

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-028072**Date Inspected:** 30-Jul-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:** 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 observed authorized welder Jin Pei Wang (Welder ID #7299) welding on weld 12W 13W-A1.2 at location Y 1000 utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-3110-4 for Flux Core Arc Welding on the weld back gouge in the interior of 12W.

Welder Mike Jimenez #4671 was observed continuing on from the previous day with welding weld number 11W 12W LS3, utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D1.5-1012-3. ABF/JV personnel were observed continuing with grinding weld 12W W2.1-C1 flush on the external side of weld at Y location 25000.

Magnetic Particle Testing

This QA performed Magnetic Particle Testing (MT) on the following welds:

- 12W W2.1-A1 at:

o Y locations 3850, 7705 and 12650. These areas were noted with transverse indications as per QC Bonifacio Daquinag Jr. Transverse indications noted in areas 3850 and 12650. At Y location 7705 the indication had been removed as per Request for Weld Repair Approval or RWR #201207-34. Transverse indications in Y locations 3850 and 12650 had not been addressed at this time. At all the above locations, a 400mm area was Magnetic Particle Tested (MT) centered on the respective Y locations.

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- 12W 13W-B1:

o Weld was Magnetic Particle Inspected (MT) and one (1) 25mm indication was noted on the weld at Y location 0. Weld 12W 13W-B1 had been previously accepted by QC Magnetic Particle technicians. This QA observed one rejectable indication 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
Reviewed By:	Levell,Bill	QA Reviewer
