

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-028265**Date Inspected:** 25-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

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-PS2 (1G & 4G, CJP), 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. 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 13W-A1.2. The "R1" rejects noted by shear wave (UTSW) were at Y locations 195, 255 350 and 450. The four (4) previously noted indications were pre-heated to over 225 degrees Fahrenheit and carbon arc gouge (CAG) out by welder Mike Jimenez from the underside of plate "A". It was then Magnetic Particle Tested (MT) by QC Patrick Swain and this QA. No indications were noted in the ground area. The weld repairs of the indications will commence the following day utilizing Caltrans approved Welding Procedure Specification's

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(WPS) ABF-WPS-D1.5-1004-Repair as per Request for Weld Repair (RWR) #201208-060 thru 063.

This QA randomly observed QC William Sherwood performing Magnetic Particle Testing (MT) on weld 12W PP117 W2.1-PS4 back gouge. This QA also observed QC Barry Drake checking fit up of various welds, and checking WPS compliance of welder throughout the day.

Also noted this day was QC Inspector Steve Jensen performing Ultrasonic Testing Shear Wave (UTSW) on weld 12W PP111.1 LS1 thru LS3. Of the three stiffener splices inspected by QC Steve Jensen only one (1) passed. Visual Testing and Magnetic Particle Testing by QC is still pending on the three stiffeners.

QC Inspector John Hays was observed performing Ultrasonic Testing Shear Wave (UTSW) on weld 12W PP111.1-A1 on the "R1" repairs from the previous day and the repairs were found to be acceptable. Visual Testing and Magnetic Particle Testing by QC is still pending.

Magnetic Particle Testing

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

12W PP117W2.1-PS2:

- Back Gouge (60mm, MT Accept.)

12W PP117W2.1-PS4:

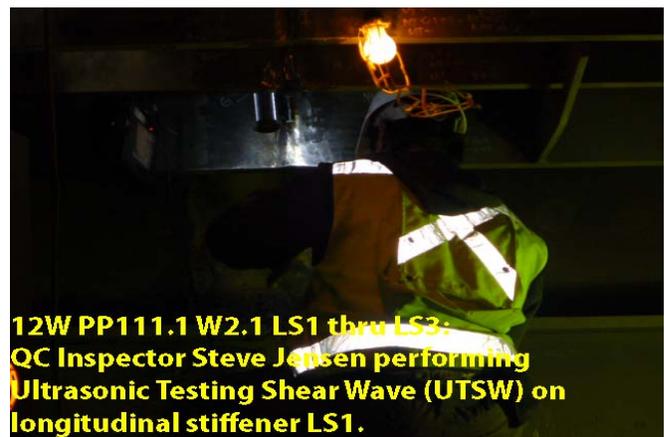
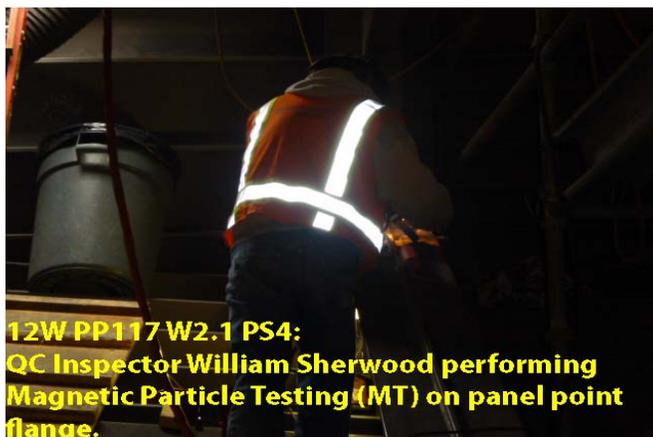
- Back Gouge (100mm, MT Accept.)

12W 13W-A1.2:

- Repair "R1" at Y location 15 (520 x 25 x 9 Deep, MT Accept.). "R1" Repairs inclusive of Y locations 195, 255, 350 and 450.

The above welds were 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
