

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-028483**Date Inspected:** 22-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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 grinding on welding 12W W2.1-A1 from the underside removing Visual Testing (VT) rejects between panel points 116 & 116.5, that were noted earlier when the weld was ground flush in preparation for Ultrasonic Testing Shear Wave (UTSW). 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. All other welding parameters appear to be in compliance with the WPS noted above.

Authorized welder Guo Wu Chen #1556:

Welder Guo Wu Chen was observed grinding on welding 12W W2.1-A1 from the underside removing Visual Testing (VT) rejects between panel points 116.5 & 117.5, that were noted earlier when the weld was ground flush in preparation for Ultrasonic Testing Shear Wave (UTSW). 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. All other welding parameters appear to be in compliance with the WPS noted above.

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Authorized welder Eric Sparks #3040:

Welder Foreman Eric Sparks was observed performing carbon arc gouging (CAG) and welding repairs on weld 12W W2.1-A1 at Y location 3140. The excavation was welded this morning utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1001-R. The weld was preheated to 125 degrees Fahrenheit prior to welding. Other welding parameters observed appear to be in compliance with the WPS noted above. The repaired areas were areas rejected by Ultrasonic Testing Shear Wave (UTSW).

Non-Destructive Testing (NDT):

This QA performed NDT on the following welds:

Magnetic Particle Testing (MPT):

12W W2.1-A1:

- Repair at Y location 3140 repair. (160 x 18 x 6 deep, 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 randomly observed QC Inspectors Barry Drake, Fred Michaels and Salvador Merino performing Visual Testing (VT) on various joint fit ups and excavations; checking welding parameters such as voltage, amps and preheats throughout the day. Also noted were QC Inspectors Steve Jensen, Jesus Cayabyab and Harry Scharein performing Ultrasonic Testing Shear Wave on weld 12W W2.1-A1 and marking multiple rejects on the weld.

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
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Reviewed By:	Levell,Bill	QA Reviewer
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