

**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-028636**Date Inspected:** 22-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:** Salvador Moreno**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:

**Ultrasonic Testing OBG**

This QA performed verification Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) Deck Access Hole weld 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 Access Hole Splice (Weld No. DAH-13W-PP124.5-W5)

The QAI performed verification in way of previous repairs rejected by the QAI on 9-25-2012. The following repair locations as well as approximately 50mm on each side of the repair were ultrasonically examined.

Y=1185 No rejectable indications observed at the time of inspection

Y=1225 No rejectable indications observed at the time of inspection

Y=1285 A total of one (1) rejectable indication was observed at the time of inspection. The rejectable indication was confirmed by ABF QC inspector Patrick Swain and Steve Jensen during the shift.

Y=1370 No rejectable indications observed at the time of inspection

Y=2490 No rejectable indications observed at the time of inspection

The QAI noted and periodically observed ABF welder Richard Garcia performing Shielded Metal Arc Welding

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# WELDING INSPECTION REPORT

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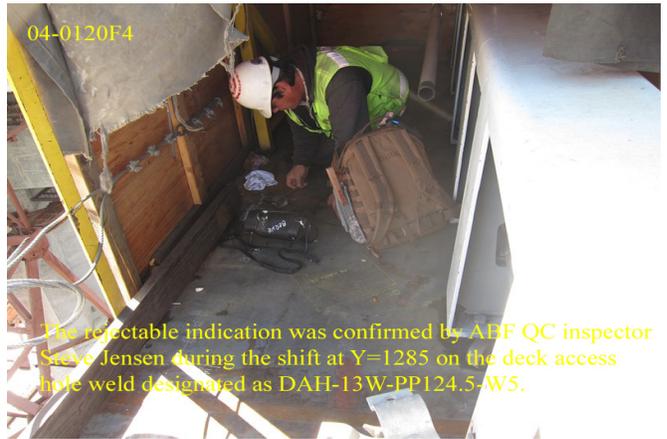
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(SMAW) utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1004-Repair in the 1G position on the Deck access hole at panel point 124.5 at E5. The weld and surrounding area was brought to a temperature of 325°F by the use of a gas torch and was confirmed by ABF QC Salvador Moreno prior to welding. The repairs made at this location were to correct the geometry of the weld face due to excessive grinding. 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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<b>Inspected By:</b>	Patterson,Rodney	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes,Danny	QA Reviewer

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