

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-028122**Date Inspected:** 06-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:** 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:

The QA inspector observed at random intervals, ABF/JV qualified welder Chris Bowles #9317 performing Flux Cored Arc Welding (FCAW) in the 4G position utilizing the Caltrans approved Welding Procedure Specification ABF-WPS-D1.5-3110-4. The welding observed was for the lift 12 east corner assembly deck splice at panel point 111 designated as 12E-E2.1. The weld surface and surrounding area was brought to temperature by the use of an induction heater and the preheat temperature as well as welding parameters were confirmed by ABF QC Steve Jensen at the beginning of the shift.

This QA Inspector performed 15% verification Magnetic Particle Testing (MT) of the longitudinal diaphragm stiffener fillet connections designated as 13E-PP122.65-E3-RSA and 13E-PP122.65-E3-RSB, 13E-PP121.65-E3-RSA, 13E-PP121.65-E3-RSB, 13E-PP121.65-E3-RSC, 13E-PP121.65-E3-RSD, 13E-PP121.65-E3-A, and 13E-PP121.65-E3-B. This welds were previously accepted by QC Magnetic Particle technicians. The QAI 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.

The QAI observed ABF QC inspector, John Pagliero performing Ultrasonic Testing of the corner assembly drop-in side plate splice weld designated 12E-2.1-C1. The QC inspector was observed marking rejectable

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indications totaling approximately 70% of the weld between panel points 112.5 and 112. The QAI performed random verification of the areas marked and confirmed the QC's findings.

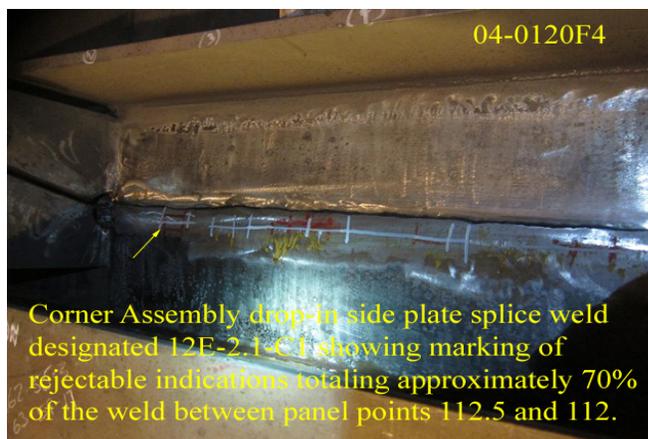
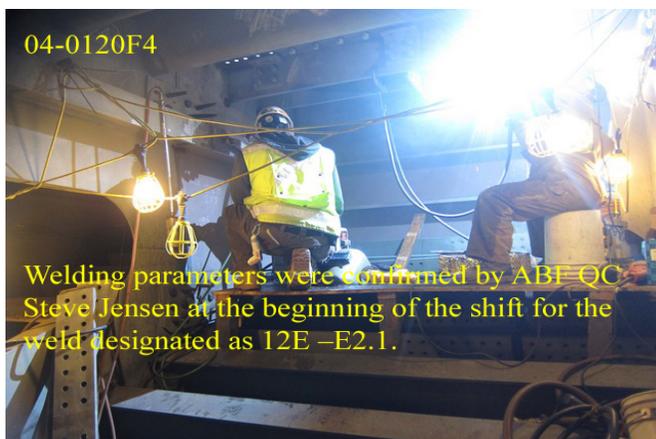
The QA inspector periodically observed ABF/JV qualified welder Wai Kitlai #2953 performing Shielded Metal Arc Welding (SMAW) in the 2G position utilizing the Caltrans approved Welding Procedure Specification ABF-WPS-D1.5-1030. The welding observed was for the longitudinal diaphragm (E3) vertical stiffener splice at panel point 122.5. 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 spent a portion of this shift reviewing and documenting the status and completion of various production welding tracking logs for lift 13W/14W and 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

Reviewed By: Levell,Bill

QA Reviewer