

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-026162**Date Inspected:** 23-Aug-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:** Job Site**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:** OBG Components**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford 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:

Approximately 8:00 this QA observed QC William Sherwood performing Magnetic Particle Testing (MT) of weld repair areas completed previously on 08-19-11. ABF/JV qualified welder Wai Kit Li #2953 utilized Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1000-R. . The joint was welded in the 3G vertical position at the side plate C1/C2 on the inside of the OBG 11E/12E.

Mr. Sherwood recorded no rejectable indications at this time.

Locations tested are:

C2 – Y=3910, D=13, W=22, L=110

C1 – Y=4250, D=13, W=20, L=90

C1 – Y=4420, D=11, W=21, L=185

Approximately 9:00 this QA observed QC Fred Vonhoff performing Magnetic Particle Testing (MT) of weld repair areas completed previously on 08-19-11. ABF/JV qualified welder Mike Jiminez #4671 utilized Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A-R1. The joint welded was a 14mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at E4-PP77-L#1~4 and was performed in the overhead position from the bottom side of the "A" deck.

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Mr. Vonhoff recorded no rejectable indications at this time.

13:00 this QA observed QC William Sherwood performing Magnetic Particle Testing (MT) of approximately 6048mm of base material at an area of drip rail removal. Mr. Sherwood recorded three rejectable indications.

Locations are recorded from panel point 10 and in millimeters:

Y= -2400, L=30

Y= -1486, L=30

Y= -913, L=28

After light grinding, indication “-1486” was no longer observable visually or through MT testing.

Indication “-2400” was excavated to a 2mm depth and was no longer observable visually or through MT testing.

Indication “-913” was excavated to a 3mm depth and was no longer observable visually or through MT testing.

Magnetic Particle Testing

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 25% of the area previously tested by QC Magnetic Particle technicians. The joint welded was a 14mm plate insert at the “A” deck to close the lifting lug deck penetration holes. This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

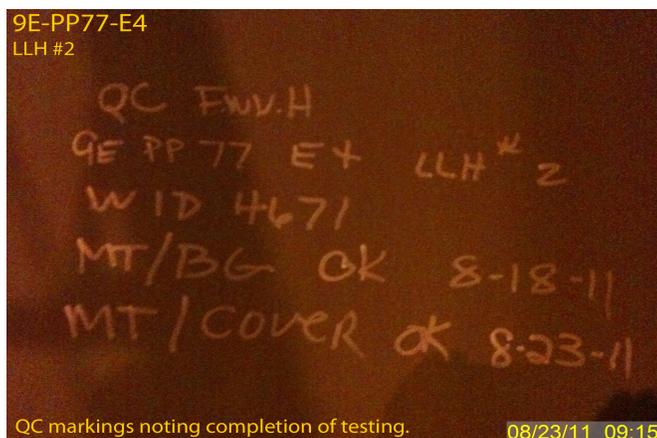
Locations of welds:

-9E, pp80, LLH #1~4, E4, external

-9E, pp79, LLH #1~4, E4, external

-9E, pp77, LLH #1~4, E4, external

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant components.

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 SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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Inspected By:	Clifford, William	Quality Assurance Inspector
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Reviewed By:	Levell, Bill	QA Reviewer
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