

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-027606**Date Inspected:** 12-May-2012**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
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: 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:

13E-E2.8 @ y+11970mm (Interior)

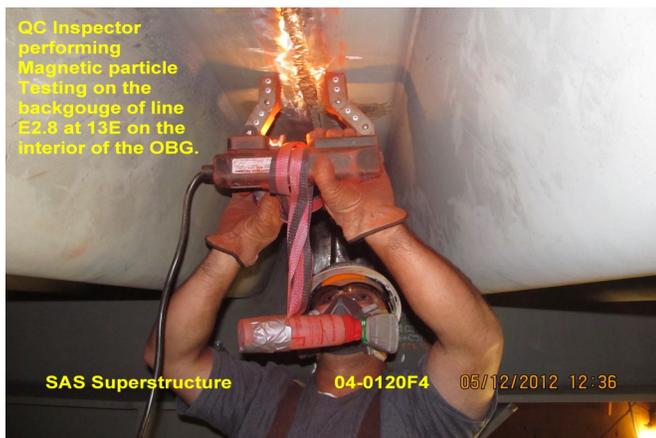
This QA Inspector observed the back-gouging operations at 13E-E2.8 @ y+100mm to y+11970mm on the interior of the OBG. ABF welding personnel utilized small disc grinders and rotary drills with steel shaving bits to remove metal from the root side of the joint. QC Inspector Sal Merino performed Magnetic Particle Testing (MT) on approximately 1000mm sections of completed areas by ABF welding personnel to ensure soundness of the metal. Upon completion of the testing, several indications were noted of varying lengths and locations. ABF welding personnel were assigned to remove the indications noted by the testing, by use of grinding until the indications were removed and verified sound by re-testing with the MT method. This process repeated itself throughout the entire length of the joint due to the observance of multiple indications with each test. On several occasions areas had to be re-tested two and three times. Upon successful testing and acceptance by QC, 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. This QA Inspector noted that the work is ongoing.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Summary of Conversations:

This QA Inspector had conversation with QA Lead Inspector Daniel Reyes about concerns regarding the back-gouging of the East Drop-In Panels.



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
