

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-028564**Date Inspected:** 10-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**Welder Chris Bruce #8901:**

Welder was observed performing weld repairs on weld 12W W2.1-A1 between at panel points 115.2 and 115.5.

Welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS)

ABF-WPS-D15-1000R Rev.2 for Shielded Metal Arc Welding (SMAW) to repair indications rejected by

Ultrasonic Testing Shear Wave (UTSW). 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.

Welder Lin E Yun #9344:

Welder was observed performing weld repairs on weld 12W PP116 W2.1-PS1 and PS2. 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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Welder Richard Chouinard #5892:

Welder was observed performing weld repairs on weld 12W W2.1-A1 between panel points 115 and 115.2.

Welder was observed utilizing Caltrans approved Welding Procedure Specification's (WPS)

ABF-WPS-D15-1000R Rev.2 for Shielded Metal Arc Welding (SMAW) to repair indications rejected by

Ultrasonic Testing Shear Wave (UTSW). 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 PP112.5 W2.1:

- Weld BW1 (640mm Long x 14mm Thick. - Accept.)
- Weld BW2 (1420mm Long x 14mm Thick. - Accept)
- Weld BW3 (200mm Long x 12mm Thick. - Accept)
- Weld PS1 (160mm Long x 16mm Thick. - Accept)
- Weld PS2 (60mm Long x 12mm Thick. - Accept)
- Weld PS4 (130mm Long x 20mm Thick. - Accept.)

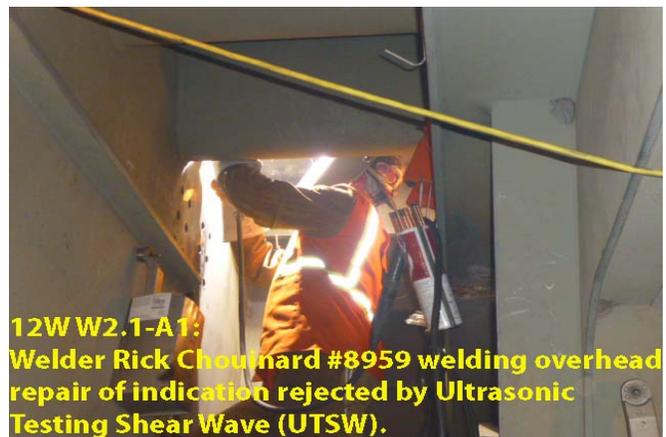
This QA Inspector completed the appropriate report form on this date noting items acceptance or rejection as per applicable code. The completed and accepted work observed on this day appeared to be in compliance with the contract specifications.

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 Hayes performing various Non-Destructive Testing (NDT) on 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.



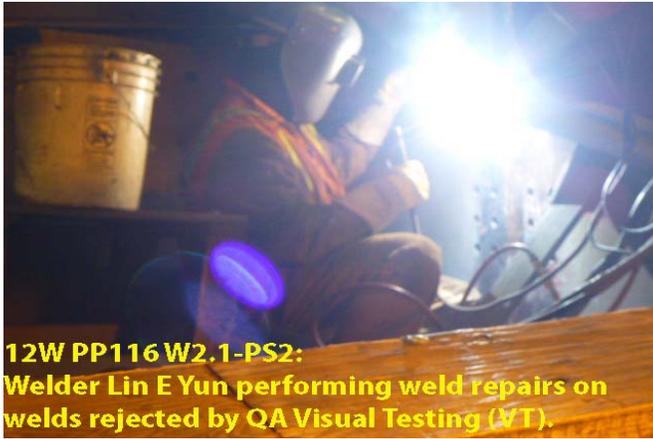
**12W PP113 W2.1-BW2:
Welder Jin Quan Huang #9340 performing weld repairs on indications rejected by Ultrasonic Testing Shear Wave (UTSW).**



**12W W2.1-A1:
Welder Rick Chouinard #8959 welding overhead repair of indication rejected by Ultrasonic Testing Shear Wave (UTSW).**

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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
