

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-029888
Date Inspected: 12-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: 1730
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/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. 57/2.5/77/BE, 47/2.5/126/BE, 46/2.5/126/BE, Lugs-130712-01 and 130712-02 were completed on this date.

FW Spencer welder Barry Mullaney #6520 was observed performing 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. 50/2.5/126/NE, 47/4/126/NE, 1/CA2/124/NE, 58/2.5/79/BE, 47/4/126/NE and 46/4/126/NE 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 welding personnel on the E2 north Shear Key plate assembly. it was noted that the south 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

Upon completion of acceptable grinding, This QA Inspector randomly observed ABF welder Wai Kit Lai #2953 perform Shielded Metal Arc Welding (SMAW) in the 4F (overhead) position on the Closure Rings on the north and south bottom plates of the North Shear Key. The welder was observed utilizing WPS ABF-D1.5- F1200A for SMAW fillet welding. The welder was observed preheating the surface area prior to welding and other welding parameters as inspected by the QC Inspector were recorded as 128 amperes and appeared to be in compliance with the WPSs 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.

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
