

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-028091**Date Inspected:** 01-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:** Julian Razo**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:

Lift 14W In-Process Inspection

The QA inspector periodically observed ABF/JV qualified welder Lin Yun #9344 performing Shielded Metal Arc Welding (SMAW) in the 1G position utilizing the Caltrans approved Welding Procedure Specification ABF-WPS-D1.5-1030. The welding observed was for the longitudinal diaphragm stiffener splice at panel point 124.5 designated as 14W-PP124.65-A/B. The weld surface and surrounding area was brought to temperature by the use of a gas torch and the preheat temperature was confirmed ABF personnel prior to welding.

The QAI observed ABF/JV welding personnel backgouge the root of the stiffener during the shift. Welder Lin Yun was later observed welding the root in the 4G position.

The QA inspector observed at random intervals, ABF/JV qualified welder Xiao Hua Luo # 1291 performing Shielded Metal Arc Welding (SMAW) in the 4G position utilizing the Caltrans approved Welding Procedure Specification ABF-WPS-D1.5-1162-4. The welding observed was for the HPS-485 longitudinal stiffener wing plate attachment welds located between panel points 124.5 and 125 at LS1. The weld is a Partial Penetration Tee joint. The weld surface and surrounding area was brought to temperature by the use of induction heaters and the preheat temperature was confirmed ABF personnel prior to welding.

The QA inspector observed at random intervals ABF/JV qualified welder Richard Garcia #5892 performing

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Carbon Arc Gouging (CAG) in the overhead position for the repair of the deck drop-in splice between panel point 124~124.5 designated as 13W-W2.8. The weld surface and surrounding area was brought to temperature by the use of induction heaters prior to gouging. The weld is being re-gouged 100% to 10mm in depth from face B, due to the amount of indications found during the ABF QC final Ultrasonic Testing inspection. The repairs at this location are being conducted in accordance with RWR-201208-001.

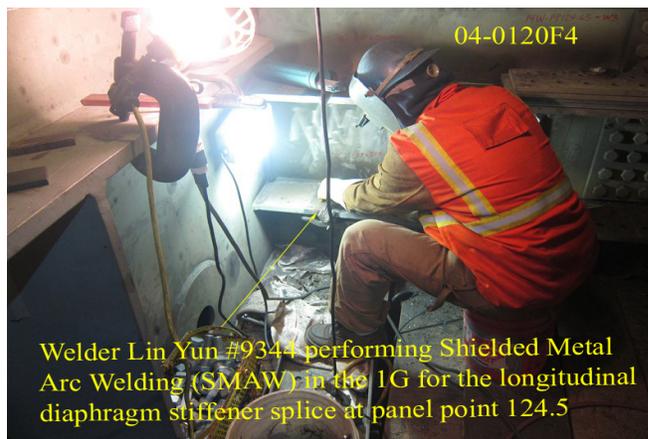
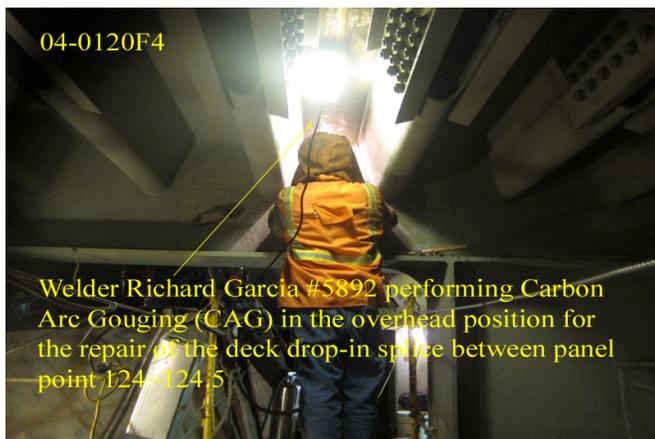
The QA inspector noted and periodically observed ABF/JV qualified welder Rick Clayborn #2773 performing Shielded Metal Arc Welding (SMAW) in the 4G position utilizing the Caltrans approved Welding Procedure Specification ABF-WPS-D1.5-1004-Repair. The welding is being performed for the repair of the deck drop-in splice between panel point 122~122.5 designated as 13W-W2.1. The weld surface and surrounding area was brought to temperature by the use of induction heaters prior to welding. The weld will be re-gouged in sections, throughout the entire length to 12mm in depth from face B, due to the amount of indications found during the ABF QC final Ultrasonic Testing inspection. The repairs at this location are being conducted in accordance with RWR-201207-016.

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.

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