

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-028609**Date Inspected:** 15-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:** Patrick Swain**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 (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 ABF welder Rick Clayborn #2773 continuing to perform Shielded Metal Arc Welding (SMAW) in the 4G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1000-Repair on the deck panel drop-in flange splice designated as 13W-PP122-W2.5-BF1. 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 the 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.

Ultrasonic Testing OBG

This QA performed verification Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) Deck Drop-in stiffener connections for lift 13W. 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;

13W Deck Drop-in Flange Splice (Weld No. 13W-E2.8-PP123-BF3)

The QAI performed 50% verification of this weld. No rejectable indications were observed at the time of inspection.

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The QAI noted and periodically observed ABF/JV welder Richard Chounard #8959 performing Shielded Metal Arc Welding (SMAW) in the 2G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1004-Repair. The repairs were performed to the K-plate web to longitudinal deck stiffener splice weld designated as 13W-WK-SK1. The repair was excavated and Magnetic Particle testing was performed on a previous shift at the following location,

13W-WK-SK1

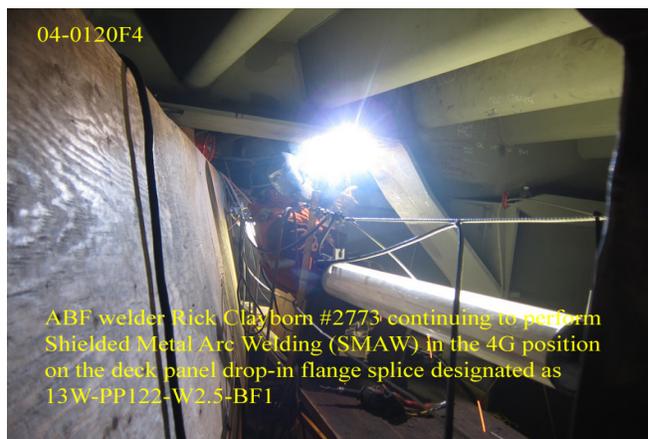
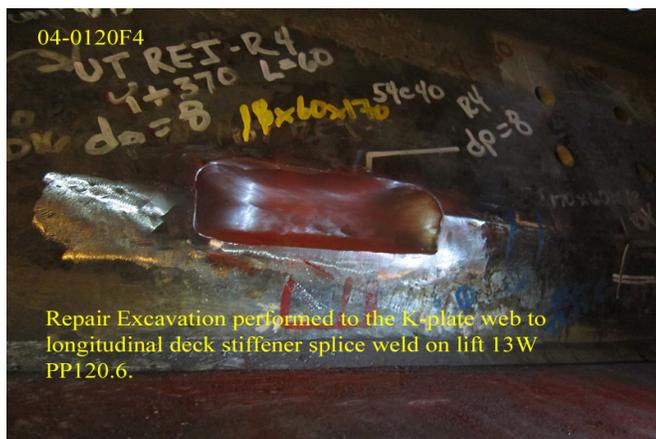
Y=370 Depth=18mm, Width= 60mm, Length=170mm

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. The repair was performed in accordance with the approval for repair document RWR201209-101.

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