

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-029129**Date Inspected:** 09-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 Chris Bruce #8901:

The welder was observed excavating by Carbon Arc Gouging (CAG) the Electroslag welds "H" W-045 and "M" W-042. Welder was observed preheating and excavating both welds, Y location 9675 for weld "H" (RWR #201302-01) and Y location 9070 for weld "M" (RWR #201301-043). The excavations were in way of UTSW rejected indications and were ground to bright clean metal and Magnetic Particle Tested by QC Inspector prior to welding. The welder was observed preheating the excavations to 300 degrees Fahrenheit prior to welding using the Miller ProHeat 35 with heat induction blankets, and utilized 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 Steve Jensen appeared to be in compliance with the WPS noted above.

Welder Eric Sparks #3040:

The welder was observed setting up his work station at weld ESW Q face B for carbon arc gouging, grinding and welding of UTSW rejected indication at Y locations 7700, 8150, 8200, 8300 and 8350. The Y locations noted are as per Request for Weld Repair (RWR) 201302-004, 005 & 006. Due to insufficient scaffolding, no welding was performed at this location throughout the shift as the workers erect/build scaffolding for the welder.

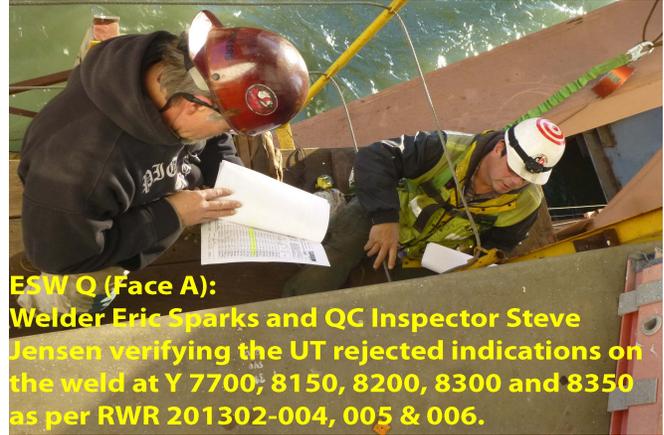
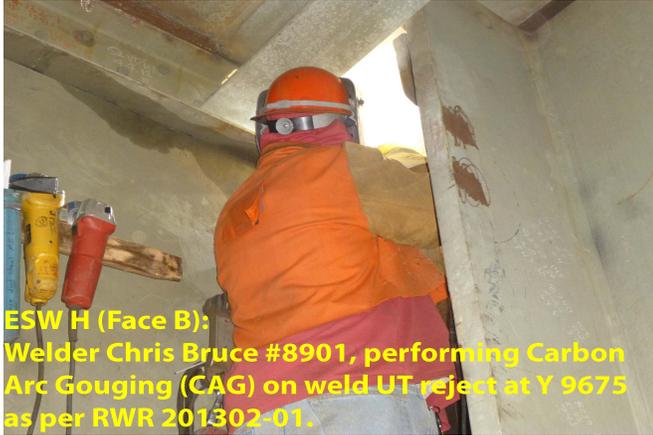
The completed and accepted work observed at this location appeared to be in compliance with the contract

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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
Reviewed By:	Reyes,Danny	QA Reviewer
