

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-029795**Date Inspected:** 11-Jul-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:** OBG/Shear Key E2**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:

FW Spencer welder Tim Esquivel #8348 was observed performing Shielded Metal Arc Welding (SMAW) welding on 2.5" and 4" schedule 40, pipe. 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 noted that the work was completed on this date and appeared to be in general conformance with the contract documents. 61/2.5/79/BE, 54/2.5/77/BE, 54A/2.5/77/BE, 77/4/121/BE and 81/4/121/BE were completed on this date.

FW Spencer welder Barry Mullaney #6520 was observed performing SMAW welding on 3x5x.5" angle for thrust blocks located at 8W PP62 W5 and 8E PP62 E5. The welder was observed utilizing WPS-FWS-Filletts Murex SFOBB Revision 2 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 noted that the work was completed on this date and appeared to be in general conformance with the contract documents. 130711-1, 130711-2 (west bound) 130711-3 and 130711-4 (east bound) were completed on this date.

E2 Shear Key Anchorages Plate Beam Assembly

WELDING INSPECTION REPORT

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This QA Inspector randomly observed ABF welder Rick Clayborn perform the thermal cutting of the bottom plate (101A) for the placement of the eight (8) studded sleeves (100A/B/C/D) as pertaining to sheet no. 7861-1011BB Delta 1 (Field locate and cut holes per actual locations). Upon completion of the cutting, it was noted that the north plate (of the north shear key) holes were being ground by ABF welding personnel to a smooth surface in accordance with AWS D1.5 Section 3, 3.2.3

(Steel and weld metal may be thermally cut, provided a smooth and regular surface free from cracks and notches is secured, and provided that an accurate profile is secured by the use of a mechanical guide. Freehand thermal cutting shall be done only when approved by the Engineer.)

This QA Inspector visually examined the south plate holes and observed a rough notched surface not in accordance with the code reference above (see photo below). This QA Inspector inquired to ABF Field Engineer Adam Reeves about the surface condition of the holes and he stated that they had been ground and no further work will be done. This QA Inspector informed Quality Control Inspector William Sherwood who informed ABF General Foreman Aaron Kent who stated that it will be taken care of tomorrow.

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.



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
