

**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 #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023480**Date Inspected:** 11-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2000**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

<b>CWI Name:</b>	James Bowers		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

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

**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

This Caltrans Quality Assurance Inspector witnessed the radiographic testing of the T1 Tower Shear Plate Welding Electroslag Full Height Mockup welded per the ABF welding procedure specification ABF-WPS-ESW-80-100TR. Assistant Structures Representative Mr. Douglas Wright requested radiography be performed at a location near the bottom of the weld joint and at 8.5 meters up. Joint detail is a square groove with 19mm root opening. Construction Materials Testing Inc. NDT Level II Inspector Mr. Ted Shoecraft assisted by Mr. Brian Rose performed radiography in accordance with Quality Control Procedure QC-RT-2A Bridge. Radiography was performed using a 34 curie Iridium 192 source at 25-inch source to film distance. The film utilized was AGFA D7. Two 'C' wire type image quality indicators and two location markers were placed in accordance with AWS figure 6.1C for each exposure. Exposure time was 3 hours and 20 minutes. After completing the first radiograph, Mr. Shoecraft performed a preliminary review. The film quality was interpreted for compliance with AWS D1.5-2002 Section 6.10. The weld quality were interpreted for compliance with AWS D1.5-2002 Section 6.26 paragraph 6.26.2.1 and Figure 6.8 (weld quality requirements for discontinuities occurring in tension welds) and the results met the requirements of Figure 6.4. The Quality Assurance Inspector concurred with NDT Level II Inspector Mr. Shoecraft's results. Caltrans lot number B228-005-11 was assigned for tracking purposes.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

General conversations with Mr. James Bowers regarding the schedule.

## 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 Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Lanz, Joe	Quality Assurance Inspector
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<b>Reviewed By:</b>	Levell, Bill	QA Reviewer
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