

**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-028705**Date Inspected:** 03-Nov-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:** Steve Jensen**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:

13W Deck Access Hole Splice (Weld No. DAH-13W-PP124.5-W5)

The QAI was provided the approval for repair document history for this weld by the QA task leader, for ultrasonic verification and closure of the listed repair documents at the following locations;

Y=120 RWR-201209-103  
Y=1180 RWR-201209-137  
Y=1135 RWR-201209-137  
Y=1275 RWR-201210-040  
Y=1360 RWR-201209-137  
Y=1715 RWR-201209-104  
Y=2490 RWR-201209-136  
Y=2490 RWR-201209-137  
Y=2600 RWR-201210-043  
Y=2700 RWR-201210-006  
Y=3320 RWR-201209-137  
Y=3690 RWR-201209-137  
Y=3860 RWR-201209-137

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No rejectable indications were observed at the time of inspection.

### Magnetic Particle Testing (OBG 13E)

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

### 13W Deck Access Hole Splice (Weld No. DAH-13W-PP124.5-W5)

The QAI was provided the approval for repair document history for this weld by the QA task leader, for magnetic particle verification and closure of the listed repair documents at the following locations;

Y=120 RWR-201209-103  
Y=1180 RWR-201209-137  
Y=1135 RWR-201209-137  
Y=1275 RWR-201210-040  
Y=1360 RWR-201209-137  
Y=1715 RWR-201209-104  
Y=2490 RWR-201209-136  
Y=2490 RWR-201209-137  
Y=2600 RWR-201210-043  
Y=2700 RWR-201210-006  
Y=3320 RWR-201209-137  
Y=3690 RWR-201209-137  
Y=3860 RWR-201209-137

No rejectable indications were observed at the time of inspection.

The QAI observed at random intervals ABF/JV welder Eric Sparks performing Carbon Arc Gouging (CAG) for the repair of the deck access hole splice designated as DAH-12E-PP116.5-E5. The ABF/JV QC inspector Steve Jensen was observed performing magnetic particle testing (MT) in way of the completed repair excavation at the following locations,

### DAH-12E-PP116.5-E5

Y=850, Depth 5, Width 15mm, Length 140mm  
Y=1285, Depth 6, Width 25mm, Length 55mm  
Y=1520, Depth 7, Width 18mm, Length 85mm  
Y=1825, Depth 7, Width 20mm, Length 95mm  
Y=2430, Depth 8, Width 20mm, Length 125mm

The ABF welder Erick Sparks was 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 QAI observed a post weld heat treatment of 450°F for one hour as required by the applicable repair document. The repairs were performed in accordance

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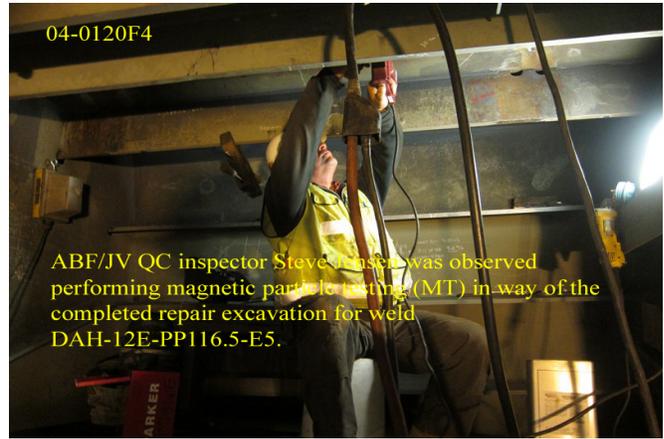
with the following approval for repair documents;

- Y=850-RWR201210-029
- Y=1285-RWR201210-026
- Y=1520-RWR201210-027
- Y=1825-RWR201210-028
- Y=2430-RWR201210-033

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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**Inspected By:** Patterson,Rodney

Quality Assurance Inspector

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**Reviewed By:** Reyes,Danny

QA Reviewer