

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-028274**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:** Salvador Merino**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 (QAI) Rodney Patterson 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:

Ultrasonic Testing OBG

This QA performed verification Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) welds related to the deck panel drop-in for the OBG east end. The welds were previously tested and accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QAI's findings are as follows;

Lift 12E Transverse Deck Splice (Weld No. 12E/13E-A1.1)

The QAI performed verification of this weld in way of repairs discovered by the QAI on 08-25-2012 at Y=545. No rejectable indications were found at the time of inspection.

Lift 13E Longitudinal Diaphragm Stiffener Splice (Weld No. 13E-PP122.75-E3-WT-W)

The QAI performed 100% verification of this weld. No rejectable indications were found at the time of inspection.

Lift 13E Longitudinal Diaphragm Stiffener Splice (Weld No. 13E-PP122.75-E3-WT-F)

The QAI performed 100% verification of this weld. No rejectable indications were found at the time of inspection.

Lift 13W Transverse Deck Splice (Weld No. 13W-121.6)

The QAI performed a minimum of 10% verification of this weld and additional testing was performed in way of

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repairs. No rejectable indications were found at the time of inspection.

Lift 13W Deck Panel Drop-in Flange connection (Weld No. 13W-PP124.5-W2.8-BF-1)

The QAI performed a minimum of 10% verification of this weld. No rejectable indications were found at the time of inspection.

Lift 13W Deck Panel Drop-in Web connection (Weld No. 13W-PP124.5-W2.8-BW-1)

The QAI performed a minimum of 10% verification of this weld. No rejectable indications were found at the time of inspection.

Lift 13W Deck Panel Drop-in Web connection (Weld No. 13W-PP124-W2.8-BW-1)

The QAI performed a minimum of 10% verification of this weld. No rejectable indications were found at the time of inspection.

Lift 13W Deck Panel Drop-in Web connection (Weld No. 13W-PP122-W2.5-BW-1)

The QAI performed a minimum of 10% verification of this weld. No rejectable indications were found at the time of inspection.

Lift 13W Deck Panel Drop-in deck splice (Weld No. 13W-W2.2)

The QAI performed 30% random verification of this weld. A total of three (3) rejectable indications were observed at the time of inspection. The rejectable indications observed by the QAI were confirmed by ABF QC inspector John Hayes during this shift.

The QAI noted and periodically observed ABF welder Guo Wu Chen #1556 performing Shielded Metal Arc Welding (SMAW) in the 2G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1000-Repair. The repairs are located on the web splice for Panel point 122. The weld is designated as 13E-PP122-E2.0-FBW-1. The weld and surrounding area was brought to a temperature by the use of a gas torch and the Quality Control (QC) inspector Salvador Merino was observed monitoring the welding parameters at the beginning of welding.

Magnetic Particle Testing (OBG 13E)

This QA Inspector performed a minimum of 15% verification Magnetic Particle Testing (MT) of the Longitudinal Diaphragm Stiffener Splice at panel point 122.75. This QA Inspector generated a TL-6028 MT report on this date. The results of the inspection are as follows;

Longitudinal Diaphragm Vertical Stiffener Web Splice (Weld 13E-PP122.75-E3-WT-V)

No indications found at the time of inspection.

The QAI observed the ABF welder Wai Kitlai continuing to perform Shielded Metal Arc Welding (SMAW) in the 4G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1004-Repair at the E3 longitudinal diaphragm stiffener connections at panel point 124.65. The weld is designated as 14E-PP124.65-E3-D. The weld and surrounding area was brought to temperature by the use of a gas torch. The Quality Control (QC) inspector Salvador Merino was observed monitoring the welding parameters at the beginning of the shift. The repairs at this location are being conducted in accordance with RWR-201208-081.

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The QAI spent a portion of this shift reviewing and documenting the status and completion of various production welding tracking logs for lift 13E-14E drop-in deck work currently in-process. The QA recorded the information on the OBG tracking log.

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

Summary of Conversations:

As noted above

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:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
