

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-025370**Date Inspected:** 28-Jul-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:** William Sherwood**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:

- 10E 11E D1/D2 (Interior)
- 11E 12E B/F (Interior)
- 11E 12E C (Exterior)

- 10E 11E D1/D2 (Interior)

The QA inspector performed a Magnetic Particle Test (MT) on D1 and D2 at 10E 11E on the interior of the OBG. The QA inspector tested 10% of the welds to verify the weld and testing by QC meet the requirements of the contract documents. For results and locations refer to attached TL-6028 generated on this date. Upon completion of the MT, the QA inspector performed Ultrasonic Testing (UT) utilizing a G.E./Krautkramer USN 60. The QA inspector utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4 during the examination. For results and locations refer to attached TL-6028 generated on this date.

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2. 11E 12E (Interior)

The QA inspector performed a Magnetic Particle Test (MT) on B and F to include the transitions from A deck at 11E 12E on the interior of the OBG. The QA inspector tested 10% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. For results and locations refer to attached TL-6028 generated on this date. Upon completion of the MT, the QA inspector performed Ultrasonic Testing (UT) utilizing a G.E./Krautkramer USN 60. The QA inspector utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev. 4 during the examination. For results and locations refer to attached TL-6027 generated on this date.

3. 11E 12E C (Exterior)

The QA inspector randomly observed ABF welder Fred Kaddu ID#2188 utilizing the Plasma Arc Cutting (PAC) method to remove the backing bar from the exterior face of side plate C at 11E 12E. The work progressed throughout the shift and 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 William Sherwood and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.



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
