

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-028519**Date Inspected:** 06-Oct-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:	Chris Concha		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	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:

The QAI observed ABF/JV qualified welder Rick Clayborn #2773 performing Carbon Arc Gouging (CAG) for the repair of the longitudinal deck drop-in weld designated as 13W-W2.1. The ABF/JV QC inspector Chris Concha was observed performing magnetic particle testing (MT) in way of the repair excavations at the following locations,

13W-W2.1

Y=2480, Depth 12, Width 55mm, Length 150mm

Y=2740, Depth 13, Width 35mm, Length 150mm

The ABF qualified welder Rick Clayborn #2773 was observed later in the shift performing Shielded Metal Arc Welding (SMAW) in the 4G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1004-Repair at the above mentioned location. The weld and surrounding area was brought to a temperature of 325°F by the use of induction heaters and maintained throughout the welding process. The repairs were then observed to be post heated at 450°F for one hour as required by the applicable repair document. The weld repairs were performed in accordance with approval for repair document RWR201209-110 for Y=2480 and RWR201209-106 for Y=2740.

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The QAI noted and periodically observed ABF welder Erick Sparks performing Shielded Metal Arc Welding (SMAW) in the 1G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1004-Repair. The repairs are located on the deck access hole drop-in weld for lift 13W between panel point 124 and 124.5 at the following locations;

Y=2700 Depth 8, Width 16mm, Length 50mm

The weld and surrounding area was brought to a temperature of 325°F by the use of a gas torch and maintained throughout the welding process. The repairs were then observed to be post heated at 450°F for one hour. The repair excavations were performed in accordance with approval for repair documents 201210-006.

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.



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:	Reyes,Danny	QA Reviewer
