

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-029577**Date Inspected:** 09-May-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 the following locations:

FW Spencer welder Tim Esquivel #8348 was observed performing SMAW welding on 4" schedule 40 pipe sockets and outlets. The welder was observed utilizing WPS-1-12-1 and pre-heating the surface area to be welded 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 completed on this date and appeared to be in general conformance with the contract documents. Completed work on this date includes weld identification #'s; 1/DW1/111.5/BE, 1/DW1/112.5/BE, 1/DW1/122.5/BE, 1/DW1/123.5/BE, 1/DW1/124.5/BE.

This QA Inspector randomly observed Quality Control Inspector William Sherwood perform Magnetic Particle (MT) testing and inspection of the lifting lug temporary attachment sites of the bike path sections located at PP97.5, 98.5, 99.5, 100.5, 101.5 and 102.5. The QC inspector performed the testing in accordance with AWS D1.5-Section 6.7.6-2002 and 6.26.2. It was noted that no rejectable indications were found and appeared to comply with the contract specifications.

This QA Inspector randomly observed Quality Control Inspector Fred Michels perform MT testing and inspection

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of the twelve (12) pairs of elevator bracket removal sites on the north shaft of the tower at the from elevations 47m – 13m. The QC performed the testing in accordance with AWS D1.5-Section, Para. 6.7.6 and ASTM E709. It was noted that no rejectable indications were found and appeared to comply with the contract specifications.

This QA Inspector performed 100% Magnetic Particle (MT) testing on the twelve (12) pairs of elevator bracket removal sites on the north shaft of the tower between the elevations 47m – 13m. 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. 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 performed a survey of the “A” deck from OBGs 4E to 7E between the grid lines E3 and E4. This inspection was conducted in conjunction with Smith Emery Quality Control personnel and impact sites as well as arc strikes and surface irregularities which were measured for depth and length as well as location and recorded for a repair procedure.

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) and Magnetic Particle Testing (MPT). The 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
