

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-027765**Date Inspected:** 12-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**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:

OBG 13E Deck Drop-in (Panel Point 122.5)

This QA observed ABF/JV welding personnel performing back gouging of weld 13E-PP122.5-E2.8-BW1. The weld is a Complete Joint Penetration (CJP) of the deck panel diaphragm web at panel point 122.5. The Quality Control (QC) Inspector Salvador Merino performed Magnetic Particle testing (MT) and visual confirmation of the excavation after it was ground to a bright finish. There were no indications observed to be present at the time of inspection.

The QA inspector observed ABF/JV qualified welder Eddie Brown #7889 performing Shielded Metal Arc Welding (SMAW) in the 3G position implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D1.5-1030. The joint being welded was the floor beam web splice at panel point 122.5 and is designated as 13E-PP122.5-E2.1-BW1. The groove surface and surrounding area was brought to temperature the use of a gas torch and the preheat temperature was confirmed by ABF personnel prior to welding. The Quality Control (QC) inspector Salvador Merino was noted monitoring the welding parameters at the beginning of the shift. The welding of this joint was noted to be completed prior to the end of the QA inspectors shift.

Ultrasonic Testing (OBG Deck Drop-in Lift 13 East)

This QA performed 100% Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) deck drop-in stiffener

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splice welds at lift 13E/14E. This weld was 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. The weld are designations are as follows

13E-PP120-TS1
13E-PP120.5-TS1,
13E-PP120.6-LS1
13E-PP121-E2.4-BW1

OBG 13E Deck Drop-in (Panel Point 123)

The QA inspector observed at random intervals ABF/JV qualified welder Richard Garcia #5892 performing Shielded Metal Arc Welding (SMAW) in the 1G position utilizing the Caltrans approved Welding Procedure Specification ABF-WPS-D1.5-1030. The weld is a Complete Joint Penetration splice between the horizontal floor beam flanges at panel point floor 123 and is designated as 13E-PP123-E2.1-BF2 beam repair surface and surrounding area was brought to temperature by the use of a gas torch and the preheat temperature was confirmed by ABF personnel prior to welding. The welding at this location was observed to be completed from face "A" prior to the end of the QA inspectors shift and will require further welding.

OBG 13E Deck Drop-in (Panel Point 123.5)

The QA inspector periodically observed ABF/JV qualified welder Khit Lounechaney #4985 performing Shielded Metal Arc Welding (SMAW) in the 2G position utilizing the Caltrans approved Welding Procedure Specification ABF-WPS-D1.5-1080. The weld is a Complete Joint Penetration splice between the horizontal and vertical floor beam flange at panel point 123.5 and is designated as 13E-PP123-E2.1-BF2. The weld surface and surrounding area was brought to temperature by the use of a gas torch and the preheat temperature was confirmed by ABF personnel prior to welding. The welding at this location was observed to be completed from face "A" prior to the end of the QA inspectors shift and will require further welding.

OBG 13E Deck Repairs

This QA observed ABF/JV welding personnel performing back gouging of weld 13E-E2.8. The weld is a Complete Joint Penetration (CJP) of the deck panel drop-in splice. The Quality Control (QC) Inspector William Sherwood was present on the topside of the deck monitoring the preheat temperature prior to gouging.

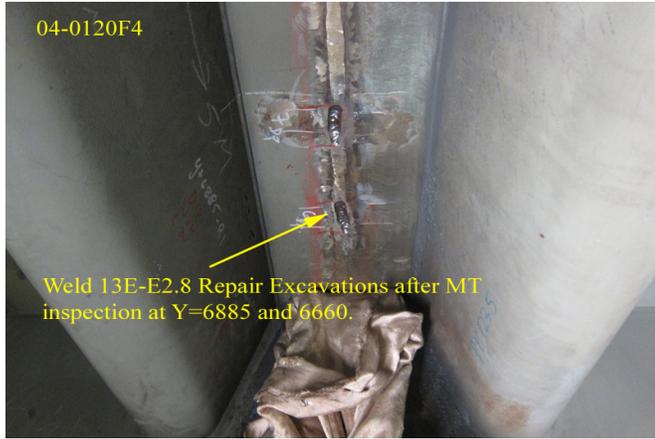
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

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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.

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
