

**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-029787  
**Date Inspected:** 25-Jun-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:** 1100  
**Location:** Job Site

<b>CWI Name:</b>	As noted below	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Crossbeam	

**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:

## Crossbeam CB-8

This QA observed the Quality Control (QC) Inspector's Bernard Docena and Brien Connolly perform and complete Ultrasonic (UT) and Magnetic Particle Test (MPT) of the damaged areas of this crossbeam which appeared to comply with contract documents. At the conclusion of the QC testing this QA inspector performed QA verification at the request of the QC inspector's.

This QA Inspector performed an Ultrasonic (UT) inspection on crossbeam CB8 edge plate (PL14) to web plate (PL14) connection between Y coordinates Y+1700mm to Y+3300mm for verification. This QA Inspector also performed a lamination scan of the web plate between Y coordinates Y+1500mm to Y+3500mm and of the edge plate between Y coordinates Y+2000mm to Y+3000mm and between Y coordinates Y+6000mm to Y+7000mm. The testing of the Complete Joint Penetration (CJP) groove weld was performed as per AWS D1.5~2002, Chapter 6, Part C and Table 6.3, Ultrasonic Acceptance/Reject Criteria. This QA Inspector noted that no rejectable indications were found at the time of testing. The testing of the of the base material was performed as per AWS D1.5~2002, Chapter 3, Section 3.2, Para. 3.2.3.7. At the conclusion of the testing this QA Inspector generated a TL-6027 UT report on this date.

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This QA Inspector also performed 100% Magnetic Particle (MPT) testing along the length of the web plate between the following Y coordinates Y+1500mm to Y+3500mm, at the edge plate Y+1200mm to Y+3800mm and Y+5600mm to Y+7300mm. This QA inspector also performed MPT on the stiffener plates identified as 1 and 2 between the Y coordinates 0mm to Y+7500mm. The testing was performed utilizing the yoke method in conformance with ASTM E 709 and the standard of acceptance with AWS D1.5~2002, Chapter 6, Part D. At the conclusion of the testing no rejectable indications were noted. This QA Inspector generated a TL-6028 MT report on this date.

This NDT was performed after straightening operations and before the installation of the retrofit assembly.

The completed work at this location appeared to be in general conformance with the contract specifications and Submittal ABF-SUB-002845R00.

### 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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<b>Inspected By:</b>	Frey,Doug	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes,Danny	QA Reviewer

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