

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 #: 01.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-030031**Date Inspected:** 14-Sep-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Tony Sherwood & Bernie 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:** See Below**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Edward Leach was at the American Bridge/Flour (ABF) job site at Yerba Buena Island between the times noted above in order to monitor Smith Emery Quality Control (QC) functions and the in process work being performed by ABF personnel. The following items were observed:

Tower Ring Beam CJP @ ESW S & R

ABF welding personnel Rick Clayborn was observed cleaning and prepping CJP splice joints for NDT on the south side of the tower ring beam. The QAI and QC Inspector Bernie Docena later performed final visual inspection, Magnetic Particle Testing (MT) and Ultrasonic Testing (UT) for ring beam CJP flange & web (#146/#147). The QC Inspector performed 100% inspection for all three methods mentioned above and accepted the final welds. The QAI also performed 100% verification after QC observing no relevant indications.

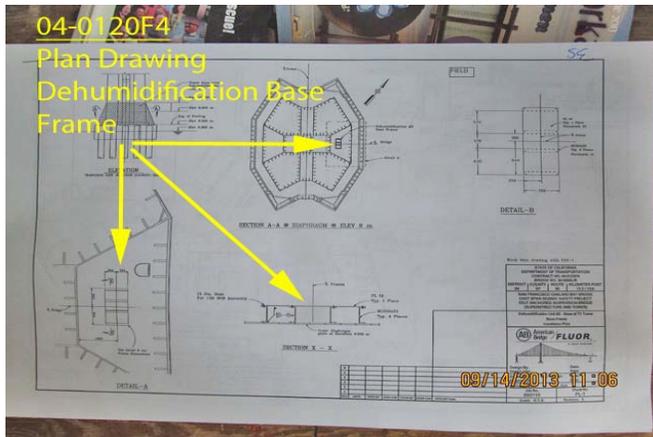
SMAW Channels

The QAI observed ABF welding personnel Gao Wu Chen performing Shielded Metal Arc Welding in the horizontal (2F) position for channel beams which will be part of a dehumidification unit base frame. Welding was being performed with Lincoln Excalibur 7018 MR, E7018 H4R, 3.2mm diameter electrode. The QAI observed welding parameters at approximately 156 amperes per ABF-WPS-D1.5-F1201A. The work observed was referenced on ABF plan drawing PL-1 for 6mm fillet welds. Once the work was completed the QAI along with QC Inspector Tony Sherwood visually inspected the work to verify compliance with the contract specifications.

The welding & workmanship observed on this date appeared to be in general compliance with the contract specifications. The following pictures detail the work in progress.

WELDING INSPECTION REPORT

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Summary of Conversations:

General conversations with ABF/JV QC NDT personnel relevant to work and testing performed during this shift.

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: Leach,Ed

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer
