

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-028330**Date Inspected:** 04-Sep-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) 12E corner assembly drop-in, edge plate field splice. The weld was 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 edge plate field splice (Weld No. 12E-PP111.1-B1)

The QAI performed 75% verification of this weld. A total of one (1) rejectable indication was observed at the time of inspection. The Rejectable indication was confirmed by ABF QC inspector Jesse Cayabyab during this shift.

The QAI observed ABF/JV qualified welder Richard Chouinard performing Carbon Arc Gouging (CAG) for the repair of the corner assembly drop-in side plate designated as 12E/13E-C1. The ABF/JV QC inspector Salvador Merino was observed performing magnetic particle testing (MT) in way of the repair excavations at the following locations,

Weld 12E/13E-C1

Y=700 Depth 11, Width 35mm, Length 410mm

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The ABF welder Richard Chouinard was observed later in the shift performing Shielded Metal Arc Welding (SMAW) in the 4G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1004-Repair at the locations previously noted. The weld and surrounding area was brought to a temperature of 325°F by the use of inductions heaters and maintained throughout the welding process. The repairs were performed in accordance with approval for repair document RWR201208-053 due to the length of the repair at this location.

The QAI was notified by ABF/JV QC inspector Salvador Merino that the lifting lug removal areas on the E3 longitudinal diaphragm south side at panel point 122.65 were completed and ready for QA verification. The results of the inspections are as follows.

Panel Point 122.65 E3 north side longitudinal diaphragm

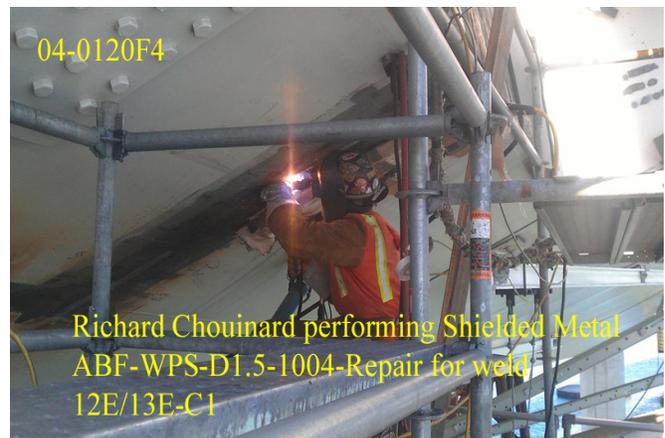
The QA visual inspection at the lifting lug removal area was performed at this location and measurements taken on the required 3/1 slope of the removal area did not comply with ABF-RFI-001151R00 and Magnetic particle testing of the removal areas has not been performed at this location to date. The ABF/JV QC inspector Salvador Merino then proceeded to perform magnetic particle testing (MT) of the lifting lug removal area and observed multiple linear indications on the remaining lug attachments. The indications will require repair at a later date.

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 Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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