

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-029792
Date Inspected: 04-Jul-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: 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:	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 ABF welder Wai Kit Lai #2953 perform Flux Core Arc Welding (FCAW) in the 1F (flat) and the 3F (vertical) positions with Eric Sparks #3040 performing Shielded metal Arc Welding (SMAW) in the 4F (overhead) position as alignment operations commenced. This QA Inspector observed that survey was not available this date and a four (4) foot level was employed to align the sign assembly. It was determined that upon welding the alignment had changed and the welds were Carbon Arc Gouged (CAG) to make adjustments. This QA Inspector noted that several attempts were made to align the sign assembly that when a weld was made the alignment changed. On a subsequent observation the root passes were requested to be inspected by QC. This QA Inspector observed QC perform Magnetic Particle Testing (MPT) on the root passes and noted that no rejectable indications were present. The alignment was verified by ABF and the crane was removed from the assembly. This work is in progress.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversations on this date were relevant to work performed.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



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 SMR 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
