

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-028967**Date Inspected:** 11-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:

This QA was tasked with checking the tracking records of the welding in the OBGs. Weld Visual, Magnetic Particle and Ultrasonic Test reports were compared to the tracking record to ensure all welds that were marked complete had documentation of the inspection and types inspections performed. Discrepancies were noted between the records and reports submitted and were corrected by re-inspecting the weld or by contacting the QA inspector involved to submit the appropriate report. This is an on going process to be completed as time and schedule allows.

Welder Richard Garcia #5892:

Welder was observed tack welding the platform handrails to the platform above the curve diaphragm at the top of the Tower utilizing Welding Procedure Specifications (WPS) ABF-WPS-D15-F2200-1. Welding parameters as verified by QC Inspector Fred Michaels appear to be in compliance with the WPS noted above.

Welder Wai Kit Lai #2953:

Welder was observed welding the PJP seal weld SS-A welding the "F" plate to the Tapped plate. Welder was observed utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1160 for Flux Core Arc Welding (FCAW). Welding parameters as verified by QC Inspector Fred Michaels appear to be in compliance with the WPS noted above.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Welder Damian Llanos (FW Spencer Welder):

Welder was observed welding the 3" diameter pipe weld #6645 for the South Tower above 151.000 m elevation utilizing Welding Procedure Specifications (WPS) 1-12-1 Rev.2. Welding parameters as verified by QC Inspector Barry Drake appear to be in compliance with the WPS noted above.

Non-Destructive Testing (NDT)

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

Weld 12W PP109.5 W5.0-TS:

o QA Verification (VT, MPT Accept.)

This QA Inspector completed 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.



Summary of Conversations:

Conversations this day as required for scope of work.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
---------------------	-------------	-------------