

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-028584**Date Inspected:** 13-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:	Patrick Swain		
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 noted and periodically observed ABF/JV welder Rick Clayborn #2773 performing Carbon Arc Gouging (CAG) for the repair of the deck drop-in flange splice designated as 13W-PP122-W2.5-BF1 from Face B. The ABF/JV QC inspector Patrick Swain was observed performing magnetic particle testing (MT) in way of the repair excavations at the following locations,

13W-PP122-W2.5-BF1 (Face B)
Y=115, Depth 16, Width 70mm, Length 240mm

The ABF 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. 5-1000-Repair at the above mentioned location. The weld and surrounding area was brought to temperature by the use of a gas torch and maintained throughout the welding process. The repair was performed in accordance with the following approval for repair document RWR201209-107 however; an error in the listed Welding Procedure Specification was noted in the repair document prior to repair, and a change to an applicable welding procedure was made in the field to suit. The QA Task leader was verbally notified of the change for further discussion with the Caltrans Structural Materials Representative (SMR) and ABF Management.

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Ultrasonic Testing OBG

This QA performed verification Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) Corner Drop-in stiffener connections for lift 12E at E2. The welds were previously tested and accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QAI's findings are as follows;

12E Deck Drop-in Stiffener Splice (Weld No. 12E-E2.1-PP111.5-BW1)

The QAI performed a minimum of 10% verification of this weld. No rejectable indications were observed at the time of inspection.

12E Deck Drop-in Stiffener Splice (Weld No. 12E-E2.1-PP111.5-BW2)

The QAI performed a minimum of 10% verification of this weld. No rejectable indications were observed at the time of inspection.

12E Deck Drop-in Stiffener Splice (Weld No. 12E-E2.1-PP111.5-BW3)

The QAI performed a minimum of 10% verification of this weld. No rejectable indications were observed at the time of inspection.

12E Deck Drop-in Stiffener Splice (Weld No. 12E-E2.1-PP111.5-PS1)

The QAI performed 100% verification of this weld. No rejectable indications were observed at the time of inspection.

12E Deck Drop-in Stiffener Splice (Weld No. 12E-E2.1-PP111.5-PS2)

The QAI performed 100% verification of this weld. No rejectable indications were observed at the time of inspection.

12E Deck Drop-in Stiffener Splice (Weld No. 12E-E2.1-PP111.5-PS3)

The QAI performed 100% verification of this weld. A total of one rejectable indication was observed at the time of inspection. The rejectable indication was confirmed by ABF QC inspector John Pagliero during the shift.

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
