

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-029084**Date Inspected:** 02-Feb-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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:** Tower**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 Eric Sparks #3040:

The welder was observed performing the weld repairs by preheating and Carbon Arc Gouging (CAG) the excavation on the indication rejected by Ultrasonic Testing on the Electroslag Weld "P" N-043 at face B. After the Carbon Arc Gouging the weld excavation was ground to bright metal and was Magnetic Particle Tested by QC Inspector William Sherwood and this QA to ensure complete removal of any indications in the weld. The welder was then observed preheating the weld excavation and the surrounding area to 300 degrees with the Miller Proheat 35 and induction blankets prior to any welding as per Request for Weld Repair or RWR #201301-049. The excavation final dimensions were 100 x 35 x 22 deep at Y location 8610 at weld face B. The welder utilized the Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3 for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector William Sherwood throughout the day and they appeared to be in compliance with the WPS noted above.

Non-Destructive Testing (NDT)

This QA performed non-destructive testing on the following:

Weld "P" N-043 (Face B):

- Y 8610 Excavation 100 x 35 x 22 (MPT Accept)

Weld "G" S-045 (Face B):

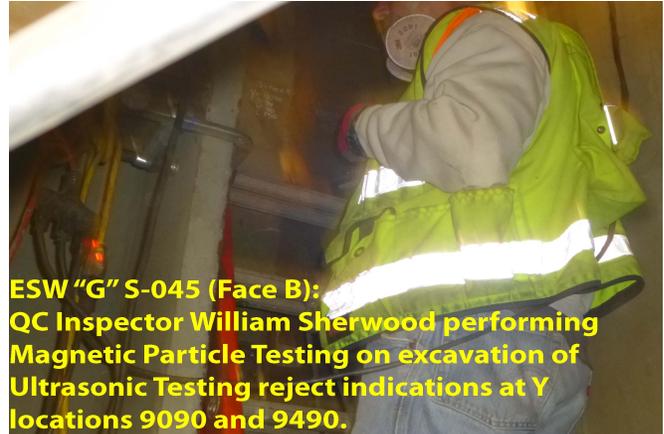
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- Y 9490 & 9500 Combined Excavation 120 x 40 x 30 (MPT Accept)
- Y 9090 Excavation 150 x 40 x 34 (MPT Accept)

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
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