

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-028561**Date Inspected:** 02-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 Richard Garcia #5892:

Welder Richard Garcia was observed welding on welds 12W PP112.5 W2.1-BW3 and 12W PP112.5 W2.1-PS1.

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:

Welder Chris Bruce was observed performing weld repairs by grinding and welding on welds 12W PP116.5 W2.

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1-BW1, 12W PP115.2 W2.1-BW2 and 12W PP117 W2.1-BW1. Welds were rejected by both Visual Testing (VT) and Ultrasonic Testing Shear Wave (UTSW). The welder was observed following repairs utilizing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1000R-Rev.2 for Shielded Metal Arc Welding (SMAW). He was observed preheating the welds to 150 degrees Fahrenheit prior to welding. Other welding parameters observed appear to be in compliance with the WPS noted above.

This QA performed Non-Destructive Testing (NDT) on the following:

Magnetic Particle Testing (MPT)

Weld 12W PP111 W2.1-Retro Plate A:

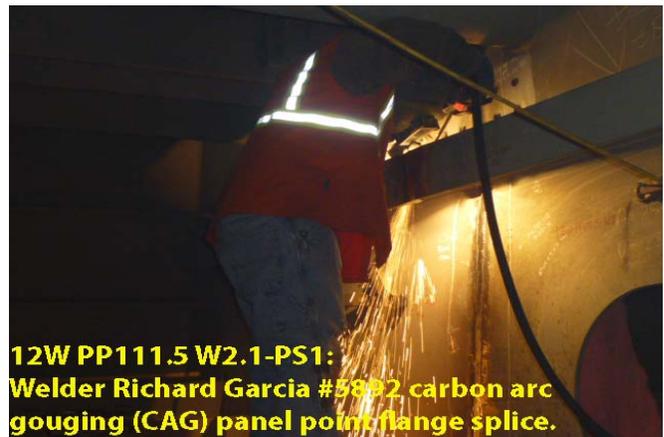
- Plate Fillet Weld (200mm x 4, MPT Accept.)

Weld 12W PP111 W2.1-Retro Plate B:

- Plate Fillet Weld (200mm x 4, MPT Accept.)

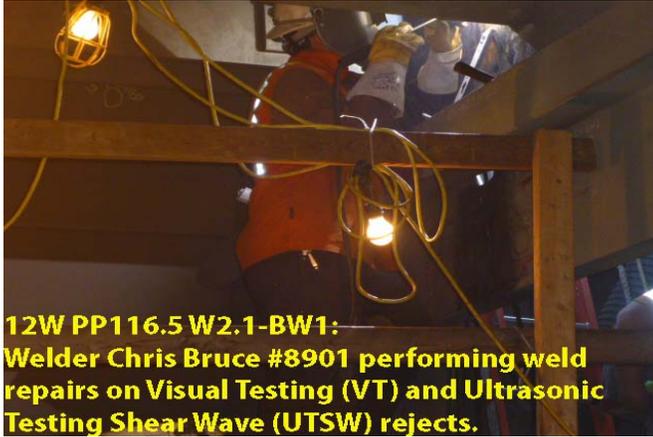
This QA observed QC Inspector Fred Michaels performing welding parameter checks such as voltage, amps, electrodes and preheats throughout the day. Also noted were QC Inspectors Steve Jensen, John Pagliero and Scott Krotum performing various Non-Destructive Testing (NDT) on panel point completed welds 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 welds 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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**12W PP116.5 W2.1-BW1:
Welder Chris Bruce #8901 performing weld
repairs on Visual Testing (VT) and Ultrasonic
Testing Shear Wave (UTSW) rejects.**

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:	Levell,Bill	QA Reviewer
