

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-027219**Date Inspected:** 13-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

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 PP118.5 W3 4 was performed in the flat position from the inside of the "A" deck plate. Hole number 2 is being fit-up for welding at this time.

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

Welding parameters were recorded. Also verified that CU backup strip was secured from top and under deck.

Magnetic Particle Testing

This QA inspector witnessed QC inspector Salvador Merino perform Magnetic Particle Testing (MT) on weld #A4 at 12W to 13W top deck.. The QC inspector observed no rejectable indications at the time of testing. This work was located at 1800mm to 5500 mm.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Ultrasonic Testing

This QA inspector witnessed QC inspector Harry Scharein perform Ultrasonic Testing (UT) on weld #A4 at 12W to 13 W top deck splice. The QC inspector observed no rejectable indications at the time of testing. This work was located at +1800mm to 5500mm.

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

This QA inspector observed fit-up of deck closure plate at access hole located at 9W/10W opposite side of barrier rails near counterweight side. Fit-up performed by Jason Collins (welder id #8128) per WPS ABF-WPS-D15-3010-1.

This QA inspector observed welder Rich Garcia performing air arc gouging at 13W/14W at weld #A3 on the backside of weld. Welder is removing backup strip and is back gouging and preparing root for back welding. Work is in progress at this time and further inspection verification is required.



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.

Inspected By: Hernandez,Rene

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer