

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-028799
Date Inspected: 14-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

CWI Name:	N/A	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 (QAI) Rodney Patterson 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:

The QAI witnessed the ABF QC inspector Patrick Swain perform UCI (Ultrasonic Contact Impedance) hardness tests on the base material, theoretical heat affected zone and weld metal on the deck panel drop-in splice for lift 13W and deck access hole for lift 8W. The hardness measurements taken by ABF QC on this date were recorded in Brinell hardness values at 3mm intervals at the following locations.

Lift 8W Deck Access Hole (Weld No. DAH-8W-PP61.5-W2)

Y=290 Baseline hardness measurements taken.

Y=2710 Hardness measurements taken prior to fifth time repair.

Lift 13W Deck Drop-in Longitudinal Splice (Weld No. 13W-W2.1)

Y=2230 Baseline hardness measurements taken for comparison.

Y=2480 Hardness measurements taken after repair for closure of heat transfer non-conformance.

Y=3550 Baseline hardness measurements taken for comparison.

Y=5200 Hardness measurements taken after repair for closure of heat transfer non-conformance.

The QAI, along with QA inspector William Clifford proceeded to take confirmation hardness measurements no less than 3mm adjacent to those taken by ABF QC inspectors.

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The average of the hardness values taken by both QC and QA on this date appeared to below the maximum provided by the Caltrans Structural Materials Representative (SMR). The SMR was provided a list of the measurements taken on this date for further evaluation.

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

Summary of Conversations:

Conversations relevant to the work being performed.

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:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
