

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-028371**Date Inspected:** 10-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted 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:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey 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:

12E PP116-FP1/PS1 (Interior)

This QA Inspector made random observations of ABF/JV qualified welder Jacob Stafford #8020 performing the Shielded Metal Arc Welding (SMAW) process in the 2G horizontal position utilizing E7018-H4R electrodes on the plate stiffeners located at 12E PP116-FP1 on the interior of the OBG. QC Inspector Salvador Merino verified the temperature and recorded the parameters as acceptable and within the requirements of ABF-WPS-D1. 5-1040A-Revision 1. The welder was observed welding the length of the joint followed by grinding and blending of the work utilizing a small disc grinder. The welder completed face "A" of the work and back-gouged from the root side of the weld. QC performed an MT test and inspection of the joint and found no relevant indications. This QA Inspector observed the welder begin work on face "B" of the plate. On a subsequent observation, this QA Inspector noted that the welding was performed in the 2G horizontal and 4G overhead positions utilizing the E7018-H4R low hydrogen electrodes. The 3.2mm electrodes were stored in electrically heated, thermostatically controlled oven after removal from the sealed containers. The exposure limits of the electrodes appeared to comply with the minimum storage oven temperature of 120 degrees Celsius as per the contract documents. The welding parameters and surface temperatures were verified by the QC inspector's utilizing a Fluke 337 clamp meter to measure the electrical welding parameters and Tempilstik Heat Indicators for verifying the preheat and inter-pass temperatures. Upon completion of FP1, QC conducted fit-up operations on PS1 at the same location. The fit-up was found to be satisfactory and welding commenced on the joint. The welder completed face "A" of the work and

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back-gouged from the root side of the weld. QC performed an MT test and inspection of the joint and found no relevant indications. At the time of the observation no issues were noted by the QA. On subsequent observations throughout the shift to monitor quality, it was noted that the work was in progress and appeared to be in general conformance with the contract documents.

12E PP113.5-BW1 (Interior)

This QA Inspector randomly observed ABF/JV qualified welder R. Alex Blanco #9650 perform the on-going in process SMAW in the 2G horizontal position on the plate stiffeners located at 12E PP113.5-BW1 on the interior of the OBG. QC Inspector Salvador Merino was observed monitoring the welding on the material the pre-heat and parameters as they pertain to ABF-WPS-D1.5-1040A-Revision 1. The welder was observed drawing 135 amperes with the 3.2mm E7018-H4R electrodes and was noted as cleaning the work between passes utilizing a small disc grinder. The welder completed face "A" of the work and back-gouged from the root side of the weld. QC performed an MT test and inspection of the joint and found no relevant indications. This QA Inspector observed the welder begin work on face "B" of the plate. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was in progress and appeared to be in general conformance with the contract specifications.

12E PP114-BW2 (Interior)

This QA Inspector randomly observed ABF/JV qualified welder Chris Bowles #9317 perform the SMAW process in the 3G vertical position on the beam web located at 12E PP114-BW2 on the interior of the OBG. QC Inspector Salvador Merino was observed monitoring the welding on the material the pre-heat and parameters as they pertain to ABF-WPS-D1.5-1040A-Revision 1. The welder was observed drawing 135 amperes with the 3.2mm E7018-H4R electrodes and was noted as cleaning the work between passes utilizing a small disc grinder. The welder completed face "A" of the work and back-gouged from the root side of the weld. QC performed an MT test and inspection of the joint and found no relevant indications. This QA Inspector observed the welder begin work on face "B" of the plate. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was in progress and appeared to be in general conformance with the contract specifications.

12E PP116.5-BW3 (Interior)

This QA Inspector randomly observed QC inspector Salvador Merino conduct fit-up operations on the beam web at 12E PP116.5-BW3 on the interior of the OBG. Upon a satisfactory fit-up, QC measured the pre-heat temperature and verified the parameters of ABF/JV qualified welder R. Guo Wu Chen #1556 to ABF-WPS-D1.5-1040A-Revision 1. The welder was observed welding in the 3G vertical position using E7018-H4R electrodes drawing amperage of 134. The welder was observed cleaning the work after each pass and this QA Inspector noted that there were no issues at the time of the observations. This QA Inspector made several observations to monitor quality and noted that the work was in progress and appeared to be in general conformance with the contract documents.

12E PP111.1-C1 (Interior)

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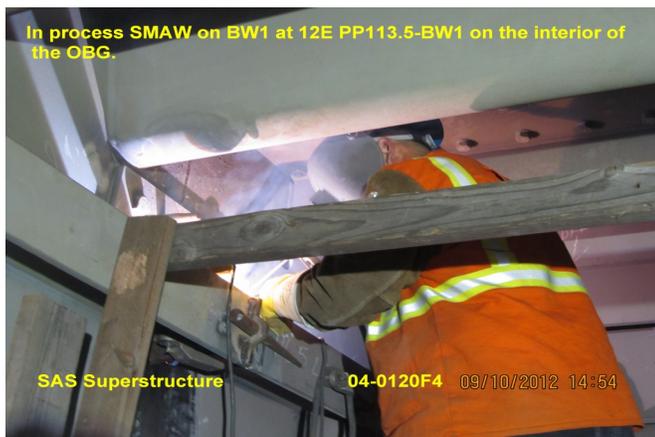
This QA Inspector randomly observed the excavation operations of Ultrasonic rejectable indications on the Complete Joint Penetration (CJP) joint at 12E PP111.1 on the interior of the OBG. This QA Inspector observed ABF/JV qualified welder Eric Sparks #3040 performing the Carbon Arc Gouging (CAG) method to remove metal from the material. The welder was observed cleaning up the excavations utilizing a small disc grinder and a de-burring drill. Upon completion of the excavation, Quality Control (QC) Inspector Salvador Merino performed a Magnetic Particle Inspection (MT) of the sites to determine soundness of the metal and observed no indications, QC then measured the dimensions of the excavations for length, width and depth. This QA Inspector recorded the dimensions of the excavations as:

Y=499mm; 76mm in length, 66mm wide and 9mm deep, y=1990mm; 75mm in length, 24mm wide and 11mm deep.

Prior to welding, QC Inspector Salvador Merino was observed monitoring and measuring the pre-heat temperatures and parameters as they pertain to ABF-WPS-D1.5-1004-Repair-Revision 0. This QA Inspector made random observations of SMAW in the 3G vertical position and noted no issues with the work at this location and at the time of this repair, an RWR was pending. This QA Inspector made subsequent observations throughout the shift to monitor quality and it was noted that the E7018-H4R electrodes were stored properly in a sealed container after being opened and they were drawing amperage of 136. The welder was observed continuing the in process repair welding and this QA Inspector noted that no issues were present at this location. QC Inspector Salvador Merino was also present to monitor the welding and the parameters in the later stages of the shift. This QA Inspector noted that the work at this location was completed on this date and appeared to be in general conformance with the contract specifications.

Summary of Conversations:

Conversations with Quality Control Inspector Slavador Merino pertaining to welder locations and testing required.



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: Frey,Doug

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer