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 #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-029501
Date Inspected: 29-May-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

CWI Name: As noted below

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS OBG/Tower

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 randomly observed ABF welder Lin E Yun #9344 perform the Shielded Metal Arc Welding (SMAW) process on the Hinge A barricade adjustment plates 1-4 (PL5, PL6 and PL7) on the north side of the eastbound OBG. The welder was observed utilizing WPS ABF-D1.5-1072-Revision 1 for Complete Joint Penetration (CJP) welding. The welder was observed preheating the surface area prior to welding and 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 in progress and appeared to be in general conformance with the contract documents.

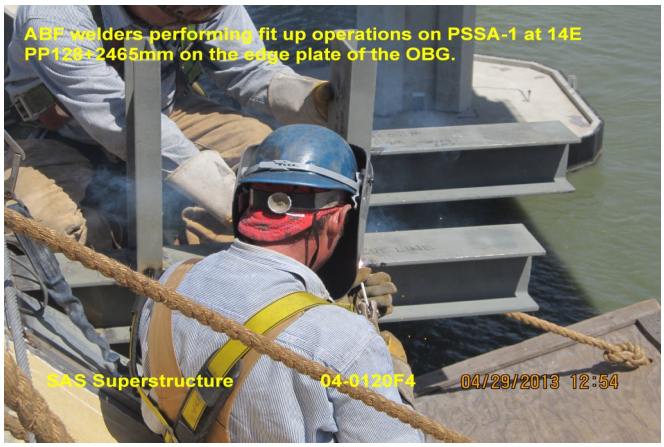
This QA Inspector randomly observed ABF welder Wai Kit Lai #2953 utilizing the SMAW process on Partial joint Penetration (PJP) joints for the W150x37 beam to the 19x500x500 plate on edge plate F of the OBG located at 14E PP128+3200mm. This QA Inspector randomly observed ABF welders Lin E Yun #9344 located at 14E PP128+3065mm installing two (2) C150x16 channel to “A” deck and Jose Torres #6325 utilizing the SMAW process on Partial joint Penetration (PJP) joints for the 19x500x500 plate to the edge plate F of the OBG located at 14W PP127+2565mm. The PSSA-5 detail on ZPMC sheet no. PS1314WB provides for 6mm fillets on the beveled

top edge of the plate. The welder was observed removing the paint from the surface area to be welded followed by preheating of the area. Parameters as inspected by the QC Inspector were recorded as 138 amperes and appeared to be in compliance with ABF-WPS-1160-Revision 0. The 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 conformance with the contract documents.

This QA observed QC Inspector William Sherwood and Salvador Merino performing welding parameter checks such as voltage, amps, electrodes and preheats throughout the day. 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 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.

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