

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-028127**Date Inspected:** 07-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 working in OBG 12W at various locations:

Authorized welder Jin Pei Wang #7299:

Welder Jin Pei Wang was observed welding on longitudinal weld 12W W2.1-A1 (4G, CJP) and transverse weld 12W PP111.1-A1 (4G, CJP) at Y locations 0 to 1740 and Y locations 0 to 2020. Welder Jin Pei Wang was noted utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-3110-4.

Authorized welder Chang Qiu Chen #2212:

Welder Chang Qiu Chen was observed welding on weld 12W PP116.5 W2.1-PS1 (3G, CJP) panel point web complete joint penetration (CJP) was utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1030

Authorized welder Jin Quan Huang #9340:

Welder Jin Quan Huang was observed welding on weld 12W PP112 W2.1-BW2 (3G, CJP) utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1030.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Authorized welder Roby Smith #4245:

Welder Roby Smith was observed welding on weld 12W PP116.5 W5-LSE (3G, CJP) utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D1.5-1012 Rev.3. QC Inspector Steve Jensen was noted checking welding parameters in the morning hours.

This QA randomly observed OBG 12W QC Inspector Chris Conche, checking fit up of various welds, Magnetic Particle Inspecting (MT) back gouges and indications in weld back gouges, and checking WPS compliance of welders throughout the day.

Magnetic Particle Testing

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

Weld 12W PP111.1-B1:

- 100% MT of Weld Back Gouge (1307mm MT Accept.)

Weld 12W PP116.5 W2.1-PS1:

- 100% MT of Weld Back Gouge (160mm MT Accept.)

Weld 12W PP116.5 W5-LSE:

- 100% MT of Weld Back Gouge (230mm, MT Accept.)

Weld 12W PP117 W2.1-BW3:

- 100% MT of Weld Back Gouge (210mm MT Accept.)

The above weld #12W PP117 W2.1-BW3 was 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.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



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
---------------------	-------------	-------------