

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-028600**Date Inspected:** 18-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 12E**Welder Rick Chouinard #8959:**

Welder was observed performing weld repairs on weld 12E E2.1-C1 externally, on Ultrasonic Testing Shear Wave (UTSW) rejected indications noted by QC Inspectors at Y location 0 - 960. 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 William Sherwood appear to be in compliance with the WPS noted above.

OBG 12W**Welder Chris Bruce #8901:**

Welder was observed performing weld repairs on weld 12W W2.1-A1, on Ultrasonic Testing Shear Wave (UTSW) rejected indications noted by QC Inspectors between panel points 114.5 & 115. 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

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welding. Other welding parameters as inspected by QC Inspector John Hays 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:

Panel Point 12W PP116.5 W2.1:

- Weld BW2 (360mm x 14mm Thick, UT Reject)

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 at this location appeared to be in compliance with the contract specifications.

This QA observed QC Inspectors Scott Kortum and John Hays performing various Non-Destructive Testing (NDT) on completed welds and weld repairs as they become available for testing in OBG 12W. 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.



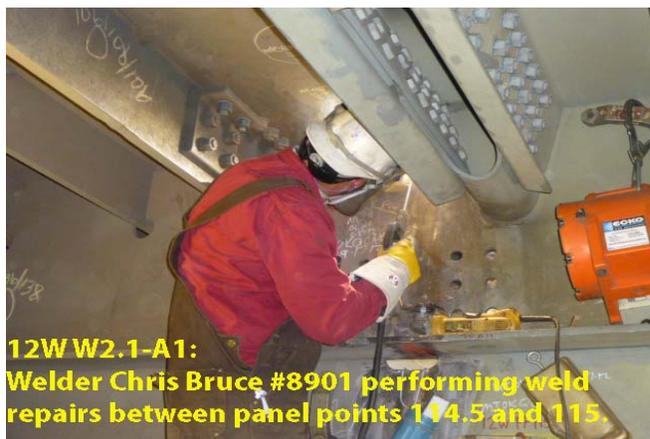
12E E2.1-C1:
ProHeat 35 settings for welding of excavation.



12E E2.1-C1:
Welder Rick Chouinard #8959 perheating prior to welding using a torch on areas not up to temperature by the internal heat blanket.



12E E2.1-C1:
Welder Rick Chouinard #8959 welding indication excavation from Y location 0- 960 externally.



12W W2.1-A1:
Welder Chris Bruce #8901 performing weld repairs between panel points 114.5 and 115.

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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
