

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-028410
Date Inspected: 10-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: 1930
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 performing Shielded Metal Arc Welding (SMAW) in the 3G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1. 5-1002-Repair for the longitudinal stiffener splice at panel point 120.6. The weld is designated as 13E-PP120. 6-LS2. The weld and surrounding area was brought to temperature by the use of a gas torch and maintained throughout the welding process. The fourth time repair at this location was performed in accordance with approval for repair document RWR201209-51.

Ultrasonic Testing OBG

This QA performed verification Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) Deck drop-in and field splice connections for lift 12E, 13E and 13W. 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 13W Deck drop-in web splice (Weld No. 13W-PP123-E2.8-BW1)

The QAI performed a minimum of 50% verification of this weld. A total of one rejectable indication was observed at the time of inspection. The rejectable indication was confirmed by ABF QC inspector John Pagliero during the shift.

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Lift 12E Corner drop-in side plate splice (Weld No. 12E-PP111.1-C1)

This weld was partially turned over by ABF QC due to a 24 hour wait on repairs performed on this date. The QAI performed a minimum of 10% verification of this weld between the repaired areas at Y=650 and Y=1700. A total of one rejectable indication was observed at the time of inspection. The rejectable indication was confirmed by ABF QC inspector Patrick Swain during the shift. Due to bolting operations of the stiffener connections for the SAS load transfer, the QAI was unable to perform additional testing at this location. Further testing and repairs are required for this weld at a later date.

Lift 13E K-plate web to LS stiffener connection (Weld No. 13E-EK-SK1)

The QAI performed verification in way of repairs (Y=350) previously rejected by the QAI on 08-28-2012. An additional 10% random verification was performed of this weld with no rejectable indications observed at the time of inspection.

The QAI noted and periodically observed ABF welder Wai Kit Lai #2953 performing Shielded Metal Arc Welding (SMAW) in the 4G position utilizing the Caltrans approved Welding Procedure Specification ABF-WPS-D1.5-1110A-Rev 1 for the deck access hole on 13E between panel points 124 and 124.5 . The weld is designated as DAH-13E-PP124.5-E5. The weld and surrounding area was brought to temperature by the use of a gas torch and maintained throughout the welding process. ABF QC inspector Fred Michaels was observed monitoring the welding parameters at the beginning of the shift. The production welding at this location was completed prior to the end of the QAI's 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

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
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Reviewed By:	Levell,Bill	QA Reviewer
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