

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-028902**Date Inspected:** 14-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 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 at Y 0 to 1850. 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 Mike Jimenez #4671:

Welder was observed performing R1 interior weld repairs on weld 12W W2.1-C1 indications rejected with Ultrasonic Testing (UTSW) by QC Inspectors at Y 22000 to 24000. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1000 Repair for Shielded Metal Arc Welding (SMAW). Welding parameters as verified by QC Inspector William Sherwood appear to be in compliance with the WPS noted above. Non SPCM weld section, "Request for Weld Repair" or (RWR) not required for R1 repairs.

Welder Damian Llanos (FW Spencer Welder):

Welder was observed welding 2.5" diameter pipe welds 10/2/42.5/T53 & 11/2/42.5/T53 for the East Side of the Tower to be installed at the 53M Tower elevation utilizing Welding Procedure Specifications (WPS) 1-12-1.

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Welding parameters as verified by QC Inspector Harry Sharein appear to be in compliance with the WPS noted above.

Non-Destructive Testing (NDT)

This QA performed Visual, Magnetic Particle and Ultrasonic Testing on the following:

Weld 13W PP122.5 W2.8-BF1:

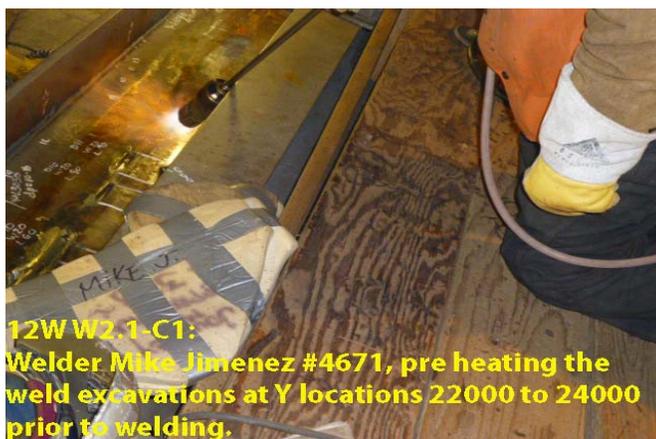
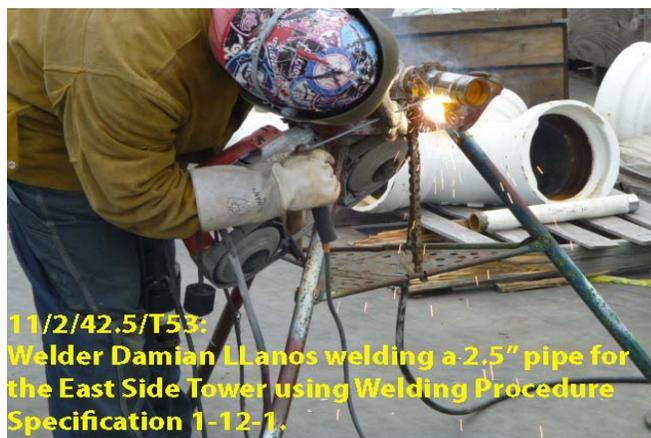
- Y 850 Repair only. (Accept.)

Weld 13W PP123 W2.8-BF2:

- Y 145 Repair only. (QA UT Reject & Confirmed by QC)

This QA Inspector completed the report form TL-6028 & TL-6027 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.



Summary of Conversations:

Conversations this day as required for scope of work.

Comments

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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
