

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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015861**Date Inspected:** 28-Jul-2010**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:** Jobsite**CWI Name:** See 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**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Splice 1W/2W Weld ID: D1 & D2, Face A
- 2). OBG Field Splice 1W/2W Weld ID: D2, Face A
- 3). OBG Field Splice 1W/2W Weld ID: F1, Face B
- 4). OBG Field Splice 4W/5W Weld ID: B1, Face B
- 5). OBG Field Splice 4W/5W Weld ID: D1 & D2, Face B

- 1). OBG Field Splice 1W/2W Weld ID: D1 & D2, Face A

The QAI periodically observed QC Jesse Cayabyab and AB/F approved welder Kenneth Chappell performing layout on the A face of rejectable Ultrasonic Testing (UT) indications detected from the B face that will be more shallow excavations from the A face.

- 2). OBG Field Splice 1W/2W Weld ID: D2, Face A

The QAI periodically observed AB/F approved welder Fred Kaddu (ID 2188) performing welding of a repair excavation per the Shielded Metal Arc Welding (SMAW) process in the 1G (flat) position of one Ultrasonic Testing (UT) reject area from the A face of the splice weld. QC Inspector Tom Pasqualone was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1000-Repair. The repair welding at this repair

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location was completed and the work appeared to be in general compliance with contract documents.

3). OBG Field Splice 1W/2W Weld ID: F1, Face B

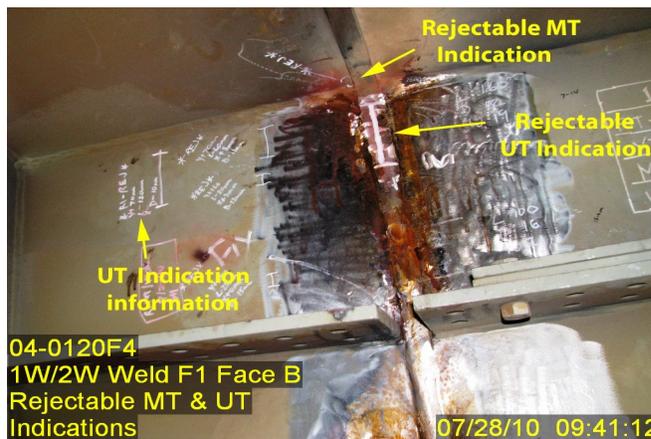
The QAI observed QC Inspector Steve McConnell performing Magnetic Particle Testing (MT) of (3) UT rejectable indication repair areas in OBG Field Splice 1W/2W Weld ID: F1 from the B Face. See photo below. Mr. McConnell accepted the MT results of the repair areas but found a MT rejectable indication at the transition/radius area (where weld F1 meets weld A5). The QAI observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. The QAI then periodically observed that QC McConnell performed Ultrasonic Testing (UT) of the same (3) areas. The QC utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4 during the examination of the splice weld repairs. The QC technician performed the required shear wave testing during the testing for weld soundness utilizing a .63 x .75 rectangular transducer. The UT examination was completed from face B during this shift and the QAI observed that the QC inspector had marked one rejectable indication on the steel. The indication was stated to be 120mm in length, 10mm deep and located at Y= 70mm. See photo of MT and UT indications below.

4). OBG Field Splice 4W/5W Weld ID: B1, Face B

The QAI periodically observed AB/F approved welding personnel Jin Pei Wang (ID 7299) performing grinding in the air carbon arc gouged groove in the B to prepare the inside groove for backwelding. The work at this location was completed during the QA Inspector's shift and the welder was waiting for QC to perform MT of the groove at the end of the QA Inspectors shift.

5). OBG Field Splice 4W/5W Weld ID: D1 & D2, Face B

The QAI periodically observed AB/F personnel performing grinding to prepare the outside groove for back welding. The work at this location was completed during the QA Inspector's shift.



Summary of Conversations:

None of relevance.

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 Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

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Inspected By: Madison,Bert

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer