

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-028452**Date Inspected:** 19-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 Jin Quan Huang #9340:

Welder Jin Quan Huang was observed welding and grinding on weld 12W W2.1-A1. The welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1001-R and preheating the weld to 150 degrees Fahrenheit prior to welding. The areas welded were areas noted for visual surface porosity after the weld cap was ground smooth in preparations for Ultrasonic Testing Shear Wave (UTSW). Welder was observed welding as per Welding Procedure Specification's (WPS) noted above.

Authorized welder Guo Wu Chen #1556:

Welder Guo Wu Chen was observed welding and grinding on weld 12W W2.1-A1. The welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1001-R and preheating the weld to 150 degrees Fahrenheit prior to welding. The areas welded were areas noted for visual surface porosity after the weld cap was ground smooth in preparations for Ultrasonic Testing Shear Wave (UTSW). Welder was observed welding as per Welding Procedure Specification's (WPS) noted above.

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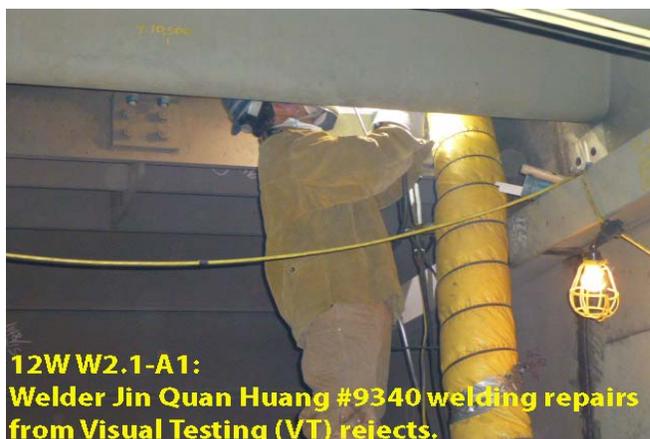
This QA randomly observed QC Inspectors Barry Drake checking the Welding Procedure Specification or WPS compliance of welders throughout the day. Also noted this day was QC Inspector Andrew Keech performing Magnetic Particle Testing (MPT) and Ultrasonic Testing Shear Wave (UTSW) on weld 12W PP116 W2.1-BW2.

Ultrasonic Testing Shear Wave

This QA performed Ultrasonic Testing Shear Wave (UTSW) on the following welds:

- 12W PP115 W2.1-PS1.
- 12W PP115.2 W2.1-BW1.
- 12W PP115.2 W2.1-BW3.
- 12W PP115.2 W2.1-PS1.
- 12W PP115.2 W2.1-PS3.
- 12W PP115.5 W2.1-BW1.
- 12W PP115.5 W2.1-BW3.

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



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.

Inspected By: Belford,Fritz

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer