

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-028470**Date Inspected:** 24-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 Richard Garcia #5892:

Welder Richard Garcia was observed welding on weld 12W PP111.5 W2.1-BW2 utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-3040B-3 for Flux Core Arc Welding (FCAW). The weld was preheated to 150 degrees Fahrenheit prior to welding. Other welding parameters observed appear to be in compliance with the WPS noted above.

Authorized welder Richard Chouard #8959:

Welder Richard Chouard was observed welding on weld 12W PP112 W2.1-PS1 utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1040A for Shield Metal Arc Welding (SMAW). The weld was preheated to 150 degrees Fahrenheit prior to welding. Other welding parameters observed appear to be in compliance with the WPS noted above.

Non-Destructive Testing (NDT):

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This QA performed NDT on the following welds:

Magnetic Particle Testing (MPT):

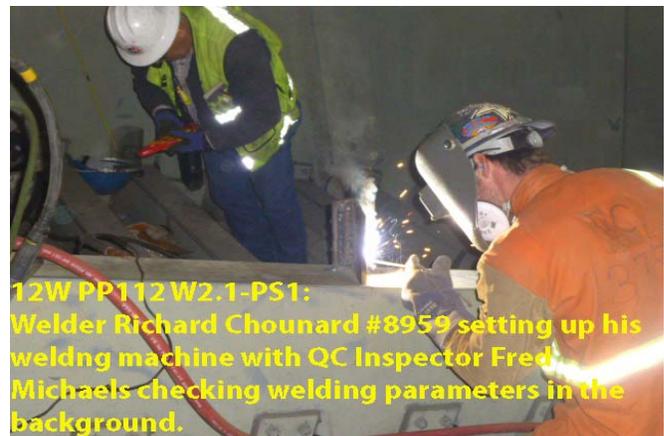
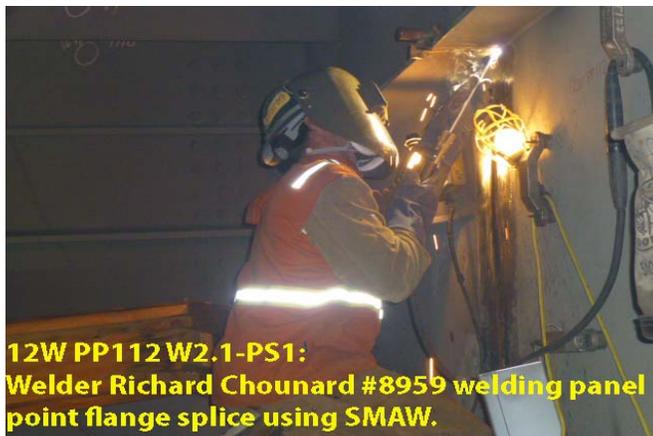
12W PP112 W2.1-PS1:

- 170mm Back Gouge, MT Accept..

This QA Inspector completed the appropriate report form on this date noting item acceptance or reject as per applicable code. The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

This QA observed QC Inspector Fred Michaels performing Visual Testing (VT) on joint fit ups and checking welding parameters such as voltage, amps and preheats throughout the day. Also noted was QC Inspector Steve Jensen performing Ultrasonic Testing Shear Wave on weld 12W W2.1-A1 at Y locations 2990 and 3140 verifying removal of indication from an earlier weld repair.

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



Summary of Conversations:

Weld 12W PP112 W2.1-PS1 fit up was not in compliance due to excessive offset (6mm) between the joining members along the major axis of the joint. This QA discussed with QC Inspector Fred Michaels the joint offset

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and was informed the appropriate paper work will be submitted on the offset for Engineers review.

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
