

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-028481**Date Inspected:** 26-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-BW3 and 12W PP111.5 W2.1-PS1 utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-3040B-3 for Flux Core Arc Welding (FCAW). The welder was observed preheating the weld to 150 degrees Fahrenheit prior to welding. Other welding parameters observed appear to be in compliance with the WPS noted above.

Authorized welder Richard Chouinard #8959:

Welder Richard Chouinard was observed welding on welds 12W PP111.5 W2.1-PS2 and 12W PP111.5 W2.1-PS3 utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1040A for Shielded Metal Arc Welding (SMAW). The welder was observed preheating the weld 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):

This QA performed NDT on the following welds:

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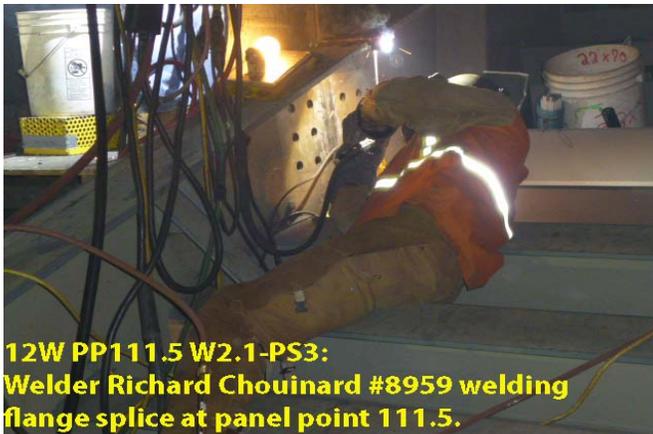
Magnetic Particle Testing (MPT):

- 12W PP111.5 W2.1-BW1. (640mm Back Gouge, MPT Accept.)
- 12W PP111.5 W2.1-BW3. (210mm Back Gouge, MPT Accept.)
- 12W PP111.5 W2.1-PS1. (160mm Back Gouge, MPT Accept.)
- 12W PP111.5 W2.1-PS2. (60mm Back Gouge, MPT Accept.)
- 12W PP111.5 W2.1-PS3. (130mm Back Gouge, 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 welding parameters checks such as voltage, amps and preheats throughout the day. Also noted was QC Inspector Scott Krotum performing the initial QC Magnetic Particle Testing (MPT) and Ultrasonic Testing Shear Wave (UTSW) on panel point 12W PP114 W2.1 welds.

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.

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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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