

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-028777**Date Inspected:** 20-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 Chris Bruce #8901:

Welder was observed performing interior weld repairs on weld 12E E2.1-C1 indications rejected with Ultrasonic Testing (UTSW) by QC Inspectors between Y 22,000 and 23,000. 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 section is non SPCM weld section.

Welder Mike Jimenez #4671:

Welder was observed performing interior weld repairs on weld 12E E2.1-C1 indications rejected with Ultrasonic Testing (UTSW) by QC Inspectors at Y 12,000. 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) 201210-016. 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 section is an SPCM weld section.

Welder Eric Sparks #3040:

Welder was observed performing Carbon Arc Gouging (CAG) on weld 13E PP123 E2.8-BF3. This QA witnessed

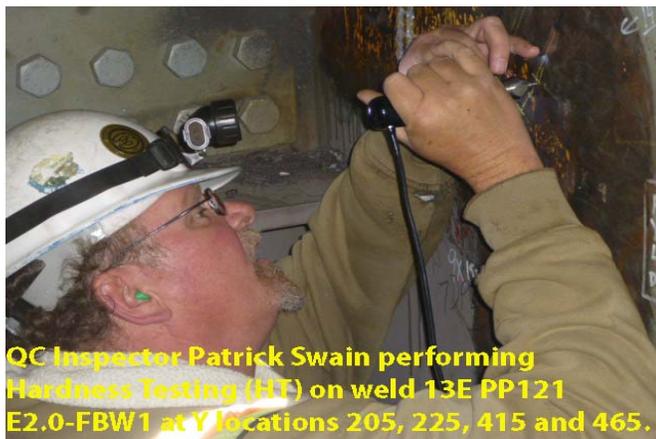
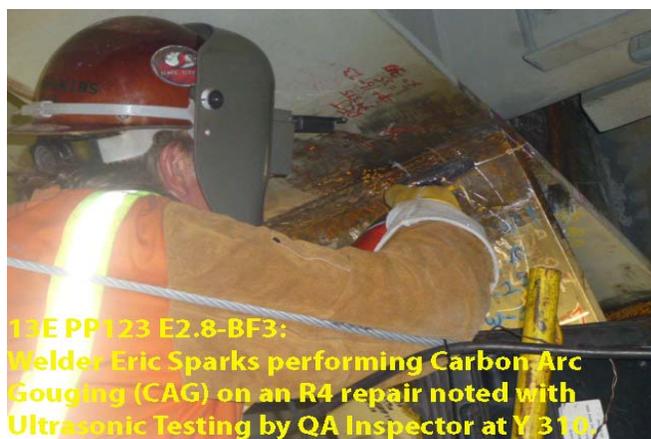
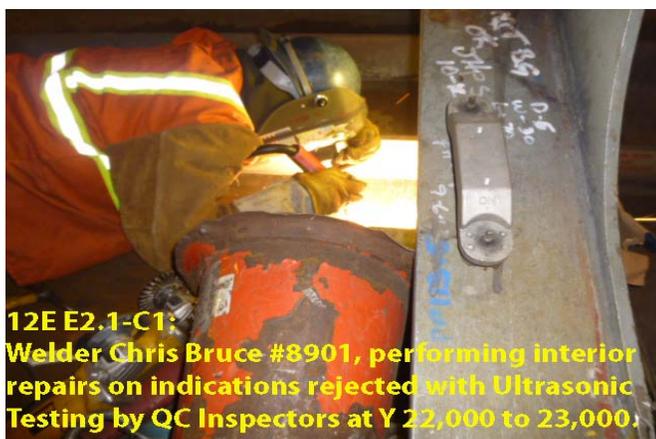
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the R4 excavation of the indication rejected with Ultrasonic Testing (UTSW) by QA Inspector at Y 310 as per Request for Weld Repair (RWR) 201210-045. Welder was then observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1004 Repair for Shielded Metal Arc Welding (SMAW). Welder was observed preheating the weld prior to welding. Welding parameters as verified by QC Inspector John Pagliero appear to be in compliance with the WPS noted above.

This QA also witnessed QC Inspector Patrick Swain perform Hardness Testing (HT) on weld 13E PP121 E2.0-FBW1. Hardness measurements were taken at 3mm on centers at baseline Y 205 and repair Y 225; and baseline Y 418 and repair Y 465.

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.

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