

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-027772**Date Inspected:** 13-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 123.5)

This QA observed ABF/JV welding personnel performing back gouging of weld 13E-PP123.5-E2.1-BF2. The weld is a Complete Joint Penetration (CJP) of the vertical and horizontal floor beam flange. 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. Indications were found present in the weld, were ground out and re-inspected with (MT) until found acceptable.

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 floor beam flange 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 incomplete prior to the end of the QA inspectors shift.

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

The QA inspector observed at random intervals ABF/JV qualified welder Richard Garcia #5892 performing

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Shielded Metal Arc Welding (SMAW) in the 3G 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-BW1. 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 prior to the end of the QA inspectors shift.

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

The QA observed ABF QC personnel carry out “Preliminary Ultrasonic Testing” of the horizontal flange splice at panel point 122.5 designated as 13E-PP122.5-E2.1-BF1. The ABF welding personnel proceeded to excavate the weld joint from face “B”, and in the process gouged into the base metal of the vertical flange below. The weld is a Complete Joint Penetration (CJP) Single-V groove in the horizontal floor beam flange that utilizes the vertical flange as backing. (See attached weld detail). Prior to the end of the shift, ABF welding personnel proceeded to weld the excavation without the approval of the engineer. The QA inspector generated a TL-15 incident report on this date.

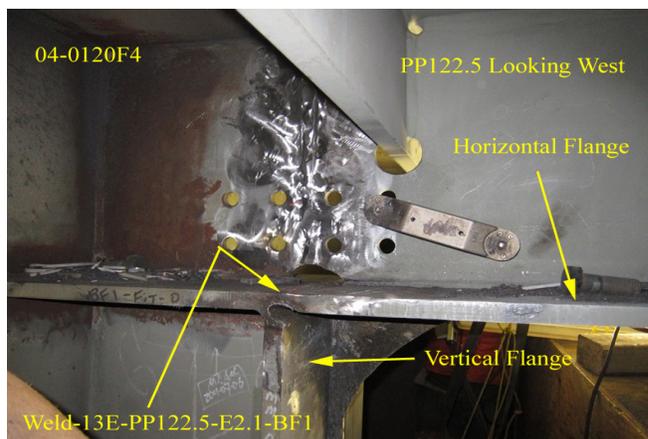
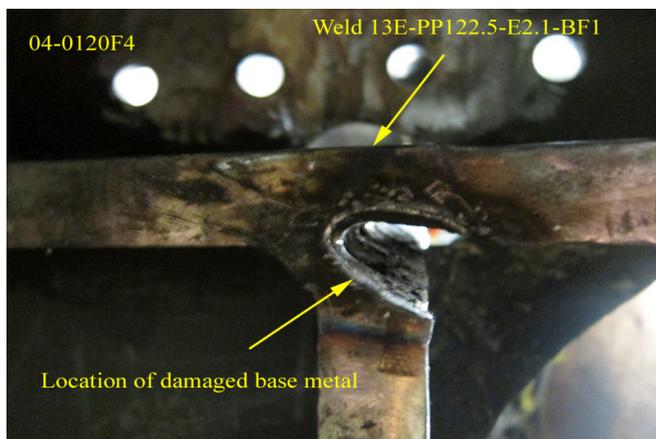
This QA observed ABF/JV welding personnel performing excavations of weld 13E-E2.8 previously rejected by ultrasonic testing (UT). The weld is a Complete Joint Penetration (CJP) butt joint of the OBG deck drop-in. The Quality Control (QC) Inspector William Sherwood performed Magnetic Particle testing (MT) and visual confirmation of the excavation after it was ground to a bright finish. No Indications were found present at the time of inspection.

This QA spent a portion of this reviewing and documenting the status and completion of various production welding tracking logs for lift 13E/14E drop-in deck work currently in-process. The QA recorded the information on the OBG tracking log.

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
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Reviewed By:	Levell,Bill	QA Reviewer
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