

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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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-028048
Date Inspected: 25-Jul-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:	See 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	

Summary of Items Observed:

Quality Assurance Inspector (QA) Fritz Belford 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

This QA randomly observed ABF/JV qualified welder Jin Pei Wang #7299 performing Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1040C-CU. The joint being welded was E corner drop in designated as 12W-W2.1-C1, at Y location 26,000. Also observed was AB/F personnel Chris Bowles removing the backing bar from weld 12W-W2.1-C1 at Y location 12,000.

Welder Foreman James Zhen #6001 was observed performing the underside weld on deck weld 12W W2.1-A1 back gouge at Y location 23000. Welding was conducted using Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-3110-4 for Flux Core Arc Welding.

This QA was informed by QC William Sherwood of two 18mm transverse indications noted with Magnetic Particle Inspection (MT) at Y locations 15120 & 17560 while inspecting the back gouge of weld 12W W2.1-A1. QC William Sherwood conducted the Magnetic Particle Inspection (MT). Later on in the day QC William Sherwood presented to this QA inspector RWR #201207-034 for the repair of the two indications. I informed QC Sherwood that I would like to be present during excavation of the two indications.

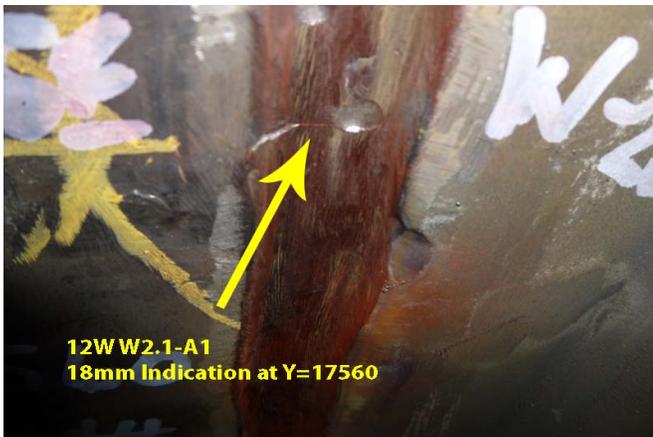
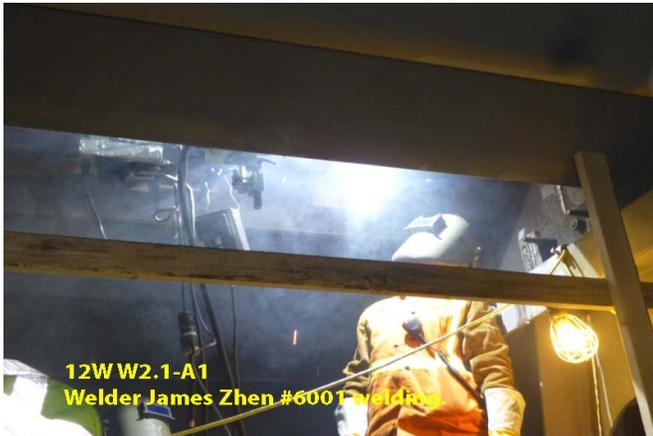
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Magnetic Particle Testing

This QA performed Magnetic Particle Testing (MT) on 3800mm (Over 10% of the weld length) of back gouge on weld 12W W2.1-A1 from face "B" at Y locations 25300 thru 23000 (2300mm) and 15500 thru 17000 (1500mm). The above areas were previously accepted by QC Magnetic Particle technicians. This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

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



Summary of Conversations:

Conversations relevant to work performed on this date.

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: Belford, Fritz

Quality Assurance Inspector

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Reviewed By: Levell,Bill

QA Reviewer