

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-028950**Date Inspected:** 07-Jan-2013**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 R2 weld repairs on weld 12W W2.1-C1 indications rejected with Ultrasonic Testing by QC Inspector at Y 15700 thru 17900 on the interior side of weld. 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 (RWR) 201301-013, 014 & 015. 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 Carbon Arc Gouging (CAG) exterior temporary Transverse Strongback Lugs in way 14E PP128 E5.0 in order to prepare the base metal for Magnetic Particle Testing (MPT) where the lugs were temporarily attached. Welder was observed by QC Inspector Salvador Merino.

Welder Mike Jimenez #4671:

Welder was observed performing R2 weld repairs on weld 12W W2.1-C1 indications rejected with Ultrasonic Testing by QC Inspector at Y 11850, 11970 & 12770 on the interior side of weld. 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 (RWR) 201301-016. Welding parameters as verified by QC Inspector William

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Sherwood appear to be in compliance with the WPS noted above.

Welder Eric Sparks #3040:

Welder was observed performing weld repairs on welds:

- 13W PP122.2 LS4-TSA & TSB.
- 13WPP122.2 LS5-TSA, TSB, TSC & TSD.
- 13W PP122.2 LS6-TSA & TSB.

The Visual Indications rejected were noted by QC Inspector and were ground and weld repaired 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. Welds are non SPCM, RWR not required.

Non-Destructive Testing (NDT)

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

Weld 2W PP13.5 W2.0-DAH:

- o QA UT Verification (UT Accept)

Location 13W PP122.2 LS4:

- o Weld DSFN (VT, MPT Accept)
- o Weld DSFS (VT, MPT Accept)
- o Weld TSA (VT, MPT Accept)
- o Weld TSB (VT, MPT Accept)

Location 13W PP122.2 LS5:

- o Weld DSFN (VT, MPT Accept)
- o Weld DSFS (VT, MPT Accept)
- o Weld TSA (VT, MPT Accept)
- o Weld TSB (VT, MPT Accept)
- o Weld TSC (VT, MPT Accept)
- o Weld TSD (VT, MPT Accept)

Location 13W PP122.2 LS6:

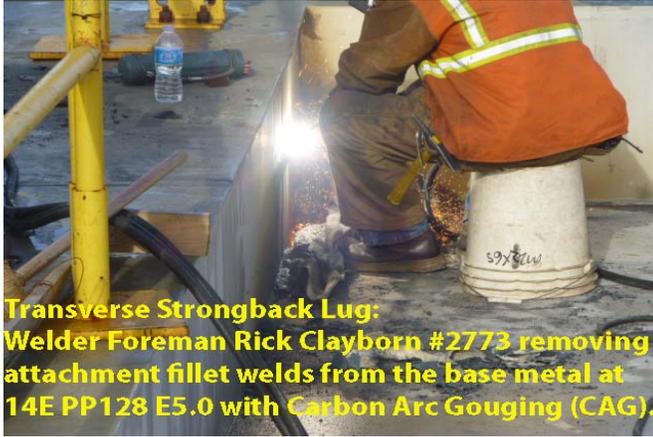
- o Weld DSFN (VT, MPT Accept)
- o Weld DSFS (VT, MPT Accept)
- o Weld TSA (VT, MPT Accept)
- o Weld TSB (VT, MPT Accept)

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.

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Transverse Strongback Lug:
Welder Foreman Rick Clayborn #2773 removing attachment fillet welds from the base metal at 14E PP128 E5.0 with Carbon Arc Gouging (CAG).



13W PP128.2 LS5-TSA:
Welder Eric Sparks #3040, preheating the weld prior to welding.

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.

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| Inspected By: | Belford,Fritz | Quality Assurance Inspector |
| Reviewed By: | Reyes,Danny | QA Reviewer |
