

**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-028832**Date Inspected:** 01-Dec-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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 12W-W2.1-C1.1 at y=7, 200mm. 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.

ABF welder Chris Bruce #8901 was observed performing ongoing weld repairs on weld 12W-W2.1-C1.1 at y=24, 350mm. 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 QC Inspector appeared to be in compliance with the WPS noted above. RWR-201211-005 was referenced during this weld repair.

ABF welder Rick Clayborn #2773 was observed performing ongoing weld repairs on weld 12W-W2.1-C1.1 at y=15,090mm. The dimensions of the excavation were noted as 360L/55W/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

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

---

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.

ABF welders Xiao Hua Luo #1291 and Jin Quan Huang #9340 were observed performing weld repairs on the cradle to OBG contact points at 10E PP86. The welders were observed utilizing WPS ABF-WPS-D1. 5-1000-R-Revision 2 for SMAW. The welders were observed preheating the welds prior to welding. Other welding parameters as inspected by the QC Inspector appeared to be in compliance with the WPS noted above.

ABF welders Deli Zhang #4735 and Gue Wu Chen #1556 were observed performing weld repairs on the cradle to OBG contact points at 10W PP92 and 10W PP100. The welders were observed utilizing WPS ABF-WPS-D1. 5-1000-R-Revision 2 for SMAW. The welders were observed preheating the welds prior to welding. Other welding parameters as inspected by the QC Inspector appeared to be in compliance with the WPS noted above.

This QA Inspector performed an Ultrasonic (UT) inspection on the welds listed below. 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. No RWR was needed for these R1 weld repairs.

13W PP122.5-W2.1-BF1 / 13W PP122.5-W2.1-BW1 / 13W PP122.5-W2.8-BW1 / 13W PP123-W2.1-BF2 / 13W PP124.5-W2.2-BW1.

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 were relevant to work performed.



---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

## 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.

---

<b>Inspected By:</b>	Frey,Doug	Quality Assurance Inspector
----------------------	-----------	-----------------------------

---

<b>Reviewed By:</b>	Reyes,Danny	QA Reviewer
---------------------	-------------	-------------