

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-028861
Date Inspected: 11-Dec-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:	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 the Tower and the OBG at various locations:

FW Spencer welder Damien Llamas # 6645 was observed performing SMAW welding on shear lugs to 2.5" schedule 40 pipe at 3W PP20 on the exterior of the OBG. The welder was observed utilizing WPS FWS-Fillets Murex for SMAW. The welder was 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 welder Richard Garcia was observed performing SMAW welding on A1.1, A1.2, A1.3 and A1.4 butt joint welds on the west face of the tower 160m elevation. The welder was observed utilizing WPS ABF-D1.5-F1200A for SMAW. The welder was 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 welder Rick Clayborn #2773 was observed performing weld repairs on weld 13E-E2.1 at y=8440mm. The dimensions of the excavation were noted as; 80L/25W/12D. 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.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This QA Inspector performed an Ultrasonic (UT) inspection on 12E-E2.1-C1.1 from 0mm to 8000mm. This QA Inspector recorded a rejectable indication at y=70mm. 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. RWR 201211-013 is applicable to this weld.

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.



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