

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-028850**Date Inspected:** 11-Dec-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 Mike Jimenez #4671:

Welder was observed performing an R5 weld repair on weld 13W WK-SK1 indication rejected with Ultrasonic Testing (UTSW) by QC Inspector at Y 1485. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1004 Repair for Shielded Metal Arc Welding (SMAW) as per "Request for Weld Repair" or (RWR) 201211-037. Welding parameters as verified by QC Inspector Salvador Merino appear to be in compliance with the WPS noted above. Excavation of the rejected indication was witnessed both by this QA and QC Inspector S. Merino.

Welder Wai Kit Lai #2953:

Welder was observed performing R1 interior weld repairs on weld 12W W2.1-C1 indications rejected with Ultrasonic Testing (UTSW) by QC Inspectors between Y 11770 and 14210. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1004 Repair for Shielded Metal Arc Welding (SMAW) as per "Request for Weld Repair" or (RWR) 201211-005. Welding parameters as verified by QC Inspector William Sherwood appear to be in compliance with the WPS noted above.

Welder Rick Chouinard #8959:

Welder was observed performing R1 exterior weld repairs on weld 12W W2.1-C1 indications rejected with

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Ultrasonic Testing (UTSW) by QC Inspectors between Y 3000 and 3700. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1004 Repair for Shielded Metal Arc Welding (SMAW) as per "Request for Weld Repair" or (RWR) 201211-005. 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 Magnetic Particle Testing (MPT) on the following:

Weld 12W W2.1-A1:

- MPT Face A at Y 1570 to 1590. (VT & MPT Accept.)

Weld 12E E2.1-A1:

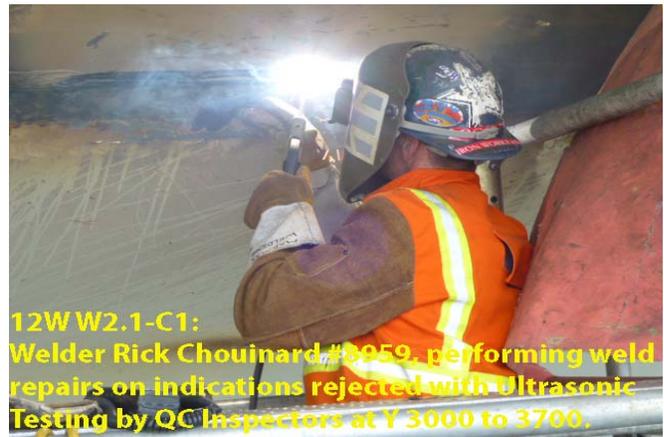
- MPT Interior Side at Y 0 to 14000. (VT & MPT Accept.)

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.



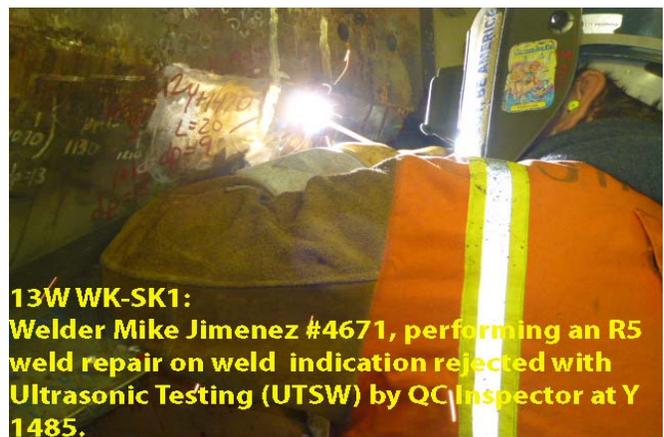
13W WK-SK1:
Welder Mike Jimenez #4671, preheating the weld prior to welding the repair at Y 1485.



12W W2.1-C1:
Welder Rick Chouinard #8959, performing weld repairs on indications rejected with Ultrasonic Testing by QC Inspectors at Y 3000 to 3700.



13W WK-SK1:
QC Inspector Salvador Merino performing welding parameter checks on welder Mike Jimenez as welder is welding.



13W WK-SK1:
Welder Mike Jimenez #4671, performing an R5 weld repair on weld indication rejected with Ultrasonic Testing (UTSW) by QC Inspector at Y 1485.

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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
