

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-029143**Date Inspected:** 14-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:** As noted 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:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey 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 observed the following welders working on the OBG at various locations:

This QA Inspector randomly observed ABF welder Mike Jimenez #4671 pre-heat the complete joint penetration (CJP) weld prior to performing Shielded Metal Arc Welding (SMAW) on the East alignment lug hole (ALH) #3 on the east end of the skyway. This QA Inspector observed QC Inspector Salvador Merino verify that the temperature was at a minimum of 66° C and the amperage for the 3.4 mm E7018-H4R electrodes was 132. This QA Inspector observed the welder grind and blend the edges of the hole utilizing a small disc grinder and installed the 20 mm plate to make up the B-U4a joint. This QA Inspector observed the QC Inspector measure the planar offset to be within 1 mm and this QA Inspector found it to be acceptable. This QA Inspector observed the QC Inspector verify that the welding parameters were in accordance with ABF-WPS-D15-1050B. Upon completion of the exterior side, the welder began preparations to begin welding on ALH #4. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was in progress and appeared to be in general compliance with the approved WPS and the contract specifications. The CCO-184 and RFI-3132 were referenced during the observations.

FW Spencer welder Damien Llamas # 6645 was observed performing SMAW welding on a PS20 modification located at 130214-01. The welder was observed utilizing WPS FWS-Fillets Murex for SMAW. The welder was

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

observed preheating the welds prior to welding. Other welding parameters as inspected by the QC Inspector appeared to be in compliance with the WPS noted above.

This QA Inspector made random observations of the SMAW process of elevator platform support of the Tower at the 53 meter elevation. ABF/JV welder Xiao Hua Luo #1291 performed the welding in compliance and conforming to ABF-WPS-D1.5-F1200A for fillet welding utilizing the SMAW process. Upon completion, the QC Inspector Fred Michels tested the welds by means of Magnetic Particle Inspection to verify soundness of the metal. The work and testing was found to be acceptable and appeared to be in general conformance to the contract documents.

ABF welder Wai Kit Lai #2953 was observed performing SMAW on the ALH#1 on the East bound skyway. The welder was observed preheating the joint prior to welding in accordance with ABF-WPS-D1.5-1050B-Revision 1. CCO-184 and RFI- 3132 were referenced throughout the observation. Welding parameters as inspected by the QC Inspector appeared to be in compliance with the WPS noted above. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work at this location was in progress and appeared to be in general conformance with the contract documents.

This QA Inspector performed Magnetic Particle (MT) testing on the Deck Access Hole located at 14E PP126.5-E2-DAH. This QA Inspector performed MT testing utilizing the yoke method in conformance with ASTM E709 and the standard of acceptance with D1.5 section 6.26.2.1. A total of 100% of face A and face B was tested. This QA Inspector noted that no rejectable indications were found at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work at this location appeared to be in general conformance with the contract specifications.

This QA Inspector performed an Ultrasonic (UT) inspection on the Deck Access Hole (DAH) located at 14E PP126.5-E2-DAH. These repairs were previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. This QA generated a TL-6027 UT report on this date. The testing was performed in accordance with AWS.D1.5-2002 Section 6, table 6.3. The testing performed included repaired indications located at y=2980mm, y=2490mm, y=1130mm, y=60mm, y= 270mm and y=1640mm. In addition, a total of 25% of the weld surface was scanned. This QA Inspector recorded and rejectable indication located at y=1130mm and was noted on the TL-6027.

This QA observed QC Inspector Fred Michels and Salvador Merino performing welding parameter checks such as voltage, amps, electrodes and preheats throughout the day. This QA also observed QC Inspector's John Hays performing various Non-Destructive Testing (NDT) on completed weld repairs as they became available for testing. Non-Destructive Testing methods utilized by the QC Inspectors were Visual Testing (VT), Magnetic Particle Testing (MPT) and Ultrasonic Testing Shear Wave (UTSW). QC Inspectors were observed performing inspection per applicable code and or contract criteria. Unless otherwise noted, all work observed on this date appeared to generally comply with the contract documents.

Summary of Conversations:

Conversations were relevant to work performed.

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:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
