

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-028354
Date Inspected: 07-Sep-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 2130
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:

The QAI observed at random intervals; ABF welder Richard Chouinard continuing to perform Shielded Metal Arc Welding (SMAW) in the 3G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1004-Repair at Y=0 and Y=100 for the edge plate field splice designated as 13E/14E-G. The weld and surrounding area was brought to a temperature of 325°F by the use of a gas torch and maintained throughout the welding process. The repairs were performed in accordance with approval for repair document RWR201208-35 and RWR201208-36.

Ultrasonic Testing OBG

This QA performed verification Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) Corner Assembly drop-in weld connections for lift 12E and 13E. 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 Edge Plate field splice (Weld No. 12E-PP111.1-B1)

The QAI performed verification of repairs ultrasonically rejected by the QAI on 09/04/2012 located at Y=620. No rejectable indications were observed at the time of inspection.

Lift 12E/13E Side Plate field splice (Weld No. 12E/13E-C1)

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The QAI performed 30% random verification verification of this weld. No rejectable indications were observed at the time of inspection.

The QAI observed at random intervals; ABF welder Wai Kit Lai #2953 performing Flux Cored Arc Welding (FCAW) in the 1G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1. 5-3040A-1 for the lift 13E deck access hole between panel point 124 and 124.5. The weld and surrounding area was brought to a temperature by the use of a gas torch.

The QAI observed ABF/JV qualified welder Richard Garcia #5892 performing Carbon Arc Gouging (CAG) for the repair transverse deck panel drop-in splice designated as 13E-PP122.2. The ABF/JV QC inspector Salvador Merino was observed performing magnetic particle testing (MT) in way of the repair excavations at the following locations,

13E-PP122.2

Y=145 Depth 11, Width 20mm, Length 60mm

Y=700 Depth 10, Width 20mm, Length 60mm

Y=1515 Depth 13, Width 20mm, Length 150mm

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 in way of the excavation at Y=145. The weld and surrounding area was brought to a temperature of 325°F by the use of induction heaters and maintained throughout the welding process. The weld was then post heated at 450°F for one hour. The repairs were performed in accordance with approval for repair document RWR201208-47.

The QA inspector noted and periodically observed ABF/JV qualified welders Mike Jiminez (west splice) and Jacob Stafford (east splice) performing Shielded Metal Arc Welding (SMAW) in the 3G position utilizing Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1012-3. The production welding performed at this location was for the east and west HPS485 longitudinal deck stiffener splice for the deck assess hole between panel points 124 and 124.5 on lift 13E. The welds at this location are designated as DAH-13E-PP124.5-E5-LS-W and DAH-13E-PP124.5-E5-LS-E. The ABF/JV QC inspector Salvador Merino was observed performing magnetic particle testing (MT) in way of the backgouged root at both locations prior to the commencement of welding face B during the shift.

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.

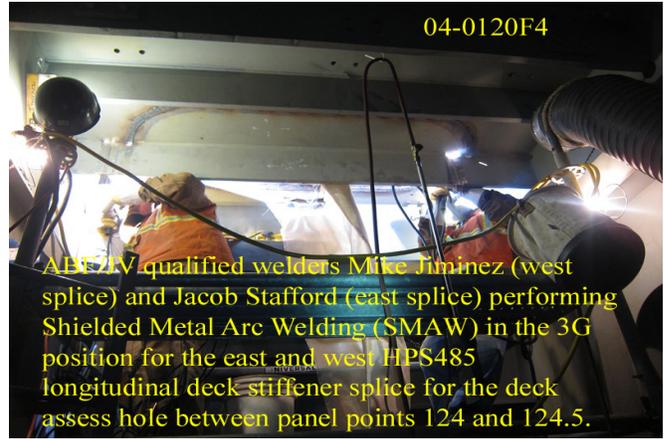
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above

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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.

Inspected By: Patterson,Rodney

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer