

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-029022**Date Inspected:** 17-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 welding fillet welds and PJP welds for the Retrofit Stiffeners at 13E PP119-ERS. The stiffeners mentioned above are the CCO 238 Retrofit Stiffeners to the "C" side plating. Welder was observed preheating and using Welding Procedure Specification (WPS) ABF-WPS-D15-F2200-2 for the fillet welds and 2170-3 for the partial joint penetration or PJP welds. Welding parameters were verified by QC Inspector John Hays throughout the day and appear to be in compliance with the both WPSs noted above.

Welder Mike Jimenez #4671:

Welder was observed welding fillet welds and PJP welds for the Retrofit Stiffeners at 13E PP118.5-ERS. The stiffeners mentioned above are the CCO 238 Retrofit Stiffeners to the "C" side plating. Welder was observed preheating and using Welding Procedure Specification (WPS) ABF-WPS-D15-F2200-2 for the fillet welds and 2170-3 for the partial joint penetration or PJP welds. Welding parameters were verified by QC Inspector John Hays throughout the day and appear to be in compliance with the both WPSs noted above.

Welder Rick Clayborn #2773:

Welder was observed performing weld repairs on the West Jacking Saddle Frame Assembly. The welder was observed preheating and welding utilizing Welding Procedure Specification (WPS) ABF-WPS-D15-1002 Repair

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for Shielded Metal Arc Welding (SMAW) as per Request for Weld Repair (RWR) 201111-003. Weld repair at Y 420 was excavated and Magnetic Particle Tested before welding. Welding parameters as verified by QC Inspector Patrick Swain 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:

“A” Deck Pltg Temporary Attachment Removal Visual Rejects at:

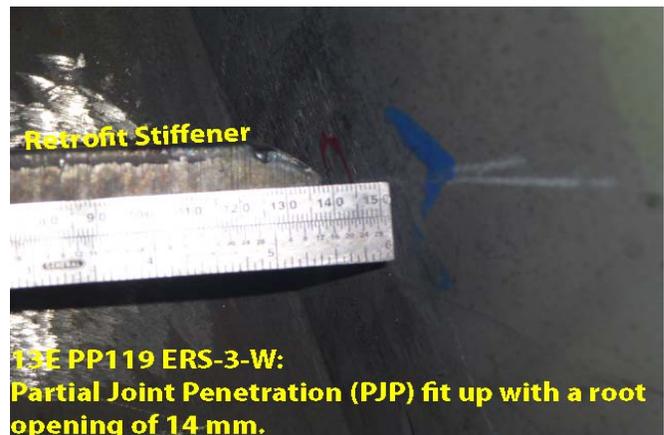
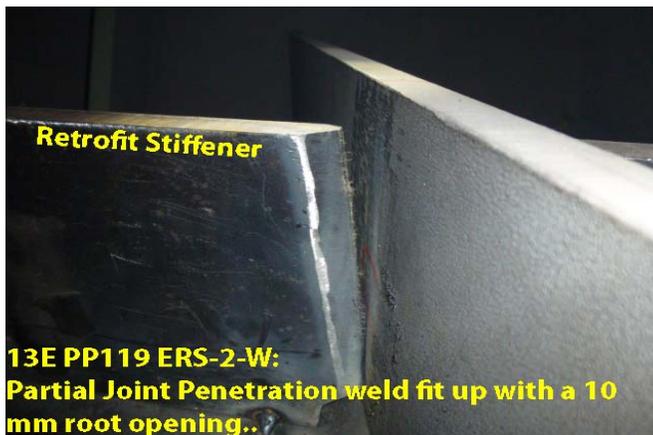
- o 13W PP121 W2.3 (160mm, VT & MPT Accept)
- o 13W PP121 W2.4 (840mm, VT & MPT Accept)
- o 13W PP121 W2.5 (820mm, VT & MPT Accept)
- o 13W PP121.5 W2.3 (120mm, VT & MPT Accept)
- o 13W PP121.6 W2.6 (50mm, VT & MPT Accept)
- o 13W PP121.6 W2.7 (60mm, VT & MPT Accept)
- o 13W PP121.7 W2.8 (2050mm, VT & MPT Accept)
- o 13W PP122 W2.5 (50mm, VT & MPT Accept)
- o 13W PP121.7 W2.7 (200mm, VT & MPT Accept)
- o 13W PP122.4 W2.9 (200, VT & MPT Accept)
- o 13W PP122.6 W3.0 (225, VT & MPT Accept)
- o 13W PP122.7 W3.0 (120, VT & MPT Accept)

- All "A" Deck repairs noted above as per RWR 201301-019.

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.

An Incident Report report was submitted for the CCO238 OBG Retrofit Stiffeners for the excessive root opening noted at a few of the stiffeners. QC Inspector John Hays was informed of the root opening issue. See “Incident Report” for detailed information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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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
Reviewed By:	Reyes,Danny	QA Reviewer
