

**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-028704**Date Inspected:** 06-Nov-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:

**Welder Xiao Hua Luo #1291:**

Welder was observed performing exterior weld repairs on weld W2 PP13.5 W5 DAH at Y locations 3515, 3580, 3620 on Ultrasonic Testing (UTSW) rejected indications noted by QC Inspectors. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1000 Rev.1 for Shielded Metal Arc Welding (SMAW). The welder preheated the weld prior to welding. Other welding parameters as verified by QC Inspector Fred Michaels appear to be in compliance with the WPS noted above.

**Welder Eric Sparks #3040:**

Welder was observed performing exterior weld repairs on weld 12W PP116.5 W5-DAH on Ultrasonic Testing (UTSW) rejected indications noted by QC Inspectors. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1000 Rev.1 for Shielded Metal Arc Welding (SMAW). Welding parameters as verified by QC Inspector Chris Concha appear to be in compliance with the WPS noted above. Welder was also observed grinding on East & West Hinge K Pipe Beams on lifting lug weld attachment areas rejected with Magnetic Particle Testing. Areas were rejected by QC Inspectors. QC Bernard Docena was the QC Inspector onsite.

Non-Destructive Testing (NDT)

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

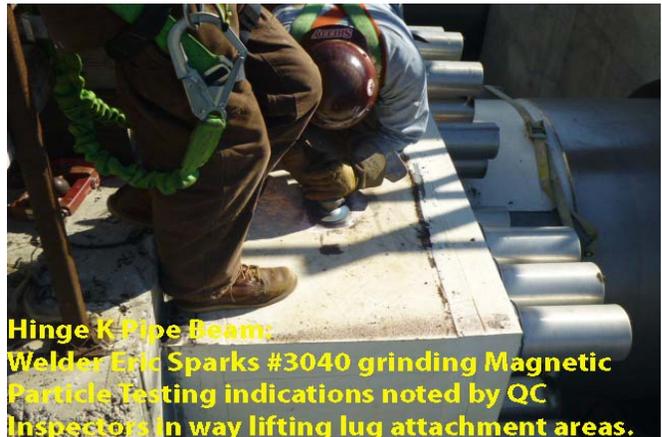
This QA performed Ultrasonic Testing Shear Wave (UTSW) on the following:

12W W2.1-A1:

- Y location 20,000-32,500 (UTSW Accept.)

This QA Inspector completed the report form TL-6027 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:

Conversations as per scope of work.

### 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.

---

<b>Inspected By:</b>	Belford,Fritz	Quality Assurance Inspector
----------------------	---------------	-----------------------------

---

<b>Reviewed By:</b>	Reyes,Danny	QA Reviewer
---------------------	-------------	-------------