

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-029875**Date Inspected:** 18-Jul-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1200**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	As noted below		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A
Component:	OBG		

Bridge No: 34-0006**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:

RWR – 201307-002

This QA Inspector randomly observed ABF personnel remove the High Strength Bolt from the side plate at PP 24 W2 in order for ABF welder Rick Clayborn #2773 to perform welding repair procedures on the gouges in the plate that extended under the bolt washers. This QA Inspector randomly observed the welder perform the Shielded Metal Arc Welding (SMAW) process on surface. The welder was observed utilizing WPS ABF-D1.5-1003-Repair 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. Upon completion of the welding and the area return to ambient temperature, this QA Inspector observed QC Inspector Bernard Docena perform Ultrasonic Testing (UT) on the site to verify sound metal. QC reported that no indications were present and the bolt was reinstalled and torqued to specifications in accordance with the repair procedure. The second bolt was removed and the process was repeated. This QA Inspector made random 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 specifications.

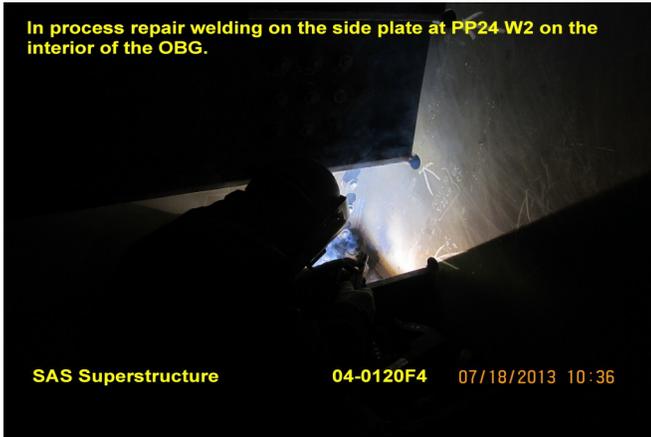
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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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
