

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-028044**Date Inspected:** 24-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job site**CWI Name:** Salvador Merino**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**Summary of Items Observed:**

Quality Assurance Inspector (QAI) 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:

Ultrasonic Testing (OBG Deck)

This QA performed verification Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) deck drop-in splice welds for lift 13E/13W, and the personnel access plate to the deck at panel point 109.5 for lift 12E. The welds have been previously tested and accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QAI's findings are as follows;

Lift 12E Deck Access Hole (Weld No. DAH 12E PP109.5 E2 SW)

The QAI performed approximately 30% random verification in way of the weld radius and previous repairs. A total of one (1) rejectable indication was observed at Y=750. The indication was confirmed by ABF QC inspector John Pagliero during this shift.

Lift 13E Longitudinal Deck Drop-in Splice (Weld No. 13E-E2.2)

The QAI performed approximately 25% random verification from Y=3500~4800. A total of two (2) rejectable indications were observed at Y=4070 and Y4140.

Lift 13W Longitudinal Deck Drop-in Splice (Weld No. 13W W2.3 Y=2800~4400)

The QAI performed approximately 40% random verification from Y=2800~3500. A total of one (1) rejectable

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indication was observed at Y=2850.

Detailed information for the rejectable indications can be found on the TL-6027 submitted on this date.

OBG Deck (In-Process Inspection)

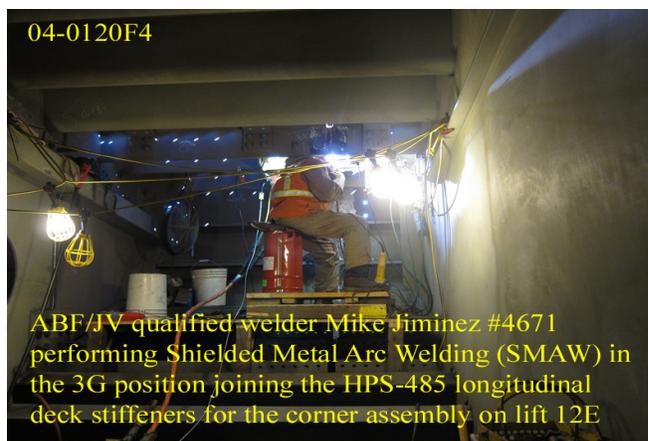
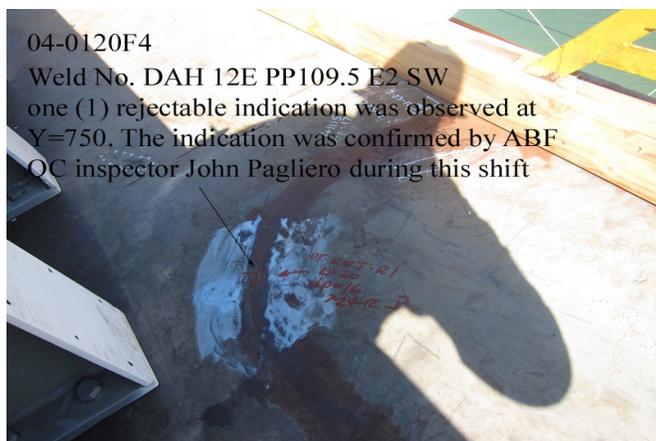
This QA inspector periodically observed ABF/JV qualified welder Mike Jiminez #4671 performing Shielded Metal Arc Welding (SMAW) in the 3G position implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D1.5-1012 Rev3. The weld is a Complete Joint Penetration (CJP) butt weld, joining the HPS-485 longitudinal deck stiffeners for the corner assembly on lift 12E. The weld is designated as 12E-PP111.1-LS2. The weld surface and surrounding area was brought to temperature the use of induction heaters and the preheat temperature was confirmed by ABF Quality Control (QC) prior to welding. The Quality Control (QC) inspector Salvador Merino was observed monitoring the welding parameters at the beginning of welding. The QAI spent a portion of this shift 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.

This QA inspector observed at random intervals ABF/JV qualified welder Richard Garcia #5892 performing Shielded Metal Arc Welding (SMAW) in the 2G position implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D1.5-1072. The weld is a Complete Joint Penetration (CJP) butt weld, joining the HPS-485 longitudinal deck stiffener to the K-plate. The weld surface and surrounding area was brought to temperature the use of induction heaters and the preheat temperature was confirmed by ABF Quality Control (QC) prior to welding. The Quality Control (QC) inspector Salvador Merino was observed monitoring the welding parameters at the beginning of the shift.

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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