

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-029136**Date Inspected:** 15-Feb-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:** 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 continuing the weld repair on the Electroslag Weld "F" at face A, at Y location 9600 as per Request for Weld Repair (RWR) 201302-013 in way of an Ultrasonic Testing rejected indication. The indication was excavated 1mm at time to a depth of 40mm as part of exploratory excavation for flaw characterization. The welder was observed preheating the weld to 300 degrees Fahrenheit prior to welding using the Miller ProHeat 35 with heat induction blankets. 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 appeared to be in compliance with the WPS noted above.

Welder Eric Sparks #3040:

The welder was observed continuing with the weld repair on the Electroslag weld "Q" at face A, at Y locations 8860, 9095 and 9241 as per Request for Weld Repair (RWR) 201302-007, 008 and 009 in way of UT rejected indications. The welder was observed preheating the weld to 300 degrees Fahrenheit prior to excavating using the Miller ProHeat 35 with heat induction blankets. 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 appeared to be in compliance with the WPS

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noted above.

Non-Destructive Testing (NDT)

This QA performed non-destructive testing on the following:

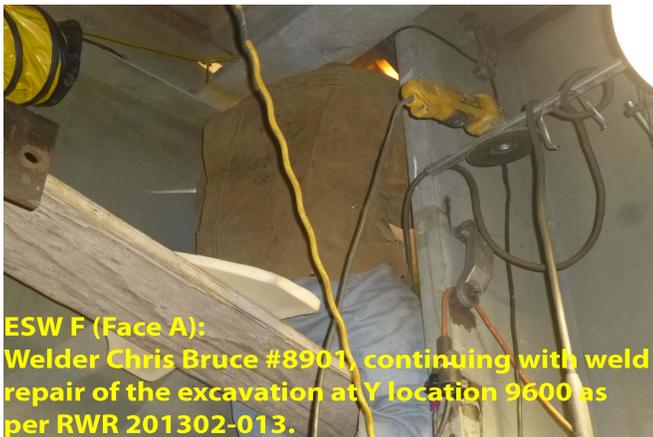
ESW G (Face A & B):

- Weld repair at Y 8340. (UT Recordable Indications noted**)

** As per supplementary procedure SE-UT-D1.5-CT-108-ESW Rev.5, with approval of SMR Aaron Prchlik.

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

Reviewed By: Reyes, Danny

QA Reviewer