

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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023441**Date Inspected:** 04-May-2011**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:	John Pagliero		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	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:**

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:

- 10E 11E E1 (Inside)
- 9W 10W C1 (outside)
- 10W 11W E1 (Inside)
- 9W 10W Longitudinal Stiffener #3 R1 VT, MT and UT
- 10W 11W Longitudinal Stiffeners # 1-6 VT, MT and UT
- 6W PP44 W4 1-4 VT, MT and UT
- 6W PP35 W4 VT, MT and UT
- 7E PP52 Lifting Lug Holes 1-4 (Inside) VT Request by QC
- 8W PP64 Lifting Lug Holes 1 & 3(Inside) VT Request by QC

- 10E 11E E1 (Inside)

The QA Inspector randomly observed ABF welding operators Song Tao Huang and Jin Quan Huang performing Flux Core Arc Welding w/gas (FCAW-G) operations on face E1 inside of the OBG. The QA Inspector observed the QC inspector Jesse Cayabyab as being present in order to monitor the progress and ensure the welding parameters were within the established WPS. The work progressed throughout the QA Inspector's shift. Upon completion the QA Inspector noted that the work appeared to be in general conformance with the contract

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documents.

2. 9W 10W C1 (outside)

The QA Inspector noted and periodically observed ABF welding operators Rory Hogan and Jeremy Dolman performing FCAW-G operations on face C outside of the OBG. The QA Inspector observed the QC inspector Jesse Cayabyab as being present in order to monitor the progress and ensure the welding parameters were within the established WPS. The work progressed throughout the QA Inspector's shift. The work is in progress and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

3. 10W 11W E1 (Inside)

The QA Inspector randomly observed ABF welder Jin Pei Wang performing FCAW-G operations on face E1 inside of the OBG. The QA Inspector observed the QC inspector Jesse Cayabyab as being present in order to monitor the progress and ensure the welding parameters were within the established WPS. The work progressed throughout the QA Inspector's shift. Upon completion the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

4. 9W 10W Longitudinal Stiffener #3 R1 VT, MT and UT

The QA Inspector performed a Magnetic Particle Test (MT) on LS #3 R1. The QA Inspector tested 10% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. . The QA Inspector noted that the work appeared to be free of defects and was found to be acceptable and in general conformance with the contract documents. Upon completion of the MT, the QA Inspector performed Ultrasonic Testing utilizing a G. E./Krautkramer USN 60. The QA Inspector also utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev. 4 during the examination. Upon completion of the testing, it was noted by the QA Inspector that no indications were present and the work was found to be acceptable.

5. 10W 11W Longitudinal Stiffeners # 1-6 VT, MT and UT

The QA Inspector performed a Magnetic Particle Test (MT) on LS's 1-6. The QA Inspector tested 10% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. . The QA Inspector noted that the work appeared to be free of defects and was found to be acceptable and in general conformance with the contract documents. Upon completion of the MT, the QA Inspector performed Ultrasonic Testing utilizing a G. E./Krautkramer USN 60. The QA Inspector also utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev. 4 during the examination. Upon completion of the testing, it was noted by the QA Inspector that no indications were present and the work was found to be acceptable.

6. 6W PP44 W4 1-4 VT, MT and UT

The QA Inspector performed a Magnetic Particle Test (MT) on the Lifting Lug Holes (LLH) located at PP44. The QA Inspector tested 10% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. . The QA Inspector noted that the work appeared to be free of defects and was found to be acceptable and in general conformance with the contract documents. Upon completion of the MT, the QA Inspector

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performed Ultrasonic Testing utilizing a G.E./Krautkramer USN 60. The QA Inspector also utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4 during the examination. Upon completion of the testing, it was noted by the QA Inspector that no indications were present and the work was found to be acceptable.

7. 6W PP35 W4 VT, MT and UT

The QA Inspector performed a Magnetic Particle Test (MT) on the LLH's at PP35. The QA Inspector tested 10% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. . The QA Inspector noted that the work appeared to be free of defects and was found to be acceptable and in general conformance with the contract documents. Upon completion of the MT, the QA Inspector performed Ultrasonic Testing utilizing a G.E./Krautkramer USN 60. The QA Inspector also utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4 during the examination. Upon completion of the testing, it was noted by the QA Inspector that no indications were present and the work was found to be acceptable.

8. 7E PP52 Lifting Lug Holes 1-4 (Inside) VT Request by QC

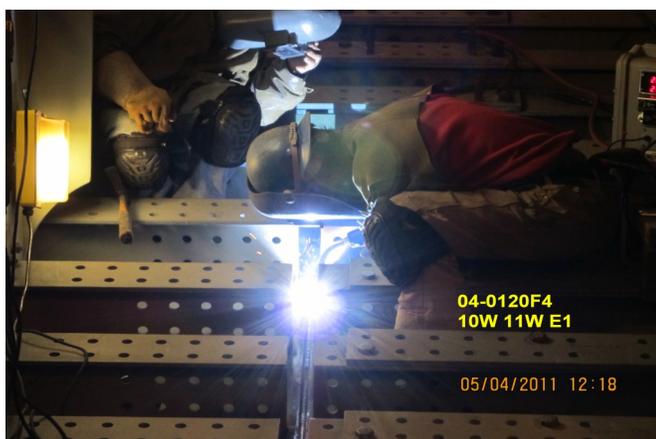
The QA Inspector was requested by QC Inspector Fred Von Hoff to perform a Visual Inspection on the LLH's located at PP52 on the inside of the OBG. The QA Inspector noted that no indications were present and the work was found to be acceptable and appears to be in general conformance with the contract documents.

9. 8W PP64 Lifting Lug Holes 1 & 3(Inside) VT Request by QC

The QA Inspector was requested by QC Inspector John Pagliero to perform a Visual Inspection on the LLH's located at PP64 on the inside of the OBG. The QA Inspector noted that no indications were present and the work was found to be acceptable and appears to be in general conformance with the contract documents.

Summary of Conversations:

As noted above



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 Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

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Inspected By:	Frey,Doug	Quality Assurance Inspector
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Reviewed By:	Levell,Bill	QA Reviewer
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