

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-028084**Date Inspected:** 02-Aug-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 the following welders welding in OBG 12W at various locations:

Authorized welders Jin Pei Wang #7299 was observed welding on weld 12W W2.1-A1 (4G) at Y location 10000 utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-3110-4 for Flux Core Arc Welding.

Authorized welder Mike Jimenez #4671 was observed continuing on from the previous day with welding weld number 12W PP111.1-LS1 (3G) on the deck longitudinal stiffener utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D1.5-1032-3.

Authorized welders Chris Bruce #8901 was observed welding on weld 12W W2.1 PP116-BW2 (3G) for panel point web complete joint penetration weld utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1030.

Authorized welders Chang Giu Chan #2312 was observed welding on weld 12W W2.1 PP116.5-BW1 (3G) utilizing Welding Procedure Specification's (WPS) ABF-WPS-D15-1030; and weld 12W W2.1 PP116.5-BW2 (3G) utilizing Welding Procedure Specification's (WPS) ABF-WPS-D15-1040-1. Welder Chang Giu Chen then moved on to weld 12W W2.1 PP117-BW2 utilizing Welding Procedure Specification's (WPS) ABF-WPS-D15-1040-1. All Welding Procedure Specification's (WPS) were approved by Caltrans.

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Also noted were QC Chris Conche and QC William Sherwood checking fit up for weld 12W W2.1 PP116-BW2 at Panel Point 116. This QA randomly observed QC Chris Conche performing Magnetic Particle Inspection (MT) on the back gouges for welds 12W W2.1 PP115.5-BW2 and 12W W2.1 PP116.5 BW1.

Magnetic Particle Testing

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

Weld 12W PP116- BW2:

- 590mm of weld back gouge. (100%, MT Accept.)

Weld 12W W2.1 116.5-BW1:

- 640mm of weld back gouge. (100%, MT Accept.)

Weld LS 12W/13W LS2:

- 100% 230mm of 230mm, MT Accept.

Weld LS 12W/13W LS3:

- 100% 270mm of 270mm, MT Accept.

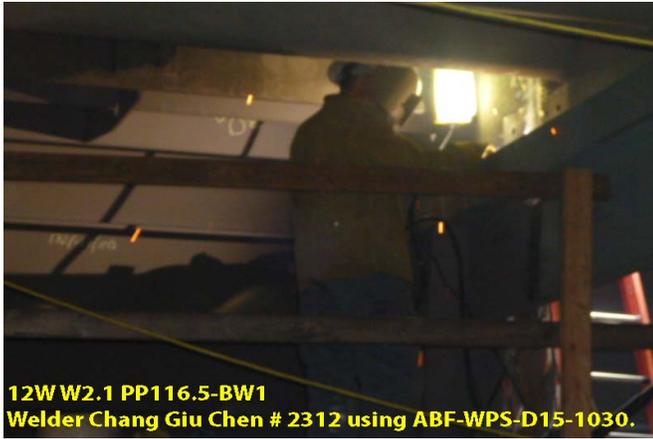
The above welds were previously accepted by QC Magnetic Particle technicians. This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

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



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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
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