

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-028173**Date Inspected:** 14-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 12W (Interior)

This QA observed the following welders working in OBG 12W and 13W at various locations:

Authorized welder Chris Bruce #8901:

Welder Chris Bruce was observed welding on welds 12W PP116 W2.1-PS1 (3G, CJP) utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1030.

Authorized welder Chau Tran #3139:

Welder Chau Tran was observed excavating and welding on the repairs for weld 12W 13W A1.2 (1G & 4G, CJP) utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D1.5-1004-Repair. Deck plating was preheated to 225 degree F before excavating. After indication excavation the repair was Magnetic Particle Tested (MT) before welding. After welding the weld was then Post Weld Heat Treated (PWHT) to 450 degree F for 1 hour before allowing it to cool. The following location was weld repaired by the welder.

Weld 12W 13W-A1.2:

Y location 1720 (Area 110 x 20 x 10mm Deep).

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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.

OBG 13W (Exterior)

Authorized welder Xiao Hua Luo #1291:

Welder Xiao Hua Luo was observed welding on weld 13W PP120 W2.0-FB1 (2G) and 13W PP120 W2.0-FB2 (3G), utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D1.5-1040A. Welder was observed pre heating weld to the WPS specified temperature before welding.

Authorized welder Mike Jimenez #4671:

Welder Mike Jimenez welding on weld 13W PP121 W2.0-BW1 (2G & 3G), utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D1.5-1040A. Welder was observed pre heating weld to the WPS specified temperature before welding. After completion of face "A" welder Mike Jimenez moved to face "B" and started Carbon Arc Gouging (CAG) the weld.

Magnetic Particle Testing

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

Weld 12W 13W LS1:

- Final MT (Face A & B, 210mm each, MT Accept.)

Weld 12W 13W-A1.2:

- Weld repair at Y location 1720 (110 x 20 x 10 Deep, External Repair)

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
