

**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-028552**Date Inspected:** 01-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:** 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 PP112.5 W2.1-BW1, 12W PP112.5 W2.1-BW2 and 12W PP112.5 W2.1-BW3. Welder was observed 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 welds 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 PP113 W2.1-PS1 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.

Authorized welder Chris Bruce #8901:

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Welder Chris Bruce was observed welding and grinding on welds 12W PP116.5 W2.1-BW1 and 12W PP116.5 W2.1-PS2 performing Visual Testing (VT) and Ultrasonic Testing Shear Wave (UTSW) reject repairs 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 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:

#### Magnetic Particle Testing (MPT)

Weld 12W PP112.5 W2.1-BW1:

- Back Gouge (640mm, MPT Accept.)

Weld 12W PP112.5 W2.1-BW2:

- Back Gouge (1420mm, MPT Accept.)

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 Steve Jensen, John Pagliero and Scott Krotum performing various Non-Destructive Testing (NDT) on panel point completed welds as they become available for testing. Non-Destructive Testing methods utilized were Visual Testing (VT), Magnetic Particle Testing (MPT) and Ultrasonic Testing Shear Wave (UTSW). Inspectors were observed accepting and rejecting as per applicable code and contract criteria.

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

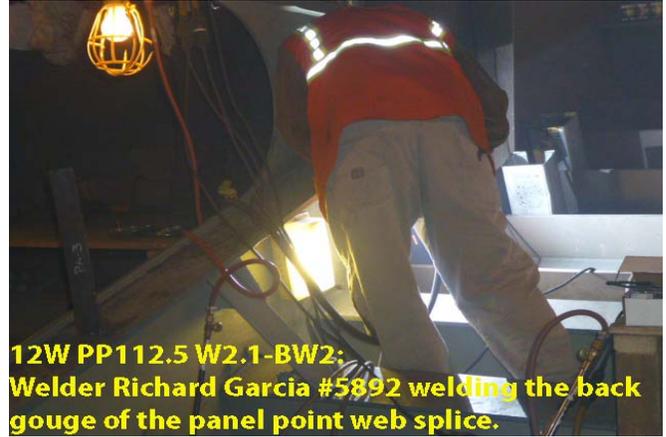


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# WELDING INSPECTION REPORT

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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.

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<b>Inspected By:</b>	Belford,Fritz	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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