

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-029251
Date Inspected: 16-Mar-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: 1530
Location: On Site

CWI Name:	Bernie Docena	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:	Skyway Lifting Lug Holes	

Summary of Items Observed:

The Quality Assurance (QA) Inspector, Art Peterson arrived on site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and monitor the welding operations performed by American Bridge Fluor (ABF) welding personnel. The following observations were:

Skyway Lifting Lug Hole (SLLH) – East Bound SLLH #10:

The QA Inspector observed ABF welder Kit Lai (Welder ID 2953) performing the fit-up, tack-weld, root, fill and cover pass weld operation per the Shielded Metal Arc Welding (SMAW) process in the (1G) flat position on the (top side) of deck plate on East bound SLLH #10.

The QA Inspector observed QC Inspector Bernie Docena verify that the fit-up of the lifting lug hole insert plate was fit-up into East bound SLLH #10 within the fit-up tolerances as specified in WPS D1.5-1030-SMAW-1G. The QA Inspector performed a fit-up verification inspection and the fit-up of the lifting lug hole insert plate into East bound SLLH #10 appeared to be in general compliance with WPS D1.5-1030-SMAW-1G

The QA Inspector observed QC Inspector Bernie Docena verify prior to the start of the tack-weld operation, that the minimum preheat temperature of (150) degrees Fahrenheit as per the approved WPS was established; and afterwards verified that the welding parameters (Amps and Travel Speed) were in accordance with WPS D1.5-1030-SMAW-1G using E7018 (3 mm) and (4 mm) diameter electrode.

WELDING INSPECTION REPORT

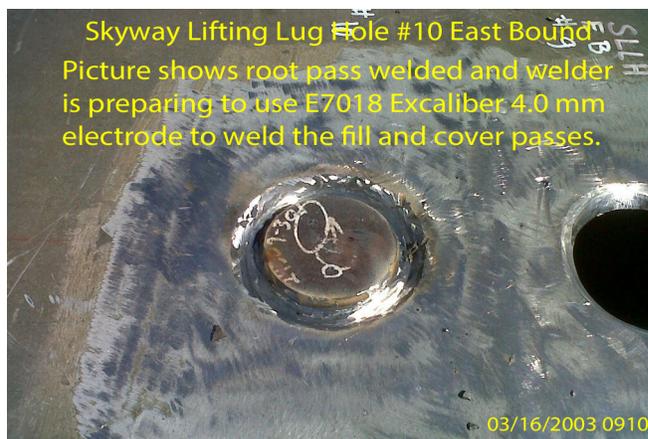
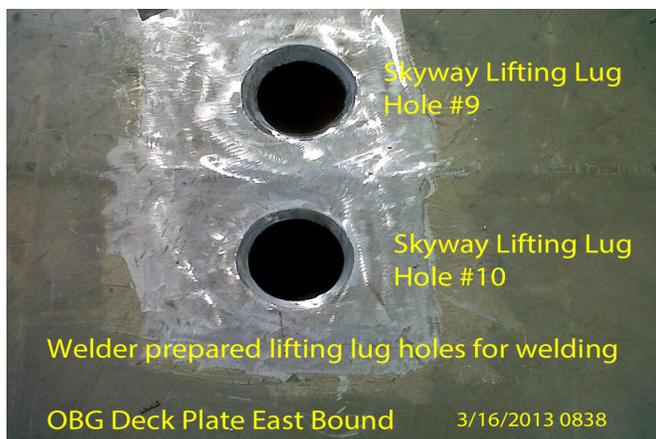
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The QA Inspector observed that ABF welder Kit Lai was in-process on the cover pass weld operation on East bound SLLH #10 at the end of this QA Inspectors' shift.

Skyway Lifting Lug Hole (SLLH) – East Bound SLLH #1:

The QA Inspector performed ultrasonic test (UT) verification inspection on the complete-joint penetration (CJP) butt-joint groove weld on East bound SLLH #1 after Quality Control (QC) performed their final NDT as per AWS D1.5-2002 and the contract specifications. The UT verification inspection was performed on 10% of the weld length around the inside and outside diameter of East bound SLLH #1.

The UT verification inspection performed on this date appeared to be in general compliance with AWS D1.5-2002 Table 6.3 for the 16 mm thick butt-joint groove weld of East bound SLLH #1. See TL-6027 Ultrasonic Test Report dated 16-Mar-2013 for further details of the UT inspection.



Summary of Conversations:

Only general conversations with QC Inspector Bernie Docena regarding the fit-up of the insert plate to East bound SLLH #10 and the SMAW process being performed on this date.

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:	Peterson, Art	Quality Assurance Inspector
Reviewed By:	Mertz, Robert	QA Reviewer
