

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-027639**Date Inspected:** 21-May-2012**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:** 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:** Tower Component**Summary of Items Observed:**

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 observed, at random intervals, ABF/JV qualified welder Richard Garcia #5892 performing Shielded Metal Arc Welding (SMAW) with 3.2mm diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1160. The joint being welded was Weld #W007 at Tower Shear Base Assembly designated as ED1-829.

During welding, ABF Quality Control (QC) John Pagliero was noted monitoring the welding parameters. Welding parameters were recorded as (A=128).

Ultrasonic Testing

This QA performed Ultrasonic Testing (UT) on approximately 1000mm of Electroslag (ESW) "ESW-A", 60mm to 70mm transition Complete Joint Penetration (CJP) butt splice weld from approximately (Y=4000mm~5000mm).

This welds section was previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.4.

This QA observed no rejectable or recordable indications at the time of testing. This QA generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

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This QA performed Ultrasonic Testing (UT) on approximately 1200mm of Electroslag (ESW) "ESW-D", 60mm to 70mm transition Complete Joint Penetration (CJP) butt splice weld from approximately (Y=3800mm~5000mm).

This welds section was previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.4.

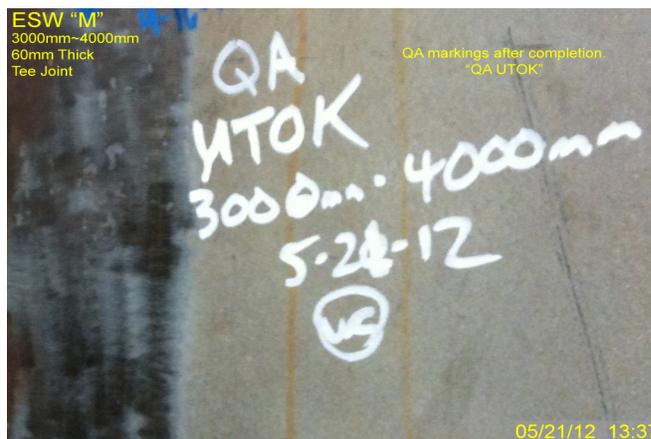
This QA observed no rejectable or recordable indications at the time of testing. This QA generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

This QA performed Ultrasonic Testing (UT) on approximately 1000mm of Electroslag (ESW) "ESW-M", 60mm 'T Joint' Complete Joint Penetration (CJP) weld from approximately (Y=3000mm~4000mm).

This welds section was previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.4.

This QA observed no rejectable or recordable indications at the time of testing. This QA generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

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

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Reviewed By: Levell,Bill

QA Reviewer