

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-028254**Date Inspected:** 24-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 at various locations:

Authorized welder Chris Bruce #8901:

Welder Chris Bruce was observed welding on welds 12W PP117 W2.1-PS4 (1G & 4G, CJP) and 12W PP117 W2.1-BW4 (3G, CJP) utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1040A.

Welder Chris Bruce was also observed by this QA moving among other panel points of the space repairing Visual (VT) rejects marked by QC Inspector Steve Jensen with welding or grinding as appropriate. The welding parameters observed as per Welding Procedure Specification's (WPS) utilized by the welder appears to be in order.

Authorized welder Mike Jimenez #4671:

Welder Mike Jimenez was observed performing weld repairs on Ultrasonic Testing Shear Wave rejects (UTSW) on weld 12W PP111.1 A1. Rejects noted by shear wave (UTSW) were at Y location 550 and Y location 1115.

Both indications were ground out by welder Mike Jimenez and repaired with welding from the underside of the plate, utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D1.5-1004-Repair.

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Welder was observed by this QA inspector using proper pre-heating techniques with a heat blanket from the topside or exterior side of plate "A". Noted temperatures for the repairs as per Welding Procedure Specification's (WPS) specified above were 325 degrees Fahrenheit for welding and 450 degrees Fahrenheit for Post Weld Heat Treatment at no less than a 1 hour time span. Since the indications were ground and not carbon arc gouge (CAG), the 225 degree Fahrenheit pre-heat for (CAG) was not necessary. An RWR is not required for these weld repairs.

This QA randomly observed OBG 12W QC Chris Concha, checking fit up of various welds, and checking WPS compliance of welders throughout the day and performing Magnetic Particle Testing (MT) on the back gouges as they become available for testing. Also noted this day was QC Inspector Steve Jensen performing Ultrasonic Testing Shear Wave (UTSW) on weld 12W 13W-C1.1 from the interior side of the weld. Multiple indications were observed by this QA being marked on the weld as the QC Inspector continued with his inspection.

Magnetic Particle Testing

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

12W PP111.1-A1 (Repairs at):

- Y Location 550 (Ground area 35 x 15 x 7 Deep, MT Accept.)
- Y Location 1115 (Ground area 80 x 20 x 13 Deep, MT Accept.)

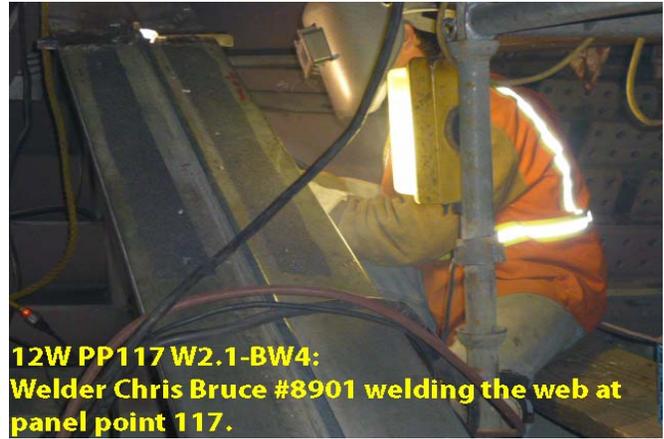
The above weld was previously accepted by QC Magnetic Particle technicians. This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

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
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Reviewed By:	Levell,Bill	QA Reviewer
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