DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026267
Date Inspected: 13-Sep-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Jobsite

CWI Name:	As noted below			**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. 5W PP35.2 Pipe Welding (Exterior)
2. 5W PP37.2 Pipe Welding (Exterior)
3. 9W PP79 W4 Lifting Lug Holes #2 and 4 (Interior)
4. 9W PP77 W4 Lifting Lug Holes (Exterior)
5. 10W PP88 W3 Lifting Lug Holes (Exterior)

1. 5W PP35.2 Pipe Welding (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing Shielded Metal Arc Welding (SMAW) in the 1G flat and 3G vertical positions on 2.5 and 4 inch schedule 80 pipe located at 5W PP835.2 weld #19/2.5/35/SW and weld #19/4/35/SW. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed implementing 6010 electrodes in the root pass with the balance using 7018 electrodes. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general conformance with the contract documents.

2. 5W PP37.2 Pipe Welding (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing Shielded Metal Arc Welding (SMAW) in the 1G flat and 3G vertical positions on 2.5 and 4 inch schedule 80 pipe located at 5W PP837.2 weld #20/2.5/37/SW and weld #20/4/37/SW. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed implementing 6010 electrodes in the root pass with the balance using 7018 electrodes. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general conformance with the contract documents.

3. 9W PP79 W4 Lifting Lug Holes #2 and 4 (Interior)

The QA inspector observed ABF welder Mike Jimenez ID# 4671 performing Shielded Metal Arc Welding (SMAW) in the 4G overhead position on Lifting Lug Holes (LLH) #2 and 4 located at 9W PP79 W4. The QA inspector observed the QC inspector identified as Sal Moreno monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1110A Revision 1. The parameters were recorded as (Amperes=135). The QA inspector made subsequent observations throughout the shift to monitor quality and the QA inspector noted that the work appeared to be in general conformance with the contract documents.

4. 9W PP77 W4 Lifting Lug Holes (Exterior)

The QA Inspector performed a Magnetic Particle Test (MT) on Lifting Lug Holes #1-4 at 9W PP77 W4 on the exterior of the OBG. The QA Inspector utilized the MT procedure SE-MT-D1.5-CT-100 Rev. 4 to test 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.

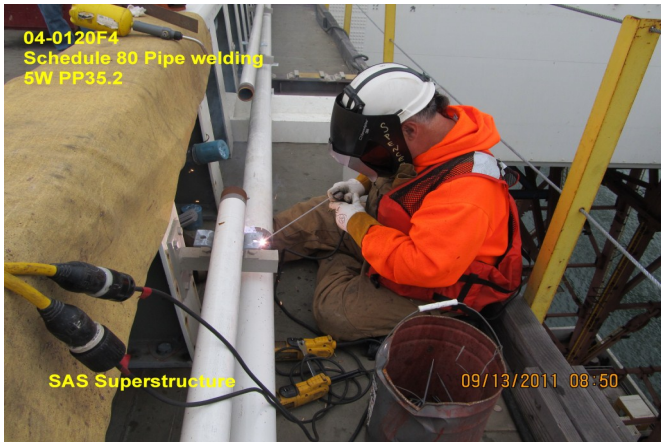
5. 10W PP88 W3 Lifting Lug Holes (Exterior)

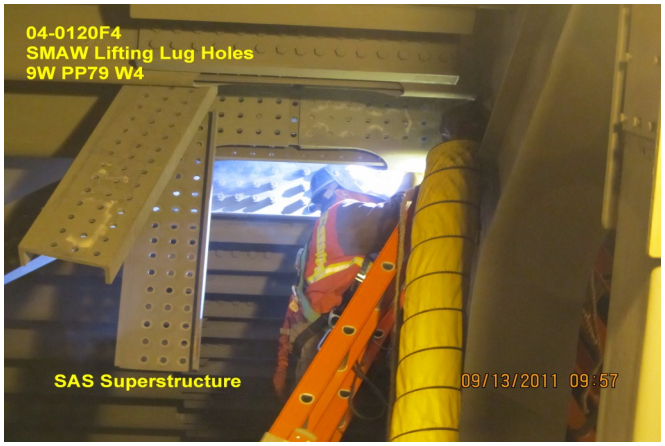
The QA Inspector performed a Magnetic Particle Test (MT) on Lifting Lug Holes #1-4 at 10W PP88 W3 on the exterior of the OBG. The QA Inspector utilized the MT procedure SE-MT-D1.5-CT-100 Rev. 4 to test 10% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. 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:

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