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-026739
Date Inspected: 21-Nov-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: 1730
Location: Job Site

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: OBG Component

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:

13W/14W "I" Plate

This QA observed, at random intervals, an ABF/JV qualified welder, Richard Garcia #5892, performing Flux Cored Arc Welding (FCAW) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3110-4. Welding was performed at the 25mm butt weld joint (B-U2a-GF) connecting Lift 13 and Lift 14 "I" side plates.

This weld is a Seismic Performance Critical Member (SPCM) member.

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters. Welding parameters were recorded as (A=221, V=23.5, T=150).

Approximately:

7:45 this QA observed QC Pat Swain perform Ultrasonic Testing (UT) of the completed weld at 14W-PP126. 7-W3.7. Mr. Swain recorded:

-four (4) indications that was within six (6) decibels of the rejectable criteria.

-ten (10) rejectable indications.

Please see QCUT report dated 11/21/11 for more information regarding these indications.

9:00 this QA observed QC Jesse Cayabyab perform Ultrasonic Testing (UT) of the completed weld at 13W/14W "A" deck plate (Y=300mm~1750mm). Mr. Cayabyab recorded:

WELDING INSPECTION REPORT

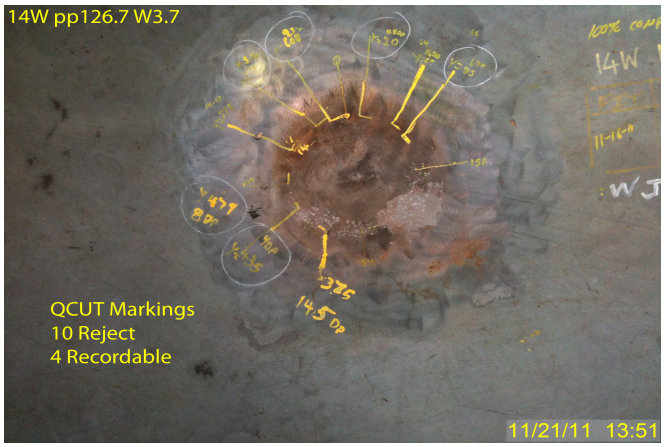
(Continued Page 2 of 2)

-one (1) indication that was within six (6) decibels of the rejectable criteria.
-one (1) rejectable indication.
Please see QCUT report dated 11/21/11 for more information regarding these indications.

This QA performed a visual survey of current status for SPCM 13W/14W splice connection welding. Please see attached graphic for current status.

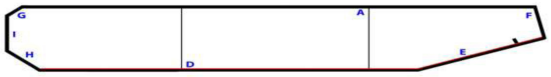
This QA verbally informed QA SPCM Lead, Daniel Reyes, of the issues noted in this report for compliance. For further details of issues of significance see QA SPCM Lead, Daniel Reyes, "Daily Inspection Report" (TL-6031) submitted for this date.

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



13W/14W Status

"A" plate	External welding completed. Back gouge / welding completed from approximately 300mm~1750mm.
"E" plate	Backing bar held in place with temporary attachments. Welding has not been initiated yet.
"F" plate	No backing bar in place. Not fit up at this time. No welding initiated.
"D" plate	Backing bar fit to external side. Welding completed from internal side at "D-1" and "D-2" locations.
"G" plate	No backing bar in place. Not fit up at this time. No welding intitated.
"H" plate	Backing bar fit to the external side. Internal welding comleted. Note: Bottom 150mm contains 8mm~10mm offset.
"I" plate	Backing bar fit to internal side. Welding inprocess from external side.



Summary of Conversations:
No relevant conversations.
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.

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