

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-029165**Date Inspected:** 25-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 Ethan Kent #7726 perform the Stud Welding process on the Bike Path support beams on the East OBG on panel points 109, 111, 115, 123, 125, 127 and 128. A total of two 7/8" threaded studs were placed and bend tested prior to the intended application and within the parameters of ABF-WPS-5001-STUD. This QA Inspector and QC verified the complete fusion and the allowable offset in degrees. This QA Inspector made subsequent observations to monitor quality and noted that the work at this location appeared to be in general conformance with the contract documents.

FW Spencer welder Damien Llamas # 6645 was observed performing SMAW welding on PS3 pipe support bracket modifications. The welder was observed utilizing WPS FWS-PLUG/SLOT SMAW. The welder was 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. ABF-RFI-003139R00 and RFI-FWS-000117R00 were referenced during the observations. The welder completed bracket #'s 1/4/BP/SE through 7/4/BP/SE on this date.

This QA Inspector randomly observed ABF welder Mike Jimenez #4671 perform the SMAW welding process in the 1G flat position on 1" threaded studs on the bike path support beams located at panel point 121. The studs were

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prepared with a 45° bevel on two sides and upon completion of one side, the root was back gouged and tested by means of Magnetic Particle (MT) testing to ensure soundness of the metal and complete fusion. The parameters and the welding were monitored by QC for compliance with ABF-WPS-D1.5-1100-Revision 1. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work at this location appeared to be in general conformance with the contract specifications.

This QA observed QC Inspector Salvador Merino performing welding parameter checks such as voltage, amps, electrodes and preheats throughout the day. This QA also observed QC Inspector's Jesse Cayabyab 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.



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
