

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-028791**Date Inspected:** 29-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:** 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 12W at various locations:

ABF welder Mike Jimenez #4671 was observed performing ongoing weld repairs on weld 12E-E2.1-C1.1 at y=12, 900mm. The dimensions of the excavation were noted as 60L/20W/8D. 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.

ABF welder Chris Bruce #8901 was observed performing ongoing weld repairs on weld 12W-W2.1-C1.1 at y=24, 370mm to 24,050mm. The dimensions of the excavation were noted as 320L/45W/10D. At 23,770mm to 23,000mm; the dimensions of the excavation were noted as 770L/45W/12D. The welder was observed utilizing WPS ABF-WPS-D15-1000-Repair-Revision 2 for SMAW. The welder was observed preheating the welds prior to Carbon Arc Gouging and welding. Other welding parameters as inspected by QC Inspector appeared to be in compliance with the WPS noted above. RWR-201211-005 was referenced during this weld repair.

ABF welder Wai Kit Lai #2953 was observed performing ongoing weld repairs on weld 12W-W2.1-C1.1 from y=28,420mm to 29,320mm. The welder was observed utilizing WPS ABF-WPS-D15-1000-Repair-Revision 2 for

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW. The welder was observed preheating the welds prior to Carbon Arc Gouging and welding. Other welding parameters as inspected by QC Inspector appeared to be in compliance with the WPS noted above.

RWR-201211-005 was referenced during this weld repair.

ABF welder Richard Chouard #8959 was observed performing ongoing weld repairs on weld 12W-W2.1-C1.1 at y=15,000mm to 14,000mm. The dimensions of the excavation were noted as 1000L/42W/10D. 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-201211-005 was referenced during this weld repair.

This QA Inspector performed an Ultrasonic (UT) lamination (0°) inspection on the lifting lug removal sites at Hinge K East #1 and 2, and Hinge K West #3 and 4. This QA Inspector noted that no rejectable indications were found at the time of testing. These welds were previously accepted by QC Ultrasonic technicians.

This QA Inspector randomly observed QC Inspector Patrick Swain perform hardness testing of the weld at 13E PP123-E2.8-BF3 on the interior of the OBG. The QC Inspector recorded the readings at the location of an R5 in order to apply for an RWR.

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 QA Inspector Joselito Lizardo concerning the Hinge K east and west NDT testing.



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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

your project.

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