

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-023644**Date Inspected:** 13-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:

1. 11E PP104 E6 Drip Rails
2. 10E 11E E1
3. 7W PP56 Lifting Lug Holes
4. 8E PP68 Lifting Lug Holes
5. 9W 10W D2 (Inside)
6. 10E 11E Longitudinal Stiffeners VT, MT and UT

1. 11E PP104 E6 Drip Rails

The QA Inspector noted and periodically observed ABF welder Gil Peralta performing Shielded Metal Arc Welding (SMAW) on the Drip Rail located at 11E PP102. The QA Inspector observed the QC inspector Fred Von Hoff as being present in order to monitor the progress and ensure the welding parameters were within the established WPS. 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.

2. 10E 11E E1

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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 the face E1 inside of the OBG. The QA Inspector observed the QC inspector Fred Von Hoff as being present in order to monitor the progress and ensure the welding parameters were within the established WPS. The QA Inspector noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

3. 7W PP56 Lifting Lug Holes

The QA Inspector periodically observed the ABF welder Mike Jiminez performing SMAW in the 4G overhead position on the Lifting Lug Holes (LLH) located at 7W PP56. The QA Inspector observed the QC inspector Fred Von Hoff as being present in order to monitor the progress and ensure the welding parameters were within the established WPS. The QA Inspector noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

4. 8E PP68 Lifting Lug Holes

The QA Inspector periodically observed the ABF welder Jason Collins performing SMAW in the 1G flat position on the LLH's located at 8E PP68. The QA Inspector observed the QC inspector Fred Von Hoff as being present in order to monitor the progress and ensure the welding parameters were within the established WPS. The QA Inspector noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

5. 9W 10W D2 R1 (Inside)

The QA Inspector noted the dimensions of the excavations as #2 y=3750 260mm's long, 30mm's wide and 17mm's deep. Excavation #3 y=4450 120mm's long, 20mm's wide and 17mm's deep. Upon approval of Magnetic Particle Testing by QC Inspector John Pagliero ABF welder Jorge Lopez performed SMAW on location #2. The QA Inspector observed the QC inspector monitor the progress and ensure the welding parameters were within the established WPS. The QA Inspector noted that the work was in process and appeared to be in general conformance with the contract documents.

6. 10E 11E Longitudinal Stiffeners VT, MT and UT

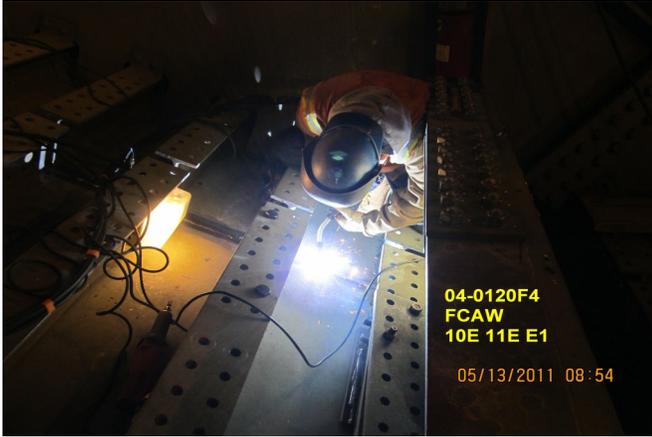
The QA Inspector performed a Magnetic Particle Test (MT) on the Longitudinal Stiffeners 1- 3 at 10E 11E. The QA Inspector tested 10% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. . The QA Inspector noted that the work appeared to be free of defects 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

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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

Reviewed By: Levell,Bill

QA Reviewer