

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-029794**Date Inspected:** 28-Jun-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**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:

FW Spencer welder Tim Esquivel #8348 was observed performing Shielded Metal Arc Welding (SMAW) welding on 2.5" schedule 40, pipe. The welder was observed utilizing WPS-1-12-1 and the welder was observed 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. 35A/2.5/45/BE, 34/2.5/45/BE and 33/2.5/45/BE were completed on this date.

FW Spencer welder Barry Mullaney #6520 was observed performing SMAW welding on 2.5" schedule 40, pipe. The welder was observed utilizing WPS-1-12-1 and the welder was observed 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. 17/BP2/T/53, 5/BP2/T/53, 16/BP2/T/53, 18/BP2/T/53, 4/BP2/T/53, 5/BP2/T/53 and 6/BP2/T/53 were completed on this date.

This QA Inspector performed a Deck survey of the surface condition of "A" deck from OBGs 2W PP16 W2 – W4.

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5 to 4W PP28 W2 – W4.5. This inspection was conducted in conjunction with Smith Emery Quality Control personnel and impact sites as well as arc strikes and any irregularities was measured for depth and length as well as location and recorded for a repair procedure. This QA Inspector randomly observed ABF welding personnel perform grinding repairs on “A” deck survey indications at the following locations;

#208 – 3W PP20.5+1110 W5-3630, #209 – 3W PP21.5+320 W5-4850, #210 – 3W PP21.5+320 W5-5170, #211 – 3W PP23.5-80 W5-2800, #212 – 4W PP24+440 W4+1080, #213 – 4W PP26+0 W4-400, #214 – 4W PP27+1500 W4+730, #215 – 5W PP30.5+270 W3+1110, #216 – 6W PP44+830 W3+5060, #217 – 6W PP44+940 W4-40, #218 – 7W PP55.5+1370 W2+4640, #219 – 7W PP56-420 W2+3700, #220 8W PP64-720 W2+4030, #221 – 8W PP69+0 W5-2920, #222 – 9W PP73+660 W4-3000, #223 – 9W PP75+820 W3-2500, #224 – 9W PP76+950 W3+0, #225 – 9W PP78+1140 W3-2500, #226 – 9W PP82.5+1530 W3+3420, #227 – 10W PP92.5+1020 W4+2470, #228 – 10W PP92.5+1430 W4+2520, #229 – 10W PP93+900 W5-5000, #230 – 10W PP93+1630 W4-4860, #231 – 10W PP95-860 W3-1720, #232 – 10W PP95-620 W3-1730, #233 – 10W PP95-620 W3-4740, #234 – 10W PP95+520 W+2750, #235 – 10W PP91+720 W2+2750, #236 – 11W PP98+1140 W5-3400, #237 – 11W PP99-800 W3-80, #238 – 11W PP109-700 W3+3035, #239 – 12W PP114+890 W2+3430.

The grinding was observed to ensure that minimal material was removed to bring the site to serviceable condition. Upon completion of the grinding Quality Control Inspector Fred Michels was observed performing Magnetic Particle (MT) Inspection of the sites. QC was observed 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.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable 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 SMR 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
