

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-028776**Date Inspected:** 26-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 Rick Chouinard #8959:

Welder was observed performing R1 exterior weld repairs on weld 12W W2.1-C1 indications rejected with Ultrasonic Testing (UTSW) by QC Inspectors between Y 30,000 and 31,000. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1000 Repair for Shielded Metal Arc Welding (SMAW). Welder was observed preheating the weld prior to welding. Welding parameters as verified by QC Inspector William Sherwood appear to be in compliance with the WPS noted above. Weld sections at Y 18,600 to 31,000 is non SPCM, a "Request for Weld Repair" or (RWR) is not required for R1 repairs.

Welder Wai Kit Lai #2953:

Welder was observed performing R1 exterior weld repairs on weld 12W W2.1-C1 indications rejected with Ultrasonic Testing (UTSW) by QC Inspectors between Y 25,800 and 26,800. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1000 Repair for Shielded Metal Arc Welding (SMAW). Welder was observed preheating the weld prior to welding. Welding parameters as verified by QC Inspector William Sherwood appear to be in compliance with the WPS noted above. Weld sections at Y 18,600 to 31,000 is non SPCM, a "Request for Weld Repair" or (RWR) is not required for R1 repairs.

Welder Deli Zhang #4735:

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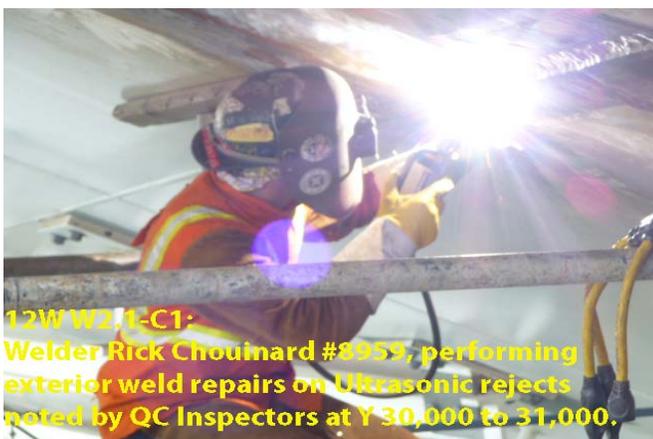
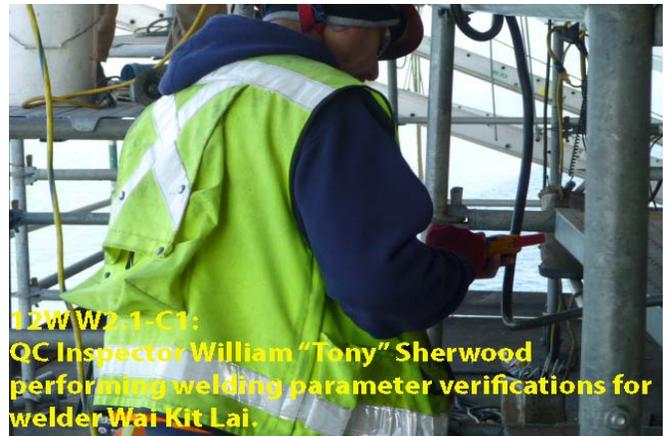
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Welder was observed performing exterior “Base Metal Repairs” surrounding weld 12E PP109.5 E2.1-DAH. Indications noted were rejected with Magnetic Particle Testing (MPT) by QA Inspectors. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1004 Repair for Shielded Metal Arc Welding (SMAW) as per “Request for Weld Repair” (RWR) 201211-029 thru 031. Welder was observed maintaining proper temperatures for preheat, interpass and post weld heat treatment as per WPS. Welding parameters as verified by QC Inspector Salvador Merino appear to be in compliance with the WPS noted above.

Welder Eric Sparks #3040:

Welder was observed performing exterior weld repairs on “A” Deck weld 13E E2.1 on indications rejected with Ultrasonic Testing (UTSW) by QC Inspectors. 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) 201210-052. Welder was observed maintaining proper temperatures for preheat, interpass and post weld heat treatment as per WPS. Welding parameters as verified by QC Inspector John Hays appear to be in compliance with the WPS noted above.

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



Summary of Conversations:

Conversations this day as required for scope of work.

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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
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Reviewed By:	Reyes,Danny	QA Reviewer
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