

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-028537**Date Inspected:** 08-Oct-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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 performing weld repairs on weld 12W PP113 W2.1-BW2. Welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1000R Rev.2 for Shielded Metal Arc Welding (SMAW). The welder was observed preheating the welds prior to Carbon Arc Gouging and welding. Other welding parameters as inspected by QC Inspector appear to be in compliance with the WPS noted above.

Authorized welder Guo Wu Chen #1556:

Welder Guo Wu Chen was observed performing weld repairs on weld 12W PP112.5 W2.1-BW3 Carbon Arc Gouging (CAG) the weld for repairs. Welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1000R Rev.2 for Shielded Metal Arc Welding (SMAW). The welder was observed preheating the welds prior to Carbon Arc Gouging and welding. Other welding parameters as inspected by QC Inspector appear to be in compliance with the WPS noted above.

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Authorized welder Eyun Lin #9344:

Welder Eyun Lin was observed performing weld repairs on weld 12W PP116.5 W2.1-PS1 Carbon Arc Gouging (CAG) the weld for repairs. Welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1000R Rev.2 for Shielded Metal Arc Welding (SMAW). The welder was observed preheating the welds prior to Carbon Arc Gouging and welding. Other welding parameters as inspected by QC Inspector appear to be in compliance with the WPS noted above.

Authorized welder Richard Garcia #5892:

Welder Richard Garcia was observed performing weld repairs on weld 12W W2.1-A1 Carbon Arc Gouging (CAG) rejectable weld indications for repairs. Welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-3000-4 for Flux Core Arc Welding (FCAW). The welder was observed preheating the welds prior to Carbon Arc Gouging and welding. Other welding parameters as inspected by QC Inspector appear to be in compliance with the WPS noted above.

Non-Destructive Testing (NDT)

This QA performed Visual, Magnetic Particle and Ultrasonic Testing on the following:

Welds at Panel Point 12W PP117 W2.1:

- Weld BW2 (390mm Long x 14mm Thick. - Accept.)
- Weld BW3 (200mm Long x 12mm Thick. - VT Reject)
- Weld BW4 (910mm Long x 14mm Thick. - VT Reject)
- Weld PS1 (160mm Long x 16mm Thick. - Accept.)
- Weld PS2 (55mm Long x 12mm Thick. - Accept.)
- Weld PS3 (95mm Long x 20mm Thick. - Accept.)
- Weld PS4 (95mm Long x 20mm Thick. - Accept.)

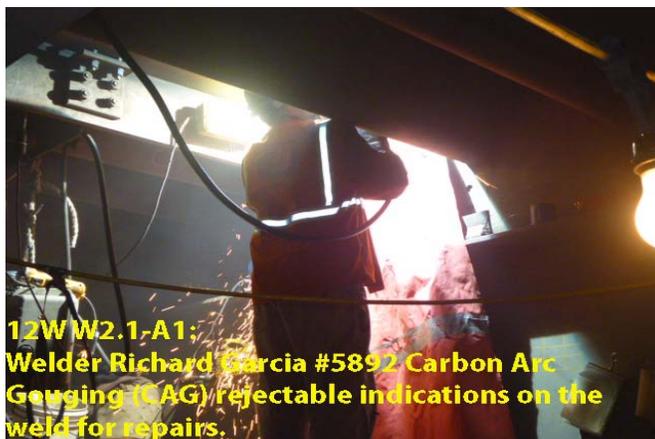
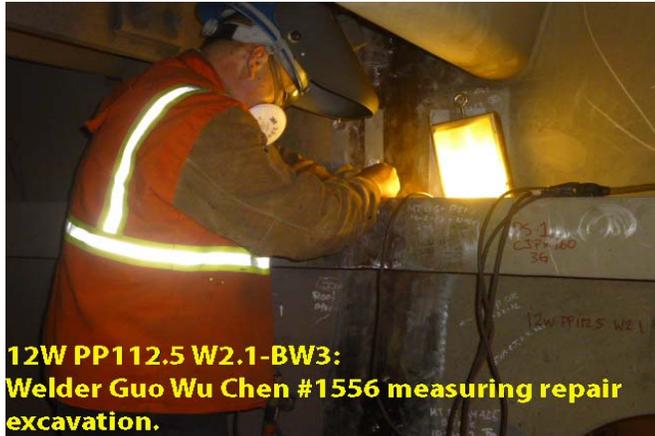
This QA Inspector completed the appropriate report form on this date noting items acceptance or rejection as per applicable code. The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

This QA observed QC Inspector Fred Michaels performing welding parameter checks such as voltage, amps, electrodes and preheats throughout the day. Also noted were QC Inspectors Scott Krotum and John Pagliero performing various Non-Destructive Testing (NDT) on panel point completed weld repairs as they become available for testing. Non-Destructive Testing methods utilized by the QC Inspectors were Visual Testing (VT), Magnetic Particle Testing (MPT) and Ultrasonic Testing Shear Wave (UTSW). QC Inspectors were observed accepting and rejecting welds per applicable code and or contract criteria.

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: Reyes,Danny

QA Reviewer
