

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-023908**Date Inspected:** 20-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. 8W PP68 W4 Lifting Lug Holes
2. 9W PP80 W3 Lifting Lug Holes
3. 9E 10E C2 (outside)
4. 8W 9W B6 Counterweight Attachment Plates
5. 8E PP68 E3 Lifting Lug Holes
6. 7W 8W A1 R2
7. 9W 10W C1 and C2 (inside) VT, MT and UT

1. 8W PP68 W4 Lifting Lug Holes

The QA Inspector periodically observed ABF welder Mike Jiminez performing Shielded Metal Arc Welding (SMAW) on the Lifting Lug Holes (LLH) located at 8W PP64 W4. The QA Inspector noted that upon completion, the welder began welding the LLH's located at 8W PP68 W4. The QA Inspector observed the QC John Pagliero as being present in order to monitor the progress and ensure the welding parameters were within the established WPS.

The work is in progress and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

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2. 9W PP80 W3 Lifting Lug Holes

The QA Inspector randomly observed the ABF welder Darcel Jackson performing SMAW in the 1G position on the LLH's located at 9W PP80 W3. The QA Inspector noted that the QC Inspector identified as John Pagliero was present in order to monitor the progress and ensure the welding parameters were within the established WPS. The work is in progress and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

3. 9E 10E C2 (outside)

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 C2 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 QA Inspector noted that the work was in progress and appeared to be in general conformance with the contract documents.

4. 8W 9W B6 Counterweight Attachment Plates

The QA Inspector noted and periodically observed ABF welder Gil Perlata perform SMAW on the Counterweight Attachment Plates at 8W 9W B6. 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 completed on this date and appeared to be in general conformance with the contract documents.

5. 8E PP68 E3 Lifting Lug Holes

The QA Inspector randomly observed the ABF welder Jason Collins performing SMAW in the 1G position on the LLH's located at 8E PP68 E3. The QA Inspector noted that the QC Inspector identified as John Pagliero was present in order to monitor the progress and ensure the welding parameters were within the established WPS. The work is in progress and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

6. 7W 8W A1 R2

The QA Inspector noted the dimensions of the excavation by ABF welder Jorge Lopez to be 100mm's long, 25mm's wide and 11mm's deep. The QA Inspector observed the QC Inspector Jesse Cayabyab perform Magnetic Particle Testing to verify the excavation as being free of indications. Upon approval of the MT testing, the welder began SMAW in the 1G position. The QA Inspector observed the QC inspector Jesse Cayabyab 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.

7. 9W 10W C1 and C2 (inside) VT, MT and UT

The QA Inspector performed a Magnetic Particle Test (MT) on the Side Plate welds at 9W 10W C1 and C2. The

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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

Reviewed By: Levell,Bill

QA Reviewer