

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-028135**Date Inspected:** 10-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 Chang Qiu Chen #2212:

Welder Chang Qiu Chen was observed grinding on weld 12W PP117 W2.1-PS1 (3G, CJP) and on weld 12W PP117 W2.1-BW1 flush in preparation for inspections.

Authorized welder Jin Quan Huang #9340:

Welder Jin Quan Huang was observed welding on weld 12W PP111.1 W2.1-BW1 (3G, CJP) utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D1.5-1110A-1.

Authorized welder Roby Smith #4245:

Welder Roby Smith was observed excavating and welding on the repairs for weld 12W 13W Deck Splice (1G & 4G, CJP) at Y location 1180 and 3280 utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D1.5-1110A-1. Deck plating was preheated to 225 degree fahrenheit before excavating. After indication excavation the repairs were Magnetic Particle Tested (MT) before welding. After welding the weld was

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then Post Weld Heat Treated (PWHT) to 450 degree fahrenheit for 1 hour before allowing it to cool.

Authorized welder Chris Bruce #8901:

Welder Chris Bruce was observed welding on weld 12W PP115.5 W2.1-PS3 (1G & 4G, CJP), 12W PP115.2 W2.1 PS1 (3G, CJP) and on weld 12W PP115.2 W2.1 PS2 (1G & 4G, CJP). Welder Chris Bruce was utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1030 and 1040 on the welds.

This QA randomly observed OBG 12W QC 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 PP115.2 W2.1-BW3:

- 100% MT of Weld Back Gouge (205mm, MT Accept.)

Weld 12W PP115.2 W2.1-PS1:

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

Weld 12W PP115.2 W2.1-PS3:

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

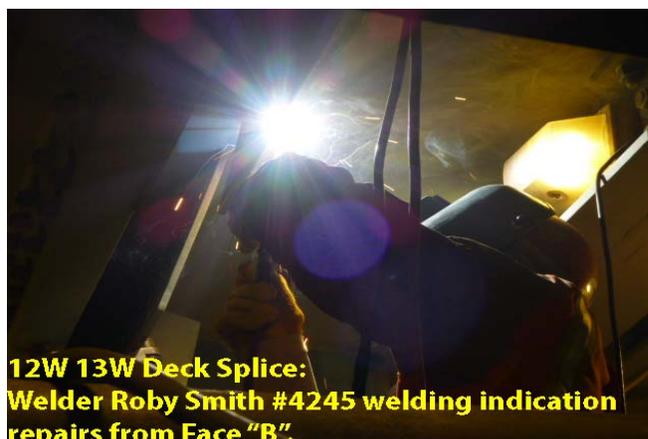
Weld 12W 13W Deck Splice:

- Indication Removal Verification at Y location 1180. (MT Accept. Area 20 x 50 x 5 Deep)

- Indication Removal Verification at Y location 3280. (MT Accept. Area 28 x 80 x 7 Deep)

The above weld 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.



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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
Reviewed By:	Levell,Bill	QA Reviewer
