

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017697**Date Inspected:** 01-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**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 Welding of East Line Lifting Rod Access Penetration Insert (SMAW)
- 2). OBG Field Splice of Ventilation Access Insert Weld at 5E-PP29.5-E2-S – (SMAW)
- 3). OBG Field Splice 5W/6W Weld ID: D2, Face A – (SMAW R-1 Repair)
- 4). OBG Field Splice 7W/8W Weld ID: A3 Face A – (SMAW R-1 Repairs)

- 1). OBG Field Welding of East Line Lifting Rod Access Penetration Insert (SMAW)

Interior: OBG 2E-PP15-E3-welds 1, 3 & 4

The QAI periodically observed the welding per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position to restore the Lifting Rod Access Penetrations in the A deck at PP15. The QAI observed that AB/F approved welder Darcell Jackson (ID 9967) performed back grinding and subsequent back welding at PP15 weld E3-1, E3-3 & E3-4. QC Inspector John Pagliero was periodically 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-D1.5-1110B rev 1. The QAI periodically observed QC Inspector John Pagliero performing Magnetic Particle Testing (MT) of the back grind areas prior to back welding at these locations. 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. Welding was completed at these locations and the QAI observed that the work appeared to be in general compliance with contract documents.

Interior: OBG 2E-PP17-E3-welds 1 & 3 & E4-weld 1

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The QAI periodically observed the welding per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position to restore the Lifting Rod Access Penetrations in the A deck at PP17. The QAI observed that AB/F approved welder Eric Sparks (ID 3040) performed back grinding and subsequent back welding at PP17 welds E3-1 and E3-3 and E4-1. QC Inspector John Pagliero was periodically 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-D1.5-1110B rev 1. The QAI periodically observed QC Inspector John Pagliero performing Magnetic Particle Testing (MT) of the back grind areas prior to back welding at these locations. 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. Welding was completed at these locations and the QAI observed that the work appeared to be in general compliance with contract documents.

2). OBG Field Splice of Ventilation Access Insert Weld at 5E-PP29.5-E2-S – (SMAW)

The QAI periodically observed the welding per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position to restore the Ventilation Access Insert at 5E-PP29.5-E2-S. The QAI observed that AB/F approved welder Jin Pei Wang (ID 7299) performed back welding from the interior of the OBG (to serve as backing for the welding from the exterior of the OBG) at this location. QC Inspector John Pagliero was periodically 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-D1.5-1010 rev 1. Welding was in process at this location and the QAI observed that the work appeared to be in general compliance with contract documents.

3). OBG Field Splice 5W/6W Weld ID: D2, Face A – (SMAW R-1 Repairs)

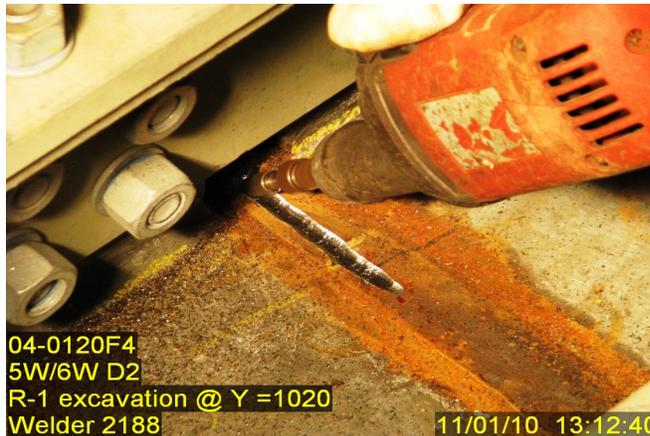
The QAI periodically observed AB/F approved welder Fred Kaddu (ID 2188) performing grinding to excavate one R-1 repair location (see photo below) and subsequently performing welding per the Shielded Metal Arc Welding (SMAW) process in the 1G (flat) position of OBG Field Splice 5W/6W Weld ID: D2. QC Inspector Jesse Cayabyab 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. QC Inspector Tony Sherwood performed Magnetic Particle Testing (MT) of the excavated area prior to the repair welding. 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 observed that Mr. Kaddu completed welding of (1) one excavation with the following dimensions at the following Y location: Weld D2 - Y = 1020mm, Length = 110mm, Width = 26mm and Depth = 13mm. The QAI observed that the welding at this location was completed and work at this location appeared to be in general compliance with contract documents.

4). OBG Field Splice 7W/8W Weld ID: A3 Face A – (SMAW R-1 Repairs)

The QAI periodically observed AB/F approved welder Fred Kaddu (ID 2188) performing welding per the Shielded Metal Arc Welding (SMAW) process in the 1G (flat) position of OBG Field Splice 7W/8W Weld ID: A3 at one R-1 Ultrasonic Testing (UT) rejectable area. See photo below. 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. This repair area located at Y = 635 was previously excavated on 10-28-10 and partially welded on that date but welding was halted on 10-29-10 due to inclement weather conditions. The QAI observed that the welding at this location was completed and work at this location appeared to be in general compliance with contract documents.

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Summary of Conversations:

Conversations on this date with Quality Control Inspectors were general in nature and pertained to locations of welding and QC activities.

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.

Inspected By: Madison,Bert

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer