

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029904**Date Inspected:** 09-Aug-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:** Bernard Docena**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 ESW 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 Kit Lai:

The welder was observed performing weld repairs by grinding on Magnetic Particle Testing (MPT) rejected indication on weld ESW F, Face A at Y locations 8530 and 8670. Weld toe indication was ground at 120 x 28 x 10 deep. Weld repair to commence on the next shift after approval from the Engineer. QC Inspector Bernard Docena was observed performing Magnetic Particle Testing (MPT) to verify removal of indication by the welder with the grinder.

Welder Don Plum:

The welder was observed performing weld repairs on previously excavated Ultrasonic Testing rejected indications on weld ESW F, Face A between Y locations 6050 and 8040 as per Request Weld Repair (RWR) 201307-009. The indication was excavated to 190 x 55 x 40 deep. 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.

Non-Destructive Testing (NDT)

WELDING INSPECTION REPORT

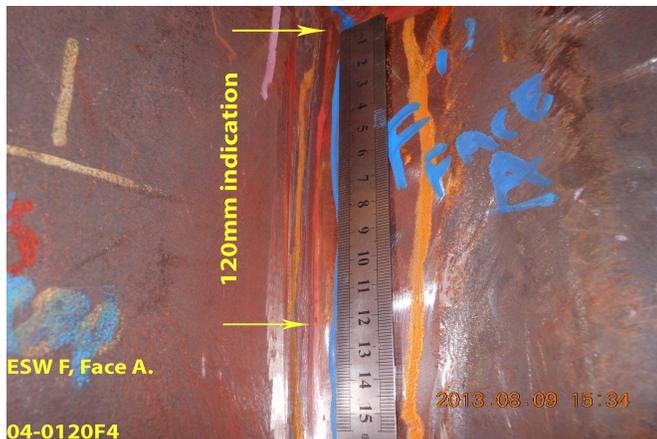
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This QA performed NDT on the following:

ESW G, Face B at Y 9090 – 9500. (Weld Repair Verification)

- Face B, Magnetic Particle Testing (MT) Acceptable.

- Face A & B Ultrasonic Testing Shear Wave (UTSW) Acceptable.



Summary of Conversations:

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
