

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-028912
Date Inspected: 27-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:	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 welding the deck stiffener fillet welds to the deck access hole in way of the 12W PP109.5 W2-DAH deck access hole. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A 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.

Welder Rick Clayborn #2773:

Welder was observed performing R1 weld repair on weld 13W PP122.2 LS5-TSA & TSB indications rejected with Ultrasonic Testing (UTSW) by QC Inspectors. 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.

Welder Mike Jimenez #4671:

Welder was observed performing R1 weld repairs on weld 13W PP122 W2-BF1 indication rejected with Ultrasonic Testing by QA Inspector. 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

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Inspector William Sherwood 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 12W PP116.5 W5-DAH:

- 100% Visual and MPT (Accept.)
- 50% UT at Y 1370 to 3835 (Accept.)

Weld 12E PP116.5 E5-DAH:

- 50% UT at Y 2190 to 4380 (Accept.)

Weld 13E PP122 E2.5-BF1:

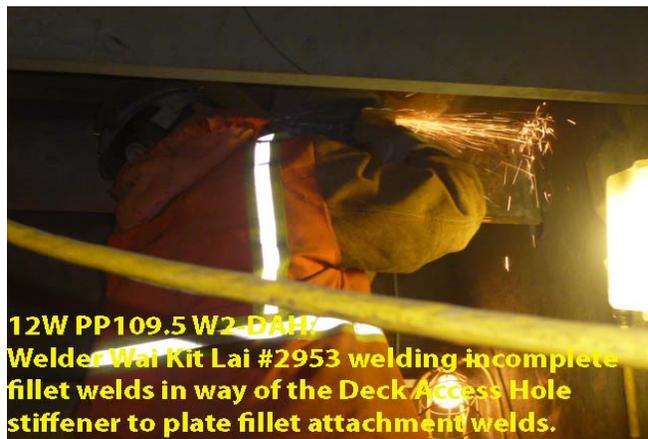
- 100% UT (Accept.)

Weld 13E E2.8:

- Additional 20% UT at Y 6000 to 8500 (Accept.)

This QA Inspector completed the report forms TL6028 and 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

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

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Reviewed By: Reyes,Danny

QA Reviewer