

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-026902
Date Inspected: 13-Dec-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
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 Component		

Summary of Items Observed:

(Information in the report supercedes report previously filed for this date.)

Quality Assurance Inspector (QA) William Clifford 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:

This QA continued performing "information only" Ultrasonic Testing of base material at the closed rib adjacent to the deck ventilations. This UT was performed to further investigate indications originally discovered during Quality Assurance percentage Ultrasonic Testing of the deck ventilation holes 14W-PP126.7-W2.5 and 14W-pp126.2-W2.6 at or near the toe of rib-to-deck PJP weld. Some locations were only accesible on one side of the weld axis. Where both sides were accesible, UT was performed to try and evaluate the indications but nothing could be detected from the opposite side of the weld axis. Testing on this date was performed using a small 5mHz, 70 degree, shear wave testing angle and wedge primarily to try and evaluate the weld from Face B.

Locations tested:

14E-PP125.7-E3.2

14E-PP126.2-E3.7

14E-PP126.7-E2.5

Testing was performed from Faces A & B. Indications could not be confirmed and no repeatable signal could be detected from this subsequent testing. At this point indications appear to be caused by mode conversion due to weld geometry. MT was also performed on Face B at the rib to deck weld and no indications were detected. Area tested was approximately 500mm in length at each test location.

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This testing was performed under the direct supervision of Quality Assurance Ultrasonic Level III Robert Mertz. No UT report has been filed.

This QA observed QC Pat Swain perform Ultrasonic Testing (UT) of the completed weld at 12W/13W-E1/E2. Please see QCUT report dated 12/13/11 for more information regarding these indications.

This QA observed QC Steve McConnell perform Ultrasonic Testing (UT) of the completed weld at 12W/13W-D2/D3. Please see QCUT report dated 12/13/11 for more information regarding these indications.

This QA observed QC Jesse Cayabyab perform Ultrasonic Testing (UT) of the completed weld at 13/14W-D1/H1. Please see QCUT report dated 12/13/11 for more information regarding these indications.

This QA observed QC John Pagliero perform Ultrasonic Testing (UT) of the completed weld at 13E/14E-F1. Please see QCUT report dated 12/13/11 for more information regarding these indications.

This QA verbally informed QA SPCM Lead, Daniel Reyes, of the issues noted in this report for compliance. For further details of issues of significance see QA SPCM Lead, Daniel Reyes, "Daily Inspection Report" (TL-6031) submitted for this date.

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

Summary of Conversations:

No relevant conversations.

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

Inspected By:	Clifford, William	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
