

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-028585**Date Inspected:** 12-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

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|------------------------------------|---------------|----|-----|
| 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 transverse deck drop-in weld designated as 13W-PP122.2 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-PP122.2(Face B)

Y=6870, Depth 9, Width 20mm, Length 60mm

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. 5-1004-Repair at the above mentioned location. The weld and surrounding area was brought to a temperature of 325°F by the use of induction heaters and maintained throughout the welding process. The repairs were then observed to be post heated at 450°F for one hour as required by the applicable repair document. Due to the first time repair at this location an approval for repair document was not required.

During the QA random visual inspection of weld 13W-W2.1 from face A, on repairs completed on a previous shift, The QAI observed the transition in way of planar offset of 9mm at Y=9250 did not comply with the 4/1 transition

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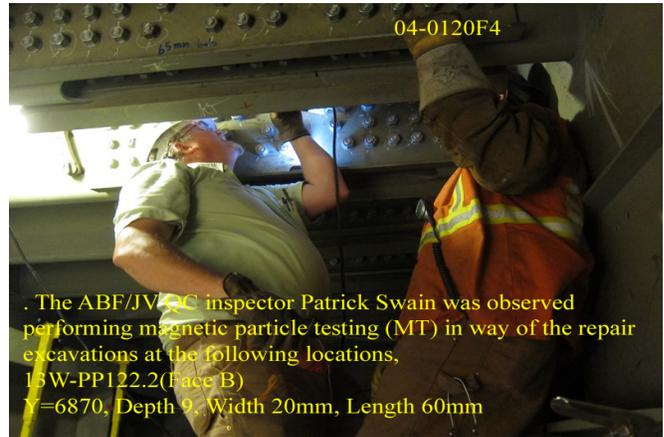
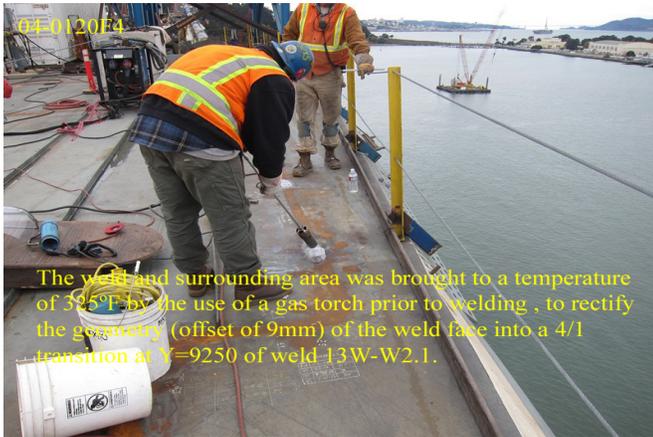
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required at this location. The ABF QC inspector Patrick Swain was notified of the issue who then stated that he would notify the welding personnel to rectify the transition by welding. The QAI then observed ABF welder Eric Sparks utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1004-Repair in the 1G position at the above mentioned location, to rectify the geometry of the weld face into a 4/1 transition. The weld and surrounding area was brought to a temperature of 325°F by the use of a gas torch and was confirmed by ABF QC Patrick Swain prior to welding. A post weld heat treatment was not required by the welding procedure used as only geometry of the weld face was corrected.

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.

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| Inspected By: | Patterson,Rodney | Quality Assurance Inspector |
| Reviewed By: | Reyes,Danny | QA Reviewer |
