

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-029515**Date Inspected:** 30-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**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/Tower**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 Lin E Yun #9344 utilizing the SMAW process on Partial joint Penetration (PJP) joints for the two (2) C150x16 channel to "A" deck of the OBG located at 14E PP128+3065mm.

The work at this location was completed on this date and the welder was observed attaching two (2) C150x16 channel to the W150x37 beam designated PSSA-1 located at 14E PP128+2465mm. This QA Inspector randomly observed ABF welders Jose Torres #6235 located at 14E PP127.3 installing one (1) C150x16 channel to "A" deck and one (1) C150x16 channel to a W150x37 beam. The welder was observed utilizing the SMAW process on the steel and appeared to comply with the details on ZPMC sheet no. PS1314EB. Parameters as inspected by the QC Inspector were recorded as 136-138 amperes and appeared to be in compliance with ABF-WPS-1160-Revision 0. 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.

FW Spencer welder Rick Kiikvee #5319 was observed performing SMAW welding on 4" schedule 40 pipe sockets. The welder was observed utilizing WPS-1-12-1 and the welder was observed pre-heating the surface area to be welded 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

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noted that the work was completed on this date and appeared to be in general conformance with the contract documents. Completed work on this date includes weld identification #'s; 23/4/25/BE, 24/4/25/BE, 1/DW1/94.5/BE, 1/DW1/93.5/BE, 1/DW1/92.5/BE and 1/DW1/91.5/BE.

This QA observed QC Inspector William Sherwood and Salvador Merino performing welding parameter checks such as voltage, amps, electrodes and preheats throughout the day. Non-Destructive Testing 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 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.

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