

**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-027644  
**Date Inspected:** 24-May-2012

**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.  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** 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:

**Tower****Electroslag Weld Excavations**

This QA randomly observed ABF/JV welding personnel performing excavation of welds previously Ultrasonic Testing (UT) rejected. Quality Control (QC) Inspector Jesse Cayabyab performed Magnetic Particle (MT) and visual confirmation of excavations. QC observed rejectable indications at the time of testing. Further repair and excavation are required for these welds. Excavations have been recorded and are to be submitted to engineer for further review.

Excavations were recorded as follows:

Weld "M" – Y=9150mm, L=210mm, W=55mm, D=40mm

Weld "M" – Y=8240mm, L=530mm, W=55mm, D=40mm

Weld "E" – Y=720mm, L=3420mm, W=45mm, D=40mm

This QA Inspector performed confirmation Magnetic Particle Testing (MT) of weld repair excavations on two locations on tower electroslag welds. This QA observed rejectable indications at the time of testing.

**In Process Visual Inspection**

This QA observed, at random intervals, ABF/JV qualified welder Richard Garcia #5892 performing Flux Core

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# WELDING INSPECTION REPORT

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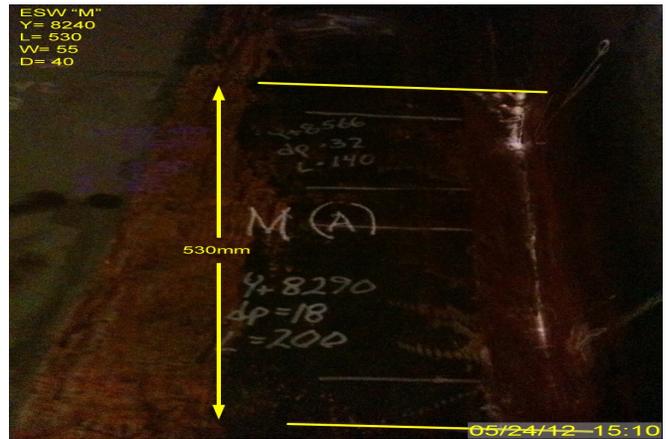
Arc Welding (FCAW) implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3160. The joint being welded was Weld #W007 at Tower Shear Base Assembly designated as ED1-829.

During welding, ABF Quality Control (QC) Jesse Cayabyab was noted monitoring the welding parameters. Welding parameters were recorded as (A=246, V=23.5).

## Note:

This QA spent the duration of this shift reviewing and documenting the status and completion of various punch list items. This QA photo documented the current status of punch list items for further review. In addition, this QA collected supporting documentation such as QC Daily and Non Destructive Testing (NDT) reports to be submitted with punch list findings.

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.

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**Inspected By:** Clifford, William

Quality Assurance Inspector

**Reviewed By:** Levell, Bill

QA Reviewer

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