

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-028480**Date Inspected:** 27-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 welds 12W PP111.5 W2.1-BW1, 12W PP111.5 W2.1-BW2, 12W PP111.5 W2.1-BW3 and 12W PP111.5 W2.1-PS1. Welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-3040B-3 for Flux Core Arc Welding (FCAW) and ABF-WPS-D15-1040A for Shielded Metal Arc Welding (SMAW). The welder was observed preheating the welds prior to welding. Other welding parameters observed appear to be in compliance with the WPS noted above.

Welder Richard Garcia was also observed performing Carbon Arc Gouging (CAG) and welding of repairs on weld 12W W2.1-A1 at Y locations 3029 and 3140 at Face "B". Welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1001-R for Shielded Metal Arc Welding (SMAW) of repairs. The weld was preheated before excavations and welding. Welding parameters appear to be in order.

Authorized welder Eric Sparks #3040:

Welder Eric Sparks was observed performing Carbon Arc Gouging (CAG) welding of repairs on weld 12W W2.1-A1 at Y locations 3029 and 3140 at Face "A". Welder was observed utilizing Caltrans approved Welding

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Procedure Specification's (WPS) ABF-WPS-D15-1001-R for Shielded Metal Arc Welding (SMAW) of repairs. The weld was preheated before excavations and welding. Welding parameters appear to be in order.

Non-Destructive Testing (NDT):

This QA performed NDT on the following welds:

Magnetic Particle Testing (MPT):

Weld 12W W2.1-A1:

- Repair Excavation Y Location 3029 (60 x 20 x 10mm Deep, MPT Accept.)
- Repair Excavation Y Location 3140 (180 x 20 x 10mm Deep, MPT Accept.)

Weld 12W PP111.5 W2.1-BW2:

- Weld Back Gouge (1420mm, MPT Accept.)

This QA Inspector completed the appropriate report form on this date noting items acceptance or rejection 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 checks on welding parameters such as voltage, amps and preheats throughout the day. Also noted was QC Inspector John Pagliero performing Magnetic Particle Testing (MPT) on weld 12W W2.1-A1 excavation repairs. QC Inspector Bernard Docena was observed performing Magnetic Particle Testing on weld 12W PP111.5 W2.1-BW2 back gouge prior to welding.

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.

Inspected By:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
