

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-028654**Date Inspected:** 23-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:** See below.**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 (QA) Fritz Belford 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:

OBG 12W

Welder Chris Bruce #8901:

Welder was observed performing weld repairs on welds 12W PP116.5 W2.1-BW2 and 12W PP114.5 W2.1-BW2, on Ultrasonic Testing (UTSW) rejected indications noted by QC Inspectors. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1004-Repair for Shielded Metal Arc Welding (SMAW). The welder preheated the welds prior to Carbon Arc Gouging (CAG) and welding. Other welding parameters as verified by QC Inspector John Hays appear to be in compliance with the WPS noted above.

OBG 13W

Welder Eric Sparks #3040:

Welder was observed performing weld repairs on weld 13W W2.3 from face A and B at Y locations 1175 and 1200 in way of Ultrasonic Testing (UTSW) rejected indications noted by QC Inspectors. The welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1004-Repair for Shielded Metal Arc Welding (SMAW) as per Request for Weld Repair (RWR) 201210-14 FD. The welder preheated the weld prior to Carbon Arc Gouging (CAG) and welding. A Post Weld Heat Treatment of 450 degrees was maintained for 1 hour

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after weld completion. Other welding parameters as verified by QC Inspector Bernard Docena appear to be in compliance with the WPS noted above.

Non-Destructive Testing (NDT)

This QA performed Visual and Magnetic Particle Testing on the following:

Deck Access Hole Weld at 13E PP124.5 E5-DAH

- QA 100% Verification (4370mm Face A, MPT Accept.)

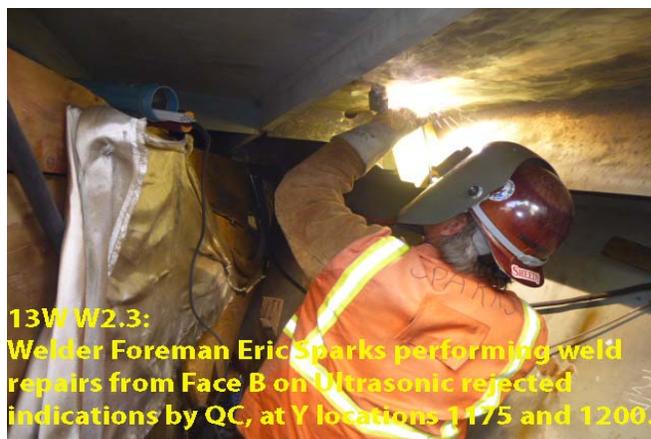
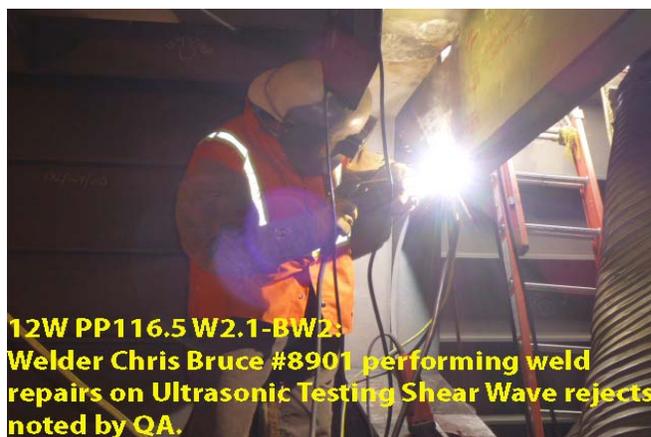
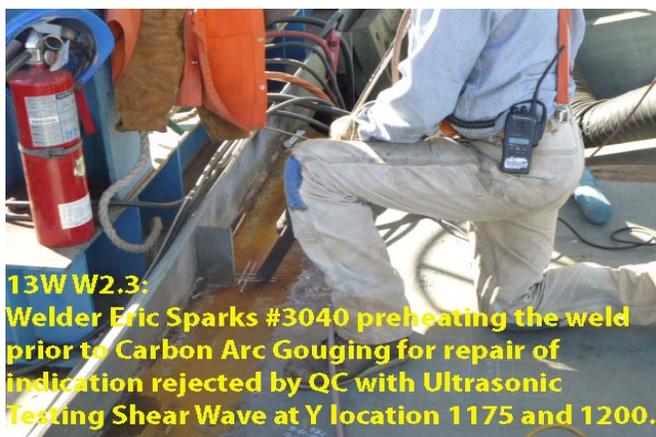
Deck Weld 13W W2.3:

- Y location 1175 - Repair Excavation (70 x 20 x 7 Deep Face B, MPT Accept.)

- Y location 1175 - Repair Excavation (50 x 20 x 12 Deep Face A, MPT Accept.)

This QA Inspector completed the report form TL-6028 on this date noting items acceptance or rejection as per applicable code. The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

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



Summary of Conversations:

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Conversation was relevant to work during this shift.

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:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
