

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-027216**Date Inspected:** 09-Feb-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Salvador Merino**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**Summary of Items Observed:**

Quality Assurance Inspector (QA) Rene Hernandez 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 randomly observed:

West Line**Magnetic Particle Testing**

This QA inspector witnessed QC inspector Salvador Merino perform Magnetic Particle Testing (MT) on weld #3 at Panel Point 118.5, the back gouge and grind weld was inspected on the deck penetration hole for lifting lug cover plates. The QC inspector observed no rejectable indications at the time of testing. This work was located at 13W-PP118.5-W4-LLH#3 and was performed in the overhead position from the inside of the "A" deck plate.

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

This QA observed, at random intervals, ABF/JV qualified welder Mike Jimenez #4671 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1050A-CU. This was a Complete Joint Penetration (CJP) weld on a 20mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at 13W-PP122.5-W4-LLH-2 was performed in the flat position from the inside of the "A" deck plate.

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During welding, ABF Quality Control (QC) Salvador Merino was noted monitoring the welding parameters. Welding parameters were recorded.

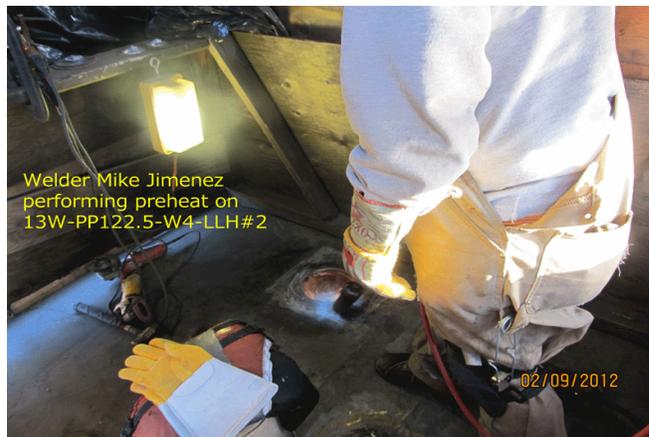
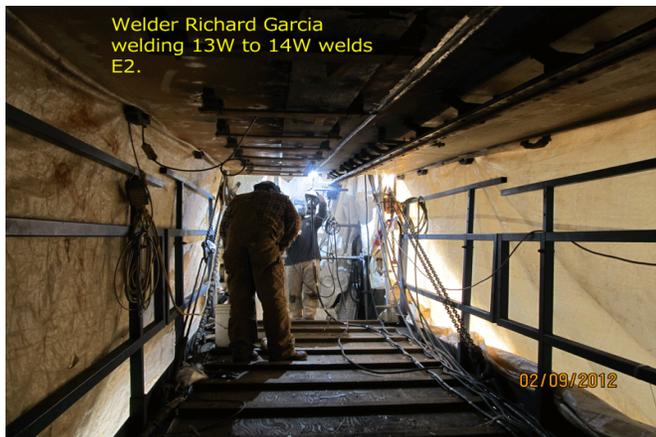
This QA observed, at random intervals, ABF/JV qualified welder Eric Sparks #3040 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1050A-CU. This was a Complete Joint Penetration (CJP) weld on a 20mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at 13W PP118.5 W4 3 and was performed in the overhead position from the inside of the "A" deck plate.

This QA observed, at random intervals, ABF/JV qualified welder Richard Garcia # performing Flux Cored Arc Welding (FCAW) with .072" diameter ESAB Dual Shield E71T-1M electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-2160-1-4G. This was a Complete Joint Penetration (PJP) weld connecting 13W to 14W side plate to side plate CJP weld E1 and E2. This work was located at West line connection joint 13W to 14W.

During welding, ABF Quality Control (QC) Salvador Merino was noted monitoring the welding parameters. Welding parameters were recorded as (Voltage 24.3V / Amperage 235A).

During welding, ABF Quality Control (QC) Salvador Merino was noted monitoring the welding parameters. Welding parameters were recorded.

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



Summary of Conversations:

Pertinent conversations are in the body of this report

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.

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Inspected By: Hernandez,Rene

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer