

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-028790
Date Inspected: 28-Nov-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Job Site

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|------------------------------------|----------------|----------------------------------|---------|--------|
| CWI Name: | As noted 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: | SAS OBG | |

Summary of Items Observed:

Quality Assurance Inspector (QA) Douglas Frey 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:

This QA observed the following welders working in OBG 12E and performed NDT testing at various locations:

ABF welder Mike Jimenez #4671 was observed performing ongoing weld repairs on weld 12E-E2.1-C1.1 at y=17, 940mm. The dimensions of the excavation were noted as 75L/20W/6D. At y=18,780mm; the dimensions of the excavation were noted as 70L/20W/10D. At y=18,800mm; the dimensions of the excavation were noted as 110L/25W/11D. The welder was observed utilizing WPS ABF-WPS-D15-1004-Repair-Revision 0 for SMAW. The welder was observed preheating the welds prior to Carbon Arc Gouging and welding. Other welding parameters as inspected by the QC Inspector appeared to be in compliance with the WPS noted above. RWR-201210-016 was referenced during this weld repair.

This QA Inspector performed Magnetic Particle (MT) testing on the welds listed below. This QA Inspector performed MT testing utilizing the yoke method in conformance with ASTM E 709 and the standard of acceptance with D1.5 section 6.26.2.1. This QA Inspector noted that no rejectable indications were found at the time of testing.

This QA Inspector generated a TL-6028 MT report on this date. The completed work at this location appeared to be in general conformance with the contract specifications.

This QA Inspector performed an Ultrasonic (UT) inspection on the welds listed below with their applicable

WELDING INSPECTION REPORT

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RWR's. This QA Inspector noted that no rejectable indications were found at the time of testing. These welds were previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. This QA generated a TL-6027 UT report on this date. The testing was performed in accordance with AWS.D1.5-2002 Section 6, table 6.3.

13E PP120.5-E2.0-BW1- 201209-069 / 201209-070

13E PP121-E2.0-FBW1 / FBW2-R1 no RWR required

13E PP121.5-E2.0-BW1 - R1 no RWR required

13E PP120-E2.0-FBW1 – 201208-100 / 201208-101 / 201210-046 / 201210-047 / 201210-048

13E PP120-E2.0-FBW2 - 201209-069 / 201209-070

This QA observed QC Inspector William Sherwood and Salvador Merino performing welding parameter checks such as voltage, amps, electrodes and preheats throughout the day. This QA also observed QC Inspector's John Pagliero and Bernie Docena performing various Non-Destructive Testing (NDT) on completed weld repairs as they became available for testing. Non-Destructive Testing methods utilized by the QC Inspectors were Visual Testing (VT), Magnetic Particle Testing (MPT) and Ultrasonic Testing Shear Wave (UTSW). QC Inspectors were observed performing inspection per applicable code and or contract criteria.

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

Summary of Conversations:

Conversations with QC Inspector Salvador Merino on welds available for turnover in 13E drop-in panel.



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: | Frey,Doug | Quality Assurance Inspector |
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| Reviewed By: | Reyes,Danny | QA Reviewer |
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