

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-028513**Date Inspected:** 29-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:** Harry Scharein**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 (QAI) Rodney Patterson 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:

Magnetic Particle Testing (OBG 13W)

This QA Inspector performed verification Magnetic Particle Testing (MT) of the lift 13W deck panel drop-in web/flange connections. This QA Inspector generated a TL-6028 MT report on this date. The results of the inspection are as follows;

Lift 13W Deck drop-in flange splice (Weld No. 13W-PP122.5-W2.5-BF2)

The QAI performed a minimum of 50% verification of this weld from face A/B. No rejectable indications were observed at the time of inspection.

Lift 13W Deck transverse stiffener splice (Weld No. 13W-PP120-TS1)

The QAI performed a minimum of 100% verification of this weld from face A/B. No rejectable indications were observed at the time of inspection.

Lift 13W Deck drop-in web splice (Weld No. 13W-PP123-W2.8-BW1)

During the QA visual inspection prior to magnetic particle testing the QAI observed multiple areas of scattered porosity on the surface of the weld face with a single pore measuring in excess of 1.6mm in diameter. Further repair at this location is required prior to QA acceptance.

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The QAI observed ABF/JV qualified welder Erick Sparks #3040 performing Carbon Arc Gouging (CAG) for the repair of the deck access hole weld designated as DAH-13E-PP124.5-E5. The ABF/JV QC inspector Brian Connolly was observed performing magnetic particle testing (MT) in way of the repair excavations at the following locations,

DAH-13E-PP124.5-E5

Y=175 Depth 12, Width 18mm, Length 78mm

Y=840 Depth 13, Width 18mm, Length 87mm

Y=905 Depth 12, Width 19mm, Length 63mm

Y=1100 Depth 12, Width 19mm, Length 66mm

The repair excavations were performed in accordance with the following approval for repair documents;

Y=175 RWR201209-124

Y=840 RWR201209-128

Y=905 RWR201209-129

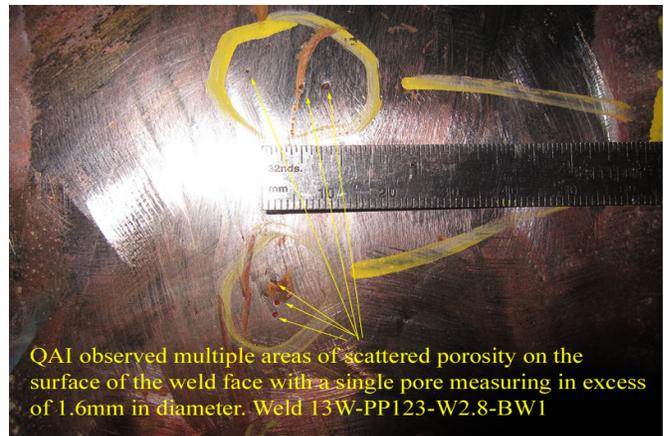
Y=1100 RWR201209-130

The repairs at this location were only excavated during the QAI's shift and will require welding at a later date.

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

Summary of Conversations:

Conversations relevant to the work being performed.



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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.

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
