

**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-027603**Date Inspected:** 14-May-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

<b>CWI Name:</b>	As noted below		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Component:</b>	SAS OBG		

**Bridge No:** 34-0006**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:

## 12W PP109.5 W5-TS (Interior)

This QA Inspector randomly observed QC Inspector Sal Merino perform Magnetic Particle Testing (MT) on the four (4) vertical welds of the Transverse Stiffener (TS) of the Deck Access Hole (DAH) located at 12W PP109.5 W5 on the interior of the OBG. The Inspector was observed performing the yoke method and found the work to be free of indications. This QA inspector performed MT testing utilizing 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.

## 11E PP104/106 E1- Suspender Bracket Modifications

This QA Inspector randomly observed QC Inspector Sal Merino perform MT on two (2) overhead welds, two (2) vertical welds and two (2) horizontal welds of the Suspender Bracket Plates on the East and West sides of the Suspenders located at 11E PP104 and PP106 on the exterior of the OBG. It was noted that the QC Inspector found no relevant indications. This QA inspector performed MT testing utilizing 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

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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.

### 8W PP61.5 W2-DAH (Exterior)

This QA Inspector made random observations of the in progress excavation operations of six (6) Ultrasonic (UT) rejectable indications on the DAH located at 8W PP61.5 W2 on the exterior of the OBG. QC Inspector Sal Merino performed MT testing on the completed excavations to verify soundness of the metal. It was noted that the QC found no indications and measured the dimensions of the sites as follows:

1. y+560mm: 125mm in length, 20mm wide and 13mm deep.
2. y+1855mm: 105mm in length, 25mm wide and 12mm deep.
3. y+1865mm: 110mm in length, 35mm wide and 15mm deep.
4. y+2440mm: 180mm in length, 20mm wide and 13mm deep.
5. y+2875mm: 110mm in length, 25mm wide and 13mm deep.
6. y+3365mm: 3500mm in length, 20mm wide and 13mm deep.

This QA Inspector made random observations of ABF welder Todd Jackson (ID 4639) performing the Shielded Metal Arc Welding (SMAW) Process in the 1G flat position on the DAH located at 8W PP61.5 W2 on the exterior of the OBG. The welder was observed pre-heating the joint prior to welding with QC Inspector Sal Merino present to verify the temperature and parameters for the work as they pertain to ABF-WPS-D1.5-1001-Repair. On a subsequent observation the welder was observed cleaning the start/stop edges of the work utilizing a small disc grinder and compressed air. The QC Inspector was present and measured the amperage as 122 with 3.2mm E7018-H4R electrodes. This QA Inspector noted that the work was in progress and appeared to be in general conformance with the contract documents.

### 11W PP104 W1- Suspender Bracket Modifications

This QA Inspector made random observations of ABF welder Eric Sparks (ID 3040) performing SMAW utilizing E7018-H4R electrodes on the modification plates for the suspender brackets at 11E PP104. The work required a 12mm fillet in the 4F and 2F position with a 22mm fillet in the 3F vertical positions. QC Inspector William Sherwood was present to monitor the welding and the parameters as they pertained to ABF-WPS-D1.5-F1200A. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work at this location had been completed on this date and appeared to be in general conformance with the contract documents.

### **Summary of Conversations:**

There were no pertinent conversations today.

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## 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:** Frey,Doug

Quality Assurance Inspector

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**Reviewed By:** Levell,Bill

QA Reviewer