

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-028612
Date Inspected: 18-Oct-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Job site

CWI Name: As Mentioned Below
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
Component: OBG

Bridge No: 34-0006**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 observed at random intervals ABF/JV welder Eric Sparks #3040 performing Carbon Arc Gouging (CAG) for the repair of the deck access hole for lift 13W at W5 from Face A designated as DAH-13W-PP124.5-W5. The ABF/JV QC inspector Salvador Merino was observed performing magnetic particle testing (MT) in way of the completed repair excavation at the following locations,

DAH-13W-PP124.5-W5 (Face A)
Y=2500, Depth 12, Width 20mm, Length 120mm

The ABF welder Eric Sparks was observed later in the shift performing Shielded Metal Arc Welding (SMAW) in the 1G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1004-Repair. The weld and surrounding area was brought to a temperature of 325°F by the use of a gas torch 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 RWR201210-006.

Ultrasonic Testing OBG

This QA performed verification Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) Deck Drop-in

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welds 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 longitudinal Splice (Weld No. 13W-W2.8)

The QAI performed verification in way of repairs and the surrounding area previously rejected by the QAI on 09-11-2012. A total of three (3) rejectable indication were observed at the time of inspection. The rejectable indications were confirmed ABF QA inspector Harry Scharein during the shift.

The QAI noted and periodically observed ABF/JV welder Wai Kit Lai performing Carbon Arc Gouging (CAG) for the repair of the deck drop-in transverse splice between lift 13W and 14W from face B. The ABF/JV QC inspector Patrick Swain was observed performing magnetic particle testing (MT) in way of the completed repair excavation at the following locations,

13E/14E-A0

Y=510, Depth 9.5, Width 30mm, Length 80mm

The ABF welder Wai Kit Lai 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. 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 RWR201210-011.

The QAI noted and periodically observed ABF welder Rick Clayborn #2773 performing Flux Cored Arc Welding (FCAW-S) in the 2F position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-F2200-1. The production welding was performed on the Catwalk Anchorage bracket on the East bound deck plate. The weld and surrounding area was brought to temperature by the use of a gas torch. The ABF QC inspector Fred Michaels was observed monitoring the welding parameters at the start of welding.

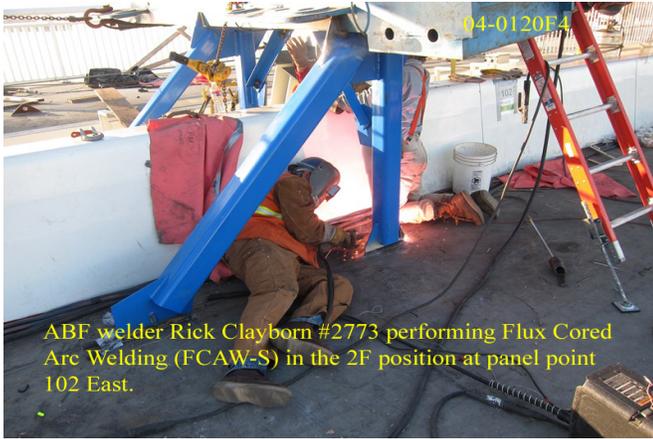
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversations relevant to the work being performed.

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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