

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-029497**Date Inspected:** 24-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

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|------------------------------------|----------------|----|-----|
| CWI Name: | As noted below | | |
| 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: | SAS OBG/Tower | | |

Bridge No: 34-0006**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 observed the following welders working on the OBG at the following locations:

This QA Inspector randomly observed ABF welder Xiao Hua Luo #1291 perform the Shielded Metal Arc Welding (SMAW) process on the Ladder extension modification located on the Tower at elevation 143. The welder was observed utilizing WPS ABF-D1.5-F1200A for SMAW. The welder was observed preheating the surface area to be welded prior to welding. Other welding parameters as inspected by the QC Inspector were recorded as 127 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 completed on this date and appeared to be in general conformance with the contract documents CCO 203 and RFI-3277.

This QA Inspector randomly observed ABF welder Lin E Yun #9344 perform the SMAW process on the Dehumidification access door hinges located at 13E PP123-E3 and 13E PP120.5-E2.8. The welder was observed utilizing WPS ABF-D1.5-F1200A for SMAW and was observed preheating the surface area to be welded 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 completed on this date and appeared to be in general conformance with the contract documents.

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FW Spencer welder Rick Kiiikvee #5319 was observed performing SMAW welding on 2.5” domestic water and 4” compressed air outlets to schedule 40 pipe. The welder was observed utilizing WPS-1-12-1 and this QA Inspector observed the welder preheat the work prior to welding. Other welding parameters as inspected by the QC Inspector appeared to be in compliance with the WPS noted above. This QA Inspector made random observations throughout the shift and noted that the work was in process and appeared to be in general conformance with the contract documents. Work in progress on this date includes; 1/DW1/85/BE and 1/CA2/8.5/BE.

Summary of Conversations:

Conversations on this date 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.

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