

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-028149**Date Inspected:** 12-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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 12W (Interior)

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 W2.1-C1 (CJP) and weld 12W 13W B1 (3G) flush in preparation for inspections.

Authorized welder Chris Bruce #8901:

Welder Chris Bruce was observed welding on welds 12W PP115.5 W2.1-PS1 (3G, CJP) and on weld 12W PP115.5 W2.1 BW3 (1G & 4G, CJP). Welder Chris Bruce was utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1040 at both locations. This QA observed welder Chris Bruce applying pre heat to the weld prior to welding and QC Chris Conche was observed measuring amps and checking welding parameters as per QC Inspector duties. Measured amps at time of welding was 131 amps using E7018 H4R electrode with a preheat of 150 degrees Fahrenheit. All welding parameters within limits of (WPS) ABF-WPS-D15-1040A as verified by this QA.

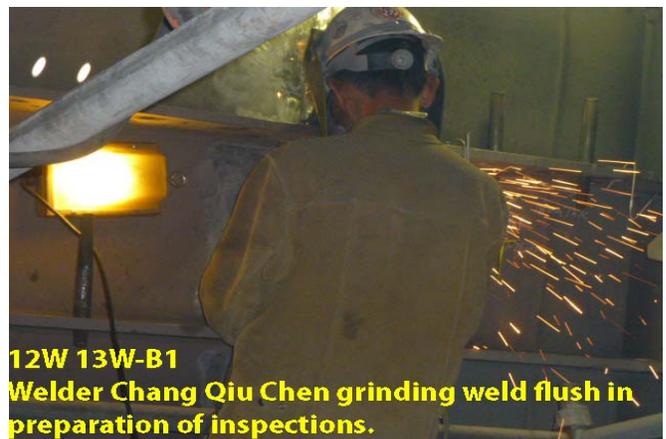
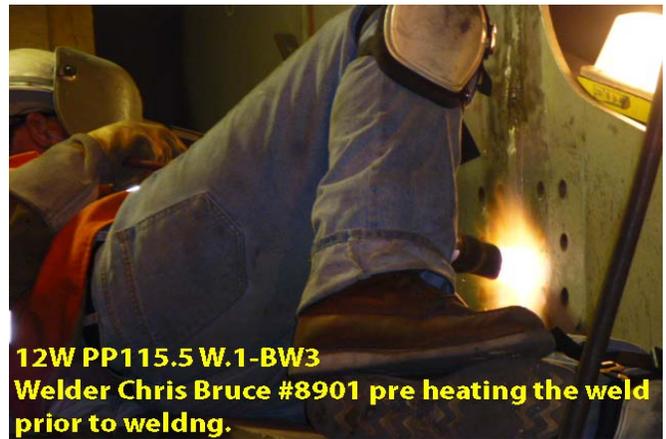
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This QA randomly observed OBG 12W QC Chris Conche, checking fit up of various welds, and checking WPS compliance of welders throughout the day and performing Magnetic testing (MT) on back gouges as they become available for testing.

At weld 12W PP111.1-B1 this QA observed QC Inspector Scott Krotum performing Ultrasonic Testing (UT) on the weld mentioned above. QC Inspector Scott was observed using a 70 degree angle on the weld utilizing all applicable scanning patterns for the inspecting of a weld ground flush. Inspection is incomplete at time of this report.

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



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

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your project.

Inspected By: Belford,Fritz

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer