

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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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-028339**Date Inspected:** 07-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**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 PP114 W2.1-BW2 (3G, CJP), 12W PP114 W2.1-BW1 (3G, CJP) and 12W PP113.5 W2.1-BW2 (3G, CJP). The welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1030 and preheating to the specified temperature of over 150 degrees prior to welding. Other welding parameters observed were as per Welding Procedure Specification's (WPS) noted above and appears to be in order.

Authorized welder Eric Sparks #3040:

Welder Eric Sparks was observed performing weld repairs on weld 12W 13W-B1 at Y location 1570 externally. Weld was excavated with a grinder to 60 x 15 x 6mm deep; it was then Magnetic Particle Inspected by QC John Pagliero and weld filled by the welder utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1004-Repair. Welding parameters observed appeared to be in order.

This QA randomly observed QC Inspectors Barry Drake, checking WPS compliance of welders throughout the

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# WELDING INSPECTION REPORT

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day and performing Visual Testing (VT) on items as they become available.

### Magnetic Particle Testing

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

12W PP111.1-B:

- 100% Final MT (A & B Sides, MT Accept.)

### Ultrasonic Testing Shear Wave

This QA performed Ultrasonic Testing Shear Wave (UTSW) on the following weld:

12W PP111.1-B:

- 15% Final UTSW (A & B Sides, UT 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.



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

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**Inspected By:** Belford,Fritz

Quality Assurance Inspector

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**Reviewed By:** Levell,Bill

QA Reviewer