

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT**

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

Report No: WIR-026557
Date Inspected: 22-Oct-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
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A
Component: SAS OBG

Bridge No: 34-0006**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:

- 12W 13W Bottom Plate "D" (Exterior)
- 12W 13W Side Plate "E" (Exterior)
- 12W 13W Edge Plate "F" (Interior)

- 12W 13W Bottom Plate "D" (Exterior)

The QA inspector observed ABF welding personnel remove the induction heating blankets from the underside of bottom plate "D" on the exterior of the OBG. The QA inspector monitored the removal of temporary attachment blank nuts and visually examined the break in the welds for indications. Upon removal, the welds were ground smooth and flush with the parent steel and re-examined with no indications noted. The QA inspector observed ABF welding personnel removing sections of the backing bar and the QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

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2. 12W 13W Side Plate “E” (Exterior)

The QA inspector observed ABF welding personnel remove the induction heating blankets from the underside of side plate “E” on the exterior of the OBG. The QA inspector monitored the removal of temporary attachment blank nuts and visually examined the break in the welds for indications. Upon removal, the welds were ground smooth and flush with the parent steel and re-examined with no indications noted. The QA inspector observed ABF welder Rory Hogan ID#3186 utilizing Plasma Arc Cutting to remove sections of the backing bar and the QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

3. 12W 13W Edge Plate “F” (Interior)

The QA inspector observed The QC inspector identified as Jesse Cayabyab perform Magnetic Particle Inspection of the back gouged joint of edge plate “F” on the interior of the OBG. . The QA inspector verified that the proper procedure was utilized as well as correct technique. The testing found no indications and the QA inspector verified the findings and noted that the work appeared to be in general conformance to the contract requirements.

Note: The QAI reviewed the observations and inspection with QA Lead Inspector, Daniel Reyes, written in this report. No issues were noted by the QAI and the QA Lead Inspector concurs with the QA report.

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
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Reviewed By:	Levell,Bill	QA Reviewer
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