

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-028064**Date Inspected:** 27-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 web/flange connections for lift 13E. 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 13E Deck Drop-in flange Splice (Weld No. 13E-PP124.5-E2.2-BF1)

The QAI performed approximately 50% random verification from Y=0~150. No rejectable indications were observed at the time of inspection.

Lift 13E Deck Drop-in Web Splice (Weld No. 13E-PP121.5-E2.4-BW1)

The QAI performed approximately 50% random verification from Y=0~300. No rejectable indications were observed at the time of inspection.

Lift 13E Deck Drop-in Web Splice (Weld No. 13E-PP122-E2.1-BW1)

The QAI performed approximately 100% verification of this weld. No rejectable indications were observed at the time of inspection.

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Lift 13E Deck Drop-in Web Splice (Weld No. 13E-PP122.5-E2.1-BW1)

The QAI performed approximately 50% random verification from Y=0~300. No rejectable indications were observed at the time of inspection.

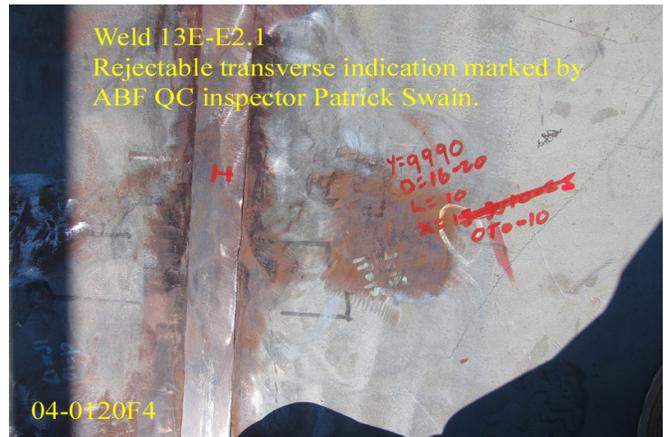
The QAI spent a portion of this shift reviewing and documenting the status and completion of various production welding tracking logs for lift 13E/14E drop-in deck work currently in-process. The QA recorded the information on the OBG tracking log.

The QAI observed at random intervals ABF QC inspectors, Jesse Cayabyab and Patrick Swain performing Ultrasonic Testing of the deck drop-in splice welds designated 13E-E2.1 and 13E-E2.8. The QC inspectors were observed to be utilizing scanning pattern D for the detection of transverse indications in the weld connection. Multiple areas on both splice welds were noted to have transverse indications present. The QAI performed random verification of the areas marked and confirmed the QC's findings.

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
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Reviewed By:	Levell,Bill	QA Reviewer
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