

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-029770**Date Inspected:** 11-Jun-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**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:** 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 Inspector randomly observed ABF welder Richard Garcia #5892 perform the Shielded Metal Arc Welding (SMAW) process in the 2F horizontal position on PS 30 pipe support plates located on the west bound OBG at PP118. The welder was observed utilizing WPS ABF-D1.5-F1200A Rev. 2 for fillet 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 132 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. RFI-003350R00 was referenced during this observation.

This QA Inspector randomly observed ABF welding personnel grind and smooth the temporary attachment sites (4 per counterweight) on counterweights 82, 84, 86, 88, 90, 92, 94, 96 and 98. This QA Inspector observed Quality Control Inspector Salvador Merino perform Magnetic Particle (MT) testing and inspection of the counterweight temporary attachment sites listed above. QC was performing the testing in accordance with AWS D1.5-Section 6.7.6-2002 and ASTM E709. It was noted that no rejectable indications were found and appeared to comply with the contract specifications.

This QA Inspector randomly observed ABF welder Jose Torres #6235 perform the SMAW process on a 9992mm

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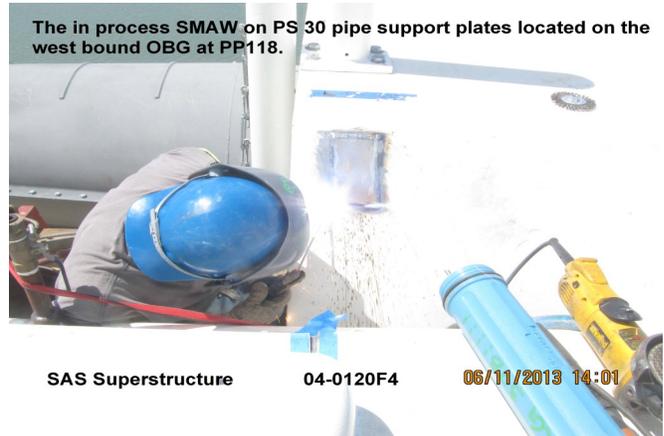
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angle to the bike path for the bike path access. The welder was observed utilizing WPS ABF-D1.5-F1200A Rev. 2 for fillet welding. The welder was observed preheating the surface area prior to welding and other welding parameters as inspected by the 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.

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
