

**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-028266**Date Inspected:** 27-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**

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

Authorized welder Mike Jimenez #4671:

Welder Mike Jimenez was observed performing weld repair on Ultrasonic Testing Shear Wave rejects (UTSW) on weld 12W 13W-A1.1. The "R2" reject noted by shear wave (UTSW) was at Y location 330. After excavation of the reject it was then Magnetic Particle Tested (MT) by QC Patrick Swain and this QA. No indication was noted in the 75 x 25 x 9 Deep excavated area. The excavation was then weld repaired utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D1.5-1004-Repair as per Request for Weld Repair (RWR) #201208-059.

Welder Mike Jimenez also performed repairs on weld 12W 13W-B1 at Y location 220 (Excavated 85 x 20 x 9 Deep) and 530 (Excavated 65 x 20 x 7 Deep). Both excavations were Magnetic Particle Tested (MT) by QC Patrick Swain and found to be acceptable. The excavation was then weld repaired utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D1.5-1004-Repair as per Request for Weld Repair (RWR) #201208-092.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

Authorized welder Chris Bruce #8901:

Welder Chris Bruce was observed welding on welds 12W PP116.5 W2.1-PS4 and 12W PP115 W2.1-BW2 (3G, CJP) utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1040A and ABF-WPS-D15-1030. The welding parameters observed were as per Welding Procedure Specification's (WPS) and appears to be in order.

Authorized welder Eric Sparks #3040:

Welder Eric Sparks was observed performing weld repair on stiffener 12W PP111.1-LS3 (3G, CJP). The "R2" indication repair was carbon arc gouge excavated to 60 x 20 x 15 Deep and welded utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1002-Repair. The welding parameters observed as per Welding Procedure Specification's (WPS) utilized by the welder appears to be in order.

This QA randomly observed QC Inspector Barry Drake checking WPS compliance of welder Mike Jimenez and welder Chris Bruce throughout the day.

Also noted this day was QC Inspector Patrick Swain performing Magnetic Particle Testing on weld repair excavations of welds noted above.

QC Inspector Harry Scharein was also observed performing Ultrasonic Testing Shear Wave on weld 12W 13W-A1.1. Rejects were noted in the weld and a Request for Weld Repair (RWR) is pending for the weld.

### Magnetic Particle Testing

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

12W 13W-A1.1:

- "R2" repair at Y location 330 (Excavated 75 x 25 x 9 Deep, MT Accept.)

12W PP111.1 LS3:

- "R2" repair (Excavated 60 x 20 x 15 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.

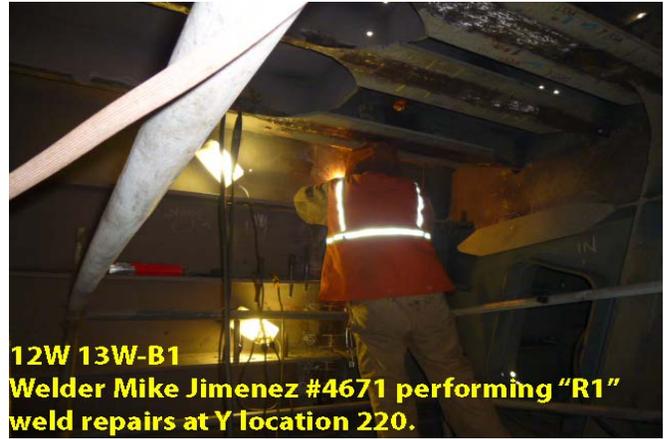
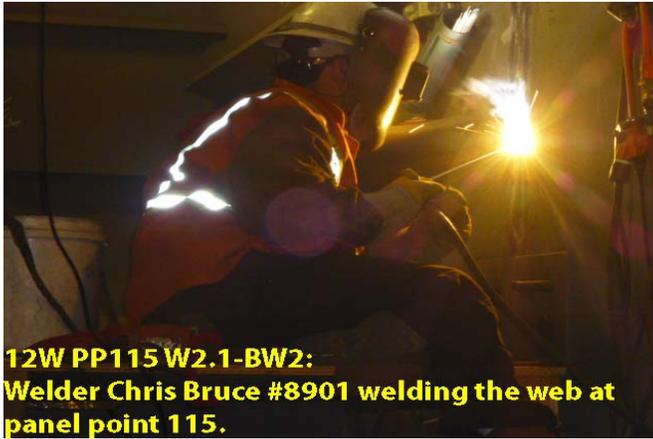
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---



## 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