Prior to and during the welding at this location the QC inspector Fred Michaels monitored 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 complying with the WPS.

14E-PP126.5-E2

This QAI observed the welder Richard Garcia preparing longitudinal stiffeners at the above-mentioned location for welding. It was noted that areas to receive weld was ground to a smooth bright clean metal condition.

The welder spent part of the shift depositing the root passes and fill passes with approximately 40% being completed at the end of the shift. QC inspector Sal 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-D15-1110-A Rev A and supporting Procedure Qualification Record. Prior to and during the welding at this location the QC inspector Sal Merino monitored 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 131 amps.

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

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Reviewed By: Reyes,Danny

QA Reviewer