

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-029896**Date Inspected:** 03-Aug-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** SAS Superstructure

CWI Name:	Jesse Cayabyab/Bernard Docena	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:	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:

In Process Visual Inspection

ESW W-043, Location "V"-Face B
RWR201305-009

The QA Inspector observed, at random intervals, ABF welder Mike Jimenez (WID-4671) performing Shield Metal Arc Welding (SMAW) of the repair excavation on Electroslag Weld (ESW) "V", at face B location noted as:

Y= 6200~7000mm

L= 800mm

W= 80mm

D= 70mm

Prior to welding, the welder was observed preheating the weld to over 300° Fahrenheit prior to welding using the Miller ProHeat 35 with heat induction blankets. The welder was using 4.0mm diameter electrode (E7018-1 HR4) per ABF Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3. The welding parameters were verified by ABF Quality Control (QC) Inspector Jesse Cayabyab with a Flukemeter and preheat was verified

WELDING INSPECTION REPORT

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with temperature indicators. QC performed welding variable verifications at random interval throughout the shift. The welding observed appeared to be in compliance with the WPS noted above.

ESW G Face A
RWR201301-055

The QA Inspector observed, at random intervals, ABF welder Wai Kit Lai (WID-2953) performing Shield Metal Arc Welding (SMAW) of the repair excavation on Electroslag Weld (ESW) "G", at face A location noted as:

Y= 9400mm
L= 200mm
W= 50mm
D= 38mm

Prior to welding, the welder was observed preheating the weld to over 300° Fahrenheit prior to welding using the Miller ProHeat 35 with heat induction blankets. The welder was using 4.0mm diameter electrode (E7018-1 HR4) per ABF Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3. The welding parameters were verified by ABF Quality Control (QC) Inspector Bernard Docena with a Flukemeter and preheat was verified with temperature indicators. QC performed welding variable verifications at random interval throughout the shift. The welding observed appeared to be in compliance with the WPS noted above.

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:	Mertz,Robert	QA Reviewer
