

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-028792**Date Inspected:** 28-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 R1 exterior weld repairs on weld 12W W2.1-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 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 Rick Clayborn #2773:

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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 28,000 and 29,000. Welder was observed Carbon Arc Gouging (CAG) the weld only before relocating to another area. Welder utilized Welding Procedure Specification (WPS) ABF-WPS-D15-1000 Repair for Shielded Metal Arc Welding (SMAW). Welder was observed preheating the weld prior to Carbon Arc Gouging. Excavation parameters as verified by QC Inspector William Sherwood appear to be in compliance with the WPS noted above. Weld section at Y 18,600 to 31,000 is non SPCM, a "Request for Weld Repair" or (RWR) is not required for R1 repairs.

Welder Jin Quan Huang #9340:

Welder was observed welding Drip Edge Plates at Panel Point 117 to the "C" side plate. Welder was observed utilizing Welding Procedure Specifications (WPS) ABF-WPS-D15-1030 Rev.1 for the splice butt weld between Drip Edge Plates and (WPS) ABF-WPS-D15-F1200A Rev.2 for attachment welds to the "C" side plate. 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.

Non-Destructive Testing (NDT)

This QA performed Visual (VT) and Magnetic Particle Testing (MPT) on the following:

Weld 12W W2.1-C1:

- Exterior Excavation 1000 x 45 x 10 Deep at Y 18,000 to 19,000 (Accept)

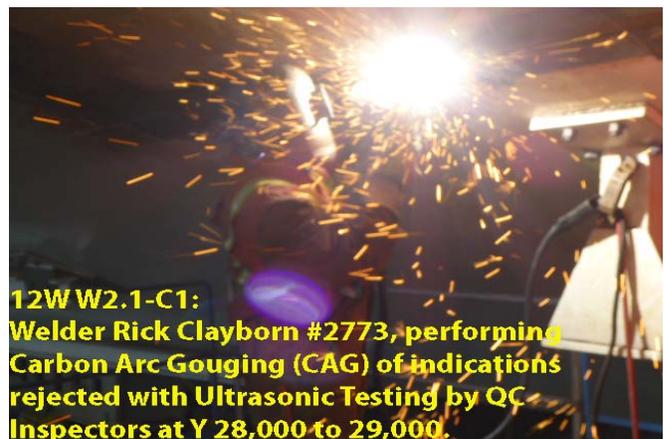
Hardness Testing on the following:

Weld 13E PP121 E2.1-FBW1

- Y locations 205 and 418. (Readings left in machine as per Engineers)

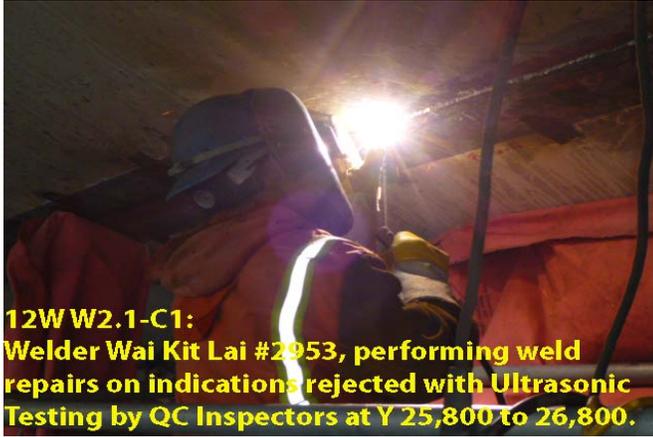
This QA Inspector completed the report form TL-6028 on this date noting items acceptance or rejection as per applicable code. The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

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



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12W W2.1-C1:
Welder Wai Kit Lai #2953, performing weld repairs on indications rejected with Ultrasonic Testing by QC Inspectors at Y 25,800 to 26,800.



12W W2.1-C1:
QC Inspector William Sherwood performing Magnetic Particle Testing (MPT) on weld excavation at Y 18,000 to 19,000 prior to welding.

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.

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