

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-029257**Date Inspected:** 10-Mar-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**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:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey 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:

This QA Inspector randomly observed the ABF welders Mike Jimenez #4671 and Guo Wu Chen #1556 perform the horizontal (2G) SMAW on the diverter bars located at 13W PP120 to PP124.5 on the west OBG. The welders were observed utilizing WPS ABF-D1.5-F1200A and was also observed preheating the welds prior to welding. Other welding parameters as inspected by the QC Inspector were recorded as 136 amperes and appeared to be in compliance with the WPS noted above. The QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was in progress and appeared to be in general conformance with the contract documents.

This QA Inspector randomly observed ABF welder Wai Kit Lai #2953 utilize the Carbon Arc Gouging (CAG) method to remove the weld metal from the back side of the weld joint of the East Skyway lifting lug Hole #8 on the interior of the Skyway. This QA Inspector observed the QC inspector perform the magnetic particle inspection to verify soundness of the metal and noted that no relevant indications were observed. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the welder was performing the SMAW process in the 4G overhead position in accordance with ABF-WPS-D1.5-1030-Revision 1. The QC inspector was observed monitoring the welding and the parameters as they applied to the above mentioned WPS and noted that the work at this location was in progress and appeared to be in general conformance with the contract documents.

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This QA Inspector randomly observed. ABF welder Terry McCormick #8494 performing Shielded Metal Arc Welding (SMAW) at the hinge “A” expansion joint east in the 2G horizontal positions on the expansion joint support plates [01] and typical barrel nuts in accordance with WPS ABF-WPS-D1.5-F1200A. The QC inspector monitored the welding and the parameters as they applied to the above mention WPS. This QA Inspector made subsequent observations to monitor quality and noted that the work at this location was in progress and appeared to be in general conformance with the contract documents.

This QA observed QC Inspector William Sherwood performing welding parameter checks such as voltage, amps, electrodes and preheats throughout the day. The Non-Destructive Testing (NDT) methods utilized by the QC Inspectors were Visual Testing (VT), Magnetic Particle Testing (MPT) and Ultrasonic Testing Shear Wave (UTSW). QC Inspectors were observed performing inspection per applicable code and or contract criteria. Unless otherwise noted, all work observed on this date appeared to generally comply with the contract documents.

Summary of Conversations:

Conversations were relevant to work performed.



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:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
