

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:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026817**Date Inspected:** 30-Nov-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:** 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:**

Note: The information contained in this report supersedes that of the report previously filed on the date of 11/30/11 and should be considered as a replacement.

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:

This QA performed exploratory / information only Magnetic Particle Testing (MT) and Ultrasonic Testing (UT) of Partial Joint Penetration welds at North and South ends of "West Jacking Frame". UT was performed to determine depth of penetration for verification of weld theoretical throat. 70 degree and 45 degree angles were used in first and second leg in this testing. Testing was performed under the observation of Structures Materials Representative (SMR) Kittrick Guest.

Measurements were recorded as:

-Two (2) 14mm PJP were scanned for a length measuring approximately 400mm per weld. The depth of penetration for these weld were found to range from 17mm ~ 24mm throughout.

-Three (3) 31mm PJP were scanned for a length measuring approximately 400mm per weld. The depth of penetration for these weld were found to range from 34mm ~ 39mm throughout.

Please contact SMR Guest for further information.

13W/14W "I" Plate

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

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=245, V=23.3, T=152).

Observation of QCUT:

QC Pat Swain performed Ultrasonic Testing (UT) of the completed weld at:

14E-PP125.7-E3.1 -no rejectable indications.

14W-PP128-W3-LLH#2 -no rejectable indications.

14W-PP128-W4-LLH#3 -no rejectable indications.

Please see QCUT reports dated 11/30/11 for more information regarding these indications.

Ultrasonic Testing

This QA performed Ultrasonic Testing (UT) on approximately 50% of the lifting lug hole welds at 14W-PP128-W3-LLH#1,2,4. These welds were previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3.

This QA observed no rejectable indications at the time of testing. This QA generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

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

This QA performed Ultrasonic Testing (UT) on approximately 50% of the lifting lug hole welds at 14W-PP128-W4-LLH#3,4. These welds were previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3.

This QA observed no rejectable indications at the time of testing. This QA generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

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

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.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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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