

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-029420**Date Inspected:** 12-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 Wai Kit Lai #2953:

The welder was observed welding the transverse stiffener weld 12E PP116.5 E2.0-TS. The welder was observed pre heating the stiffeners prior to welding. The welding was performed utilizing the Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A Rev.2 for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Salvador Merino throughout the day and appeared to be in compliance with the WPS noted above.

Welder Jimmy Zhen #6001:

The welder was observed performing non-critical weld repairs on the Cover Plates seal welds at OBG 12W Panel Point 119 (-1500) in way of the K plate for the West Saddle Grillage Dehumidification Zone as per ABF-RFI-003256R00. The non-critical weld repairs were in way of excessive undercut throughout the seal welds. The welder was observed pre heating the plates to 300 and 350 degrees Fahrenheit prior to welding. The welding was performed utilizing the Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A Rev.2 for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Salvador Merino throughout the day and appeared to be in compliance with the WPS noted above.

Welder Earl Clayborn #5070

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

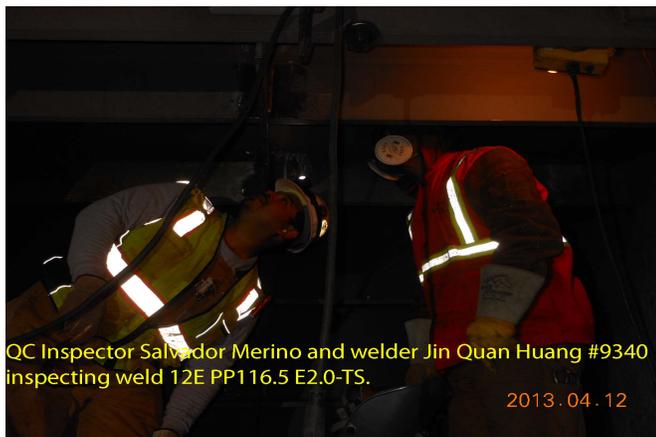
The welder was observed tack welding seal cover plates at OBG 12E Panel Point 119 (-1500) in way of the K plate for the East Saddle Grillage Dehumidification Zone as per ABF-RFI-003256R00. The welder was observed pre heating the plates to 300 degrees Fahrenheit prior to welding. The welding was performed utilizing the Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A Rev.2 for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Salvador Merino throughout the day and appeared to be in compliance with the WPS noted above.

Welder Jin Quan Huang #9340

The welder was observed tack welding seal cover plates at OBG 13E Panel Point 119 (+1500) in way of the K plate for the East Saddle Grillage Dehumidification Zone as per ABF-RFI-003256R00. The welder was observed pre heating the plates to 300 degrees Fahrenheit prior to welding. The welding was performed utilizing the Welding Procedure Specification (WPS) ABF-WPS-D15-F1200A Rev.2 for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Salvador Merino throughout the day and appeared to be in compliance with the WPS noted above.

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

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Reviewed By: Reyes,Danny

QA Reviewer