

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-023478**Date Inspected:** 10-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**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:**

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:

1. 9W PP76 W3 Lifting Lug Holes
2. 8W 9W A1 Field Splice R1
3. 2W PP13 Deck Access Hole Plate
4. 7W PP52 W4 Lifting Lug Holes #1, 2 and 4 VT, MT and UT
5. 7E PP56 E3 Lifting Lug Hole #4 VT, MT and UT
6. 7E PP55 E3 Lifting Lug Hole #1 VT, MT and UT
7. 9W 10W E1 and E2 VT, MT and UT

1. 9W PP76 W3 Lifting Lug Holes

The QA Inspector noted and periodically observed ABF welder Darcell Jackson performing Shielded Metal Arc Welding (SMAW) on the Lifting Lug Holes (LLH) at 9W PP76. The QA Inspector observed the QC inspector John Pagliero 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.

2. 8W 9W A1 Field Splice R1

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The QA Inspector observed the ABF Welder Jorge Lopez performing SMAW in the 1G flat position on the “A” deck field splice at 8W 9W A1 R1. The QA Inspector observed the QC Inspector John Pagliero 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 was completed on this date and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

3. 2W PP13 Deck Access Hole Plate

The QA Inspector periodically observed the ABF welder Fred Kaddu prepare the joint fit-up and installation of the Deck Access Hole Plate (DAH) at 2W PP13. Upon approval of the joint geometry the QC Inspector Bonafacio Baquinag, was observed 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 and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

4. 7W PP52 W4 Lifting Lug Holes #1, 2 and 4 VT, MT and UT

The QA Inspector performed a Magnetic Particle Test (MT) on LLH’s 1, 2 and 4 at 7W PP52 W4. 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. 7E PP56 E3 Lifting Lug Hole #4 VT, MT and UT

The QA Inspector performed a Magnetic Particle Test (MT) on LLH #4 at 7E PP56 E3. 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. 7E PP55 E3 Lifting Lug Hole #1 VT, MT and UT

The QA Inspector performed a Magnetic Particle Test (MT) on LLH # 1 at 7E PP55 E3. 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.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

7. 9W 10W E1 and E2 (Inside) VT, MT and UT

The QA Inspector performed a Magnetic Particle Test (MT) on the side plates E1 and E2. 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.

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.

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