

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-029351**Date Inspected:** 02-Apr-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:** OBG**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 Earl Clayborn #5070:

The welder was observed weld repairing the welds on the hatch hinges for Crossbeam number 1 and 4 hatches at Panel Points 14 and 32 in way of the bridge centerline. The welder was observed welding utilizing the Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Fred Michaels throughout the day and appeared to be in compliance with the WPS noted above. Welder Foreman Eric Sparks #3040 was noted assisting and directing welder Earl Clayborn throughout the day.

F.W. Spencer Welder Damian Llanos :

The welder was observed welding 3" diameter pipe butt weld for the Bike Beam Path water service line. The weld was identified as weld 1/CA2/111.5 /BE. The welder was observed welding utilizing the Welding Procedure Specification (WPS) 1-12-1 for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Bonifacio Daquinag Jr. throughout the day and appeared to be in compliance with the WPS noted above.

F.W. Spencer Welder Rick Kickvee :

The welder was observed welding 2.5" diameter pipe socket welds for the Bike Beam Path water service line. The

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welds were identified as welds 1/CA2/121.5 /BE & 1/CA2/126.5 /BE. The welder was observed welding utilizing the Welding Procedure Specification (WPS) 1-12-1 for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Bonifacio Daquinag Jr. throughout the day and appeared to be in compliance with the WPS noted above.

Miscellaneous:

This QAI observed welder Richard Chouinard #8959 installing the East Tower exterior ladder wells above the 50 meter level. The ladder was installed using nuts and bolts. Also noted was welder Eric Sparks and Earl Clayborn grinding off temporary attachments to the bike beam path at the North face side plate and preparing them for MPT by the QC and QA Inspectors. This QAI also observed QC Inspector Fred Michaels perform Magnetic Particle Testing on the North Tower, North exterior face between the 47 and 81 meter level from.

Non-Destructive Testing (NDT)

This QA performed Visual Testing (VT) and Magnetic Particle Testing (MPT) on the following:

OBG Crossbeam Hatch Hinges at:

- Crossbeam 1 hatch hinges at Panel Point 14. (Acceptable)
- Crossbeam 4 hatch hinges at Panel Point 32. (Acceptable)

North Tower, North exterior face between 47 – 81 meter level:

- Elevator Bracket Temporary attachments. (Acceptable)

See TL-6028 for MPT report information.

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.



F.W. Spencer Welder Rick Kickvee :
The welder was observed welding 2.5" diameter pipe socket weld #1/CA2/121.5/BE for the Bike Beam Path water service line.



North Tower:
QC Inspector Fred Michaels performing Magnetic Particle Testing on the towers north face in way of the elevator temporary attachment removals.

Summary of Conversations:

Conversations this day as required for scope of work.

Comments

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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
