

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-027245
Date Inspected: 27-Feb-2012

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: Jobsite

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:	SAS OBG		

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:

FW Spencer Pipe Welding (Exterior)

This QA Inspector observed F.W. Spencer welder Damian LLanos ID# (6645) performing SMAW in all positions on schedule 80, 4" domestic water pipe and 2.5" compressed air pipe outlets at the locations listed below. This QA Inspector verified the fit up of the joints and found it to be satisfactory and randomly observed QC Inspector Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed utilizing 6010 electrodes in the root pass with the balance using 7018 electrodes and cleaning the weld after each pass utilizing a wire wheel on a small disc grinder. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general conformance with the contract documents.

1/DW1/72/NW, 1/CA2/72/NW
1/DW1/74/NW, 1/CA2/74/NW
1/DW1/76/NW, 1/CA2/76/NW

QC NDT (Exterior)

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This QA Inspector randomly observed ABF Quality Control Inspector Mr. John Pagliero performing Ultrasonic Testing (UT) inspection on the locations listed below. This QA Inspector observed that Mr. Pagliero detected rejectable indications and were recorded with their respective location. The deck at this location is 20mm thick and is a Seismic Performance Critical Member (SPCM).

13W PP119.5 W4 #2-y+0; 40mm's in length, 13mm's deep at +9db's.

13W PP121.5 W4 #1-y+340; 20mm's in length, 16mm's deep at +10db's, y+430; 30mm's in length, 15mm's deep at +8db's.

#4-y+335; 30mm's in length, 14mm's deep at +7db's, y+430; 40mm's in length, 17mm's deep at +11db's.

13W PP122.5 W4 #1-y+345; 40mm's in length, 4mm's deep at +7db's, #2-y+0; 15mm's in length, 14mm's deep at +8db's, y+70; 20mm's in length, 8mm's deep at +9 db's.

QA NDT (Interior)

This QA Inspector performed a Magnetic Particle (MT) Inspection on the locations listed below. This QA Inspector performed the yoke method in conformance with ASTM E 709 and the standard of acceptance with D1.5 section 6.26. This QA Inspector noted that no rejectable indications were found at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work at this location appeared to be in general conformance with the contract specifications.

13W PP118.5 W4 Lifting Lug Holes #1-4

13W PP119.5 W4 Lifting Lug Holes #1-4

13W PP121.5 W4 Lifting Lug Holes #2 and 3

13W/14W Longitudinal Stiffeners #4, 5, 6 (Interior)

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of the welds at the locations listed below. 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.

13W PP119.5 W4 Lifting Lug Holes #1 and 3

13W PP121.5 W4 Lifting Lug Holes #2 and 3

13W/14W Longitudinal Stiffeners #4, 5, 6 (Interior)

5W PP29 W2 Deck Access Hole (Interior)

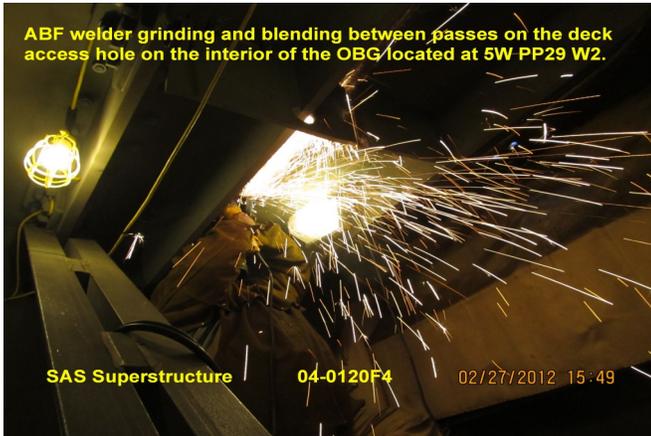
This QA Inspector randomly observed ABF welder Jason Collins perform back-gouge operations on face "B" of the deck access hole on the interior of the OBG. This QA Inspector observed QC Inspector Sal Merino perform MT testing to ensure the soundness of the metal. This QA Inspector randomly observed the welder perform SMAW in the (4G) overhead position with the QC Inspector monitoring the welding to insure the parameters were in accordance with ABF-WPS-D15-1110A-Revision 1. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appeared to be in general accordance with the contract documents.

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Summary of Conversations:

The were no pertinent conversations to 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: Frey,Doug

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer