

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-029496
Date Inspected: 23-Apr-2013

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Job Site

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|------------------------------------|----------------|----------------------------------|---------|--------|
| 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 the following locations:

This QA Inspector performed 100% Magnetic Particle (MT) testing along the length of, and the edges of the weld on the Dehumidification Seal Plates located at 13E PP119+1500mm. This QA Inspector performed MT testing utilizing the yoke method in conformance with ASTM E 709 and the standard of acceptance with D1.5 section 6. 26.2.1. 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 randomly observed ABF welders Lin E Yun #9344 perform the Shielded Metal Arc Welding (SMAW) process on the Dehumidification access door hinges located at 13W PP120.5 W3. The welder was observed utilizing WPS ABF-D1.5-F1200A for SMAW and was observed preheating the area to be welded prior to welding. Other welding parameters as inspected by the QC Inspector were recorded as 136 amperes and appeared to be in compliance with the WPS noted above. The QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

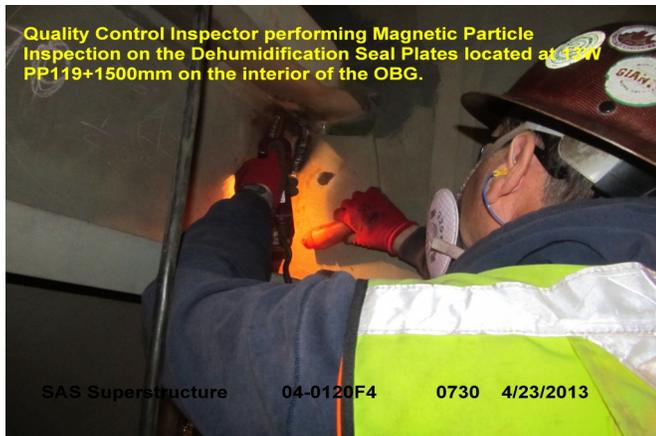
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FW Spencer welder Rick Kiikvee #5319 was observed performing SMAW welding on 2.5” domestic water and 4” compressed air outlets to schedule 40 pipe. The welder was observed utilizing WPS-1-12-1 and was observed the welder preheat the site prior to welding. 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 throughout the shift and noted that the work was in process and appeared to be in general conformance with the contract documents. Completed work on this date includes; 1/DW1/10/NW and 1/CA2/10/NW.

Summary of Conversations:

Conversations on this date 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.

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