

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-028637**Date Inspected:** 20-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:	N/A	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 Drop-in welds for lift 13E. 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;

13E Drop-in Web Splice (Weld No. 13E-PP120-E2.1-FBW1)

The QAI performed 100% verification of this weld. A total of three (3) rejectable indications were observed at the time of inspection. The rejectable indication was confirmed by ABF QC inspector Patrick Swain during the shift.

13E Drop-in Web Splice (Weld No. 13E-PP120-E2.1-FBW2)

The QAI performed a minimum of 100% verification of this weld. No rejectable indications were observed at the time of inspection.

13E Drop-in Web Splice (Weld No. 13E-PP120.5-E2.1-BW1)

During the QA final visual inspection of this weld the QAI observed excessive grinding of over 3mm in way of the leading edge of the floor beam web as seen in the attached photograph. The ABF QC inspector Salvador Moreno was notified, who then stated that further welding and QC inspection would be done prior to QA final verification.

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Ultrasonic testing verification was not performed at this location on this date due to the visually rejected weld.

13E Deck Drop-in Skewed flange connection (Weld No. 13E-PP123-E2.8-BF3)

The QAI performed verification of this weld in way of a previous repair rejected ultrasonically by the QAI on 09-20-2012 at Y=370. A total of one (1) rejectable indication was observed at the time of inspection in way of the repair. The rejectable indication was confirmed by ABF QC inspector John Pagliero.

13E Deck Access Hole Stiffener Splice (Weld No. DAH-13E-PP124.5-E5-LS-W)

The QAI performed 100% verification of this weld. No rejectable indications were observed at the time of inspection.

13E Deck Access Hole Stiffener Splice (Weld No. DAH-13E-PP124.5-E5-LS-E)

The QAI performed 100% verification of this weld. A total of one rejectable indication was observed at the time of inspection. The rejectable indication was confirmed by ABF QC inspector Steve Jensen on the following shift.

Magnetic Particle Testing (OBG 13E)

This QA Inspector performed verification Magnetic Particle Testing (MT) of the lift 13W Deck Drop-in Web Splice. This QA Inspector generated a TL-6028 MT report on this date. The results of the inspection are as follows;

Lift 13E Deck Drop-in Web Splice (Weld No. 13E- PP120-W2.1-FBW2)

The QAI performed 100% verification of this weld from face A and B. No rejectable indications were observed at the time of inspection.

13E Deck Access Hole Stiffener Splice (Weld No. DAH-13E-PP124.5-E5-LS-W)

The QAI performed 100% verification of this weld. No rejectable indications were observed at the time of inspection.

13E Deck Access Hole Splice (Weld No. DAH-13E-PP124.5-E5)

The QAI performed a minimum of 15% random verification of this weld from Face B only. No rejectable indications were observed at the time of inspection however; during visual inspection of this weld the QAI observed missing fillet welds in way of the 485 longitudinal deck stiffener to the deck connection as seen in the attached photograph. The welds appeared to be intentional holdback welds left by the manufacturer to aid in the fit-up of the deck access hole stiffeners. The QAI then reviewed the fabrication drawings and confirmed these locations required fillet welds. The ABF QC Lead inspector Bonifacio Daquinag was notified who then stated he would discuss the issue with ABF management.

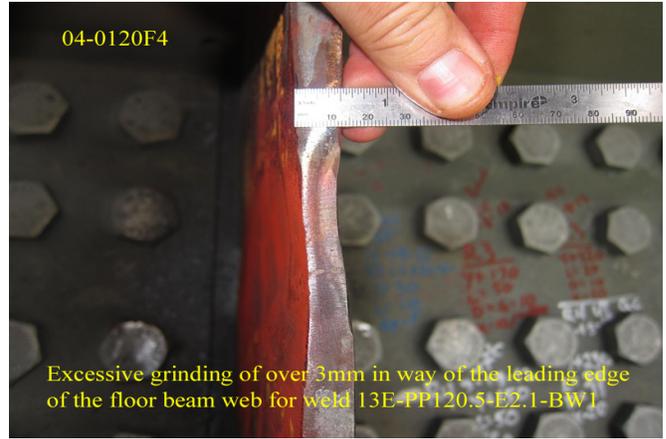
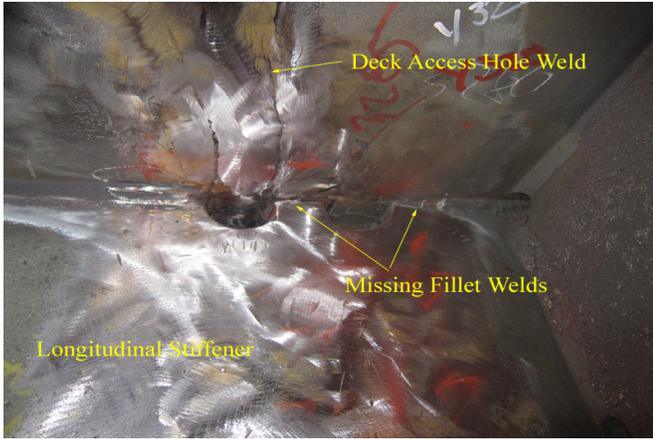
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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