

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-028375**Date Inspected:** 12-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 PP113.5 W2.1-BW1 (3G, CJP), 12W PP113.5 W2.1-BW2 (3G, CJP), 12W PP113.5 W2.1-PS2 (1G/4G, CJP) and 12W PP113.5 W2.1-PS3 (1G/4G, CJP). The welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1030; preheating to the specified temperature prior to welding. Welding parameters observed were as per Welding Procedure Specification's (WPS) noted above and appears to be in order.

Authorized welder Jin Quan Huang #9340:

Welder Jin Quan Huang was observed welding on welds 12W PP112 W2.1-BW2 (3G, CJP). The welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1030; preheating to the specified temperature of over 150 degrees prior to welding. Welding parameters observed were as per Welding Procedure Specification's (WPS) noted above and appears to be in order.

Authorized welder Richard Garcia #5892:

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Welder Richard Garcia was observed welding overhead on weld 12W W2.1-A1(1G/4G, CJP). The welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-3110-4 and preheating to 200 degrees prior to welding. Welding parameters observed were as per Welding Procedure Specification's (WPS) noted above and appears to be in order. The areas welded by the welder were visual porosity noted previously after grinding. Porosity was excavated to cumulative length of 2300mm long x 8mm deep. Total weld length is 31,000mm. As discussed on 12-08-15 with lead Danny Reyes, weld was still in process and no Request for Weld Repair or RWR was required.

Magnetic Particle Testing

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

12W PP113.5 W2.1-PS2:

- 100% Back Gouge MT (MT Accept.)

12W PP113.5 W2.1-PS3:

- 100% Back Gouge MT (MT Accept.)

This QA observed no rejectable indications at the time of testing. This QA Inspector generated an MT report on this date. The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

This QA randomly observed QC Inspectors Barry Drake checking WPS compliance of welders throughout the day and performing Visual Testing (VT) on items as they become available. This QA also observed QC Inspector Andrew Keech performing Magnetic Particle Testing (MPT) and Ultrasonic Testing Shear Wave on welds on panel points 12W PP115.2 thru 12W PP116.5.

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



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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 |
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