

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-027734
Date Inspected: 07-Jun-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: Job site

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:	OBG/Tower	

Summary of Items Observed:

Quality Assurance Inspector (QA) Rodney Patterson 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:

Tower (ESW Weld Repairs)

This QA observed, at random intervals, ABF/JV qualified welder Wai Kit Lai #2953 performing Flux Core Arc Welding (FCAW) implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3000-3Repair.

The joint being welded was tower shear plate designated as ESW weld, location "E" from face B. Dimensions excavated for this repair were: (Y=6645mm~7640mm, Width 45mm, Depth 38mm) During welding, ABF Quality Control (QC) Ted Ilo was noted monitoring the welding parameters. Welding parameters were recorded as (A=227, V=22.5).

This QA observed, at random intervals, ABF/JV qualified welder Wan Xiao Jian #9677 performing Flux Core Arc Welding (FCAW) implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3000-3Repair.

The joint being welded was tower shear plate designated as ESW weld, location "E" from face A. Dimensions excavated for this repair were: (Y=8240mm~8770mm, Width 55mm, Depth 40mm) During welding, ABF Quality Control (QC) Ted Ilo was noted monitoring the welding parameters. Welding parameters were recorded as (A=230, V=22.7).

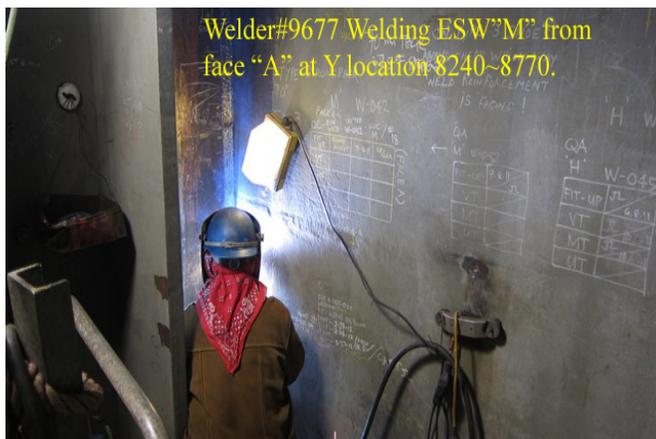
WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA observed at random intervals, ABF/JV personnel performing final grinding of the weld cap to a bright clean finish. The joint being welded was tower shear plate designated as ESW weld, location "P" from the external face at location Y=780mm~1480mm.

The QC inspector overseeing the work was Bernard Docena and was observed earlier documenting the time of completion due to a 48 hour hold time prior to final MT inspection required by the applicable repair procedure.

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



Summary of Conversations:

No relevant conversations.

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: Patterson,Rodney

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer