

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-028363**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:** 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 PP114.5 W2.1-BW1 (3G, CJP) and 12W PP114.5 W2.1-BW2 (3G, CJP). The welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1030 with a preheat temperature of over 150 degrees. The welding parameters observed were as per Welding Procedure Specification's (WPS) and appears to be in order.

Authorized welder Xiao Hua Luo #1291:

Welder Xiao Hua Luo was observed welding the Water Diverter Bar on weld 12W PP111.1 W2.1. The welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-F1200A. The welding parameters observed were as per Welding Procedure Specification's (WPS) and appears to be in order. The welder was also observed performing welding repairs on weld 12W PP111.1-B, utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1004-Repair.

This QA randomly observed QC Inspector Barry Drake and Chris Concha checking WPS compliance of welders

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throughout the day and performing Non-Destructive Testing on items as they become available. Also observed was QC Inspector Patrick Swain performing Magnetic Particle Inspection on the “A” deck plating in way of the area for the Water Diverter Bar fillet weld at 12W PP111.1.

Magnetic Particle Testing

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

12W PP111.1 W2.1:

- “A” Deck Pltg (1000mm area for the Water Diverter Bar fillet weld. 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.



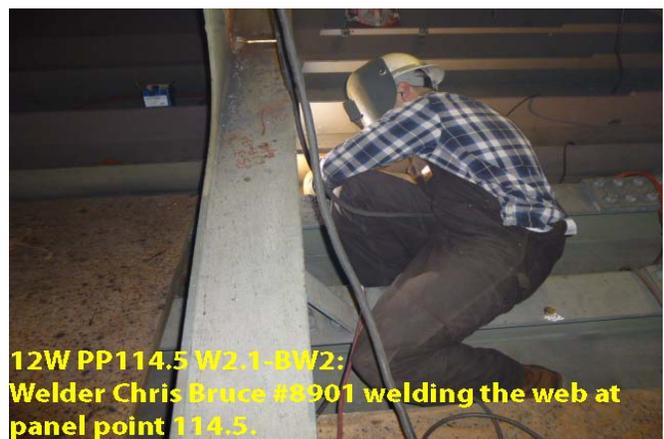
**12W PP111.1-B:
Welder Xiao Hua Luo #1291 performing weld repairs on weld rejects noted by Visual Testing (VT).**



**12W PP111.1 Water Diverter Bar:
Welder Xiao Hua Luo #1291 tack welding the water diverter bar to the deck.**



**12W PP111.1 Water Diverter Bar:
QC Patrick Swain performing Magnetic Particle Testing on the deck for the diverter bar weld.**



**12W PP114.5 W2.1-BW2:
Welder Chris Bruce #8901 welding the web at panel point 114.5.**

Summary of Conversations:

Conversations relevant to work performed on this date.

Comments

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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:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
