

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-024081**Date Inspected:** 01-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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 PP80 W3 Lifting Lug Holes #1-4 VT, MT and UT
2. 10E 11E E2 Diagonal Plate Splice (Inside)
3. 9E PP76 E3 Lifting Lug Holes #2 & 4
4. 9W 10W W1 Drip Rails/Counterweight connections
5. 7W PP59 B Plate Retrofit

1. 9W PP79 W3 Lifting Lug Holes #1-4 VT, MT and UT

The QA Inspector performed a Magnetic Particle Test (MT) on Lifting Lug Holes (LLH) 1- 4 at 9W PP80 W3. 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.

2. 10E 11E E2 Diagonal Plate Splice (Inside)

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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 in the 3G vertical position on face E2 inside of the OBG. The QA Inspector observed the QC Inspector John Pagliero as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3042B-1. 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.

3. 9E PP76 E3 Lifting Lug Holes #2 & 4

The QA Inspector made periodic observations of ABF welder Jorge Lopez performing Shielded Metal Arc Welding (SMAW) in the 1G flat position on the LLH's #2 and #4 located at 9E PP76 E3. 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 in compliance pertaining to ABF-WPS-D15-1050A-CU. Upon completion of the work the QC Inspector performed a Visual Inspection of the weld. The QA Inspector verified the testing and found the work to be acceptable and in general conformance with the contract documents.

4. 9W 10W PP85 W1 Drip Rails/Counterweight Connections

The QA Inspector randomly observed ABF welder Rick Clayborn performing SMAW in the 2G horizontal position on Drip Rails and Counterweight connections at 9W 10W PP85 W1. The QA Inspector observed the QC Inspector John Pagliero as being present in order to monitor the progress and ensure the welding parameters were in compliance with ABF-WPS-D15-F1200A for the Drip Rails and ABF-WPS-D15 1110A Rev 1 for the Counterweight Connections. Upon completion the QC Inspector performed a Visual and Magnetic Particle test. The QA Inspector verified the testing and found the work to be free of indications and acceptable. The QA Inspector noted that the work appeared to be in general conformance with the contract documents.

5. 7W PP59 B Plate Retrofit

The QA Inspector randomly observed ABF welder Darcel Jackson performing SMAW in the 4G overhead position of 10mm plate washers for the B Plate Retrofit at the following locations; PP59.25, PP57, PP54, PP66.25, PP64.75, and PP56.75. The QA Inspector observed the QC Inspector John Pagliero as being present in order to monitor the progress and ensure the welding parameters were in compliance with ABF-WPS-D15-F1200A and ABF-RFI-001985R01. Upon completion of each plate the QC Inspector performed a Visual and Magnetic Particle test. The QA Inspector verified the testing and found the work to be free of indications and acceptable. The QA Inspector noted that the work appeared to be in general conformance with the contract documents.

Summary of Conversations:

At the beginning the shift the QA Inspector met with QC Inspector John Pagliero and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing. As pertaining to a discussion with Bill Level, it was brought to the QA Inspector's attention that the QA Inspector had inadvertently recorded the shift ending time as 1530 instead of 1730 on the following dates; 4/21, 5/2, 5/3, 5/4, 5/5, 5/16, 5/18, 5/19, and 5/31.

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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