

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-029666**Date Inspected:** 11-Jun-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:** Tower Electroslag Welds**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 Mike Jimenez #4671:

The welder was observed continuing with the weld repairs on Ultrasonic Testing rejected indications on weld ESW T at Face B between Y locations 5000 and 6000. The welder was observed preheating the weld to 350 degrees Fahrenheit prior to welding using the Miller ProHeat 35 with heat induction blankets. The welder utilized the Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3 for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Bernard Docena throughout the day and they appeared to be in compliance with the WPS noted above.

Welder Don Plumb #0891:

The welder was observed continuing with the excavation of weld ESW S at Face B by Carbon Arc Gouging (CAG) at Y locations 5620 and 5900. The excavations were in way of rejects noted with Ultrasonic Testing Shear Wave (UTSW). After Carbon Arc Gouging (CAG) the weld excavation was then ground to shiny metal by an ABF apprentice and was Magnetic Particle Tested (MPT) by this QA Inspector and QC Inspector Bernard Docena. A transverse indication was noted in the excavated area and was excavated out at 45mm Deep. Indications at Y locations 5620 and 5900 were combined for final excavation length of 450mm. The excavation was Magnetic Particle Tested and was accepted.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Non-Destructive Testing (NDT)

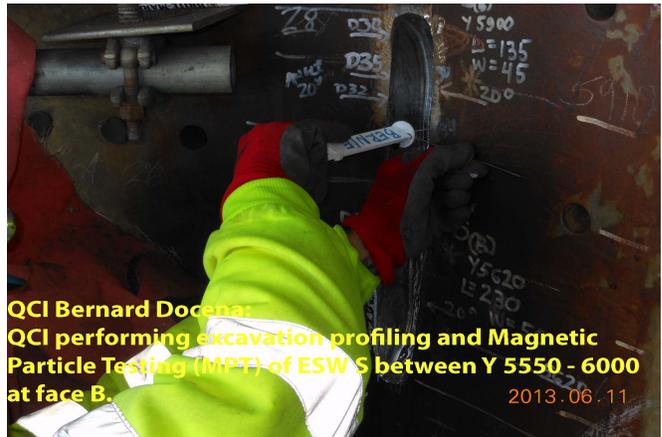
This QA performed Magnetic Particle Tested (MPT) on the following:

ESW S, S041:

- Face B, Weld Excavation at Y5550 - 6000.
 - 450 x 50 x 45deep (MPT Accept)

See TL-6028 for MPT report details.

The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.



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
Reviewed By:	Mertz,Robert	QA Reviewer
