

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-028638**Date Inspected:** 19-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:** Tony Sherwood/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 QAI observed at random intervals ABF/JV welder Rick Clayborn #2773 performing Carbon Arc Gouging (CAG) for the repair of the corner drop-in side plate splice designated as 12E-E2.1-C1. The ABF/JV QC inspector Tony Sherwood was observed performing magnetic particle testing (MT) in way of the completed repair excavation at the following locations,

12E-E2.1-C1

Y=4000, Depth 10, Width 60mm, Length 1000mm

Y=8000, Depth 11, Width 60mm, Length 1000mm

The ABF welders Richard Chouard #8959 and Mike Jimenez #4671 were 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 at the above mentioned locations. 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 at this location were incomplete at the end of the QAI's shift. The QAI observed a post weld heat treatment of 450°F of the incomplete weld prior to the end of the shift. The repair was performed in accordance with the approval for repair document RWR201209-013.

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The QAI noted and periodically observed ABF/JV welder Wai Kit Lai performing Carbon Arc Gouging (CAG) for the repair of the floor beam flange splice designated as 13W-PP123-W2.1-BF1. 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,

13W-PP123-E2.1-BF1

Y=25, Depth 15, Width 25mm, Length 95mm

Y=345, Depth 12, Width 20mm, Length 90mm

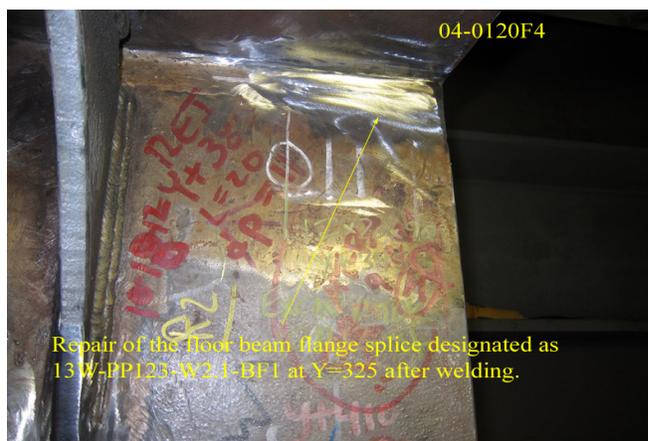
The ABF welder Wai Kit Lai was observed later in the shift performing Shielded Metal Arc Welding (SMAW) in the 2G position utilizing the Caltrans approved Welding Procedure Specifications ABF-WPS-D1.5-1000-Repair. The weld and surrounding area was brought to temperature by the use of a gas torch and maintained throughout the welding process. Due to the second time repair at this location an approval for repair document was not required.

The QAI spent a portion of this shift reviewing and documenting the status and completion of various production welding tracking logs for lift 13W-14W drop-in deck work currently in-process. The QA recorded the information on the OBG tracking log.

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

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Reviewed By: Reyes,Danny

QA Reviewer