

**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-028718**Date Inspected:** 07-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:** Barry Drake**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:

**Magnetic Particle Testing (OBG 12E)**

This QA Inspector performed verification Magnetic Particle Testing (MT) of the lift 13E deck-drop-in repair locations rejected ultrasonically during the QA recordable verification. This QA Inspector generated a TL-6028 MT report on this date. The results of the inspection are as follows;

**13E Deck Drop-in Transverse Splice (Weld No. 13E/14E-A1)**

The QAI performed magnetic particle testing of this weld from face A/B in way of repairs at Y=1715. No rejectable indications were observed at the time of inspection.

**13E Deck Drop-in Transverse Splice (Weld No. 13E-PP121.6)**

The QAI performed magnetic particle testing of this weld from face A/B in way of repairs at Y=1800 and Y=1885. No rejectable indications were observed at the time of inspection.

**13E Deck Drop-in Transverse Splice (Weld No. 13E-PP120.6)**

The QAI performed magnetic particle testing of this weld from face A/B in way of repairs at Y=850. No rejectable indications were observed at the time of inspection.

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# WELDING INSPECTION REPORT

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The QAI observed at random intervals ABF welder Rick Clayborn #2773 performing Shielded Metal Arc Welding (SMAW) in the 1G position utilizing the Caltrans Welding Procedure Specifications ABF-WPS-D1.5-1040A. The weld is a complete joint penetration butt weld with backing, between the OBG tie plate and the bike path cantilever top plate designated as 14E-PP128 BPB-2. The weld and surrounding area was brought to a temperature of 150°F by the use of a gas torch and maintained throughout the welding process. The weld connection was observed to be incomplete at the end of the shift.

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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<b>Inspected By:</b>	Patterson,Rodney	Quality Assurance Inspector
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<b>Reviewed By:</b>	Reyes,Danny	QA Reviewer
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