

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-027688
Date Inspected: 01-Jun-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.	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:

Electroslag Weld Excavation

This QA observed ABF/JV welding personnel Xiao Jian Wan #9677 performing excavation of an Electroslag Weld (ESW) previously Ultrasonic Tested (UT) by Quality Control (QC) technicians.

The UT discovered indications were found to be oriented in both the transverse and longitudinal positions. The indications were found to range from rejectable per AWS D1.5 Table 6.4 to within the recordable criteria to be subject to further Radiographic Testing (RT).

The weld excavated is designated as "ESW E" and was excavated from Y location 6645mm for a length of 955mm. The final measured depth of this excavation was 38mm, with a measured width of 45mm.

The carbon arc gouging process as well as machine grinding were used to excavate approximately 2mm-5mm at a time. In between excavation passes both QA and QC performed Magnetic Particle Testing (MT) and photographed any discovered indications.

Throughout this excavation this QA observed and photographed intermittent transverse and longitudinal linear indications ranging in sizes from 2mm to 12mm.

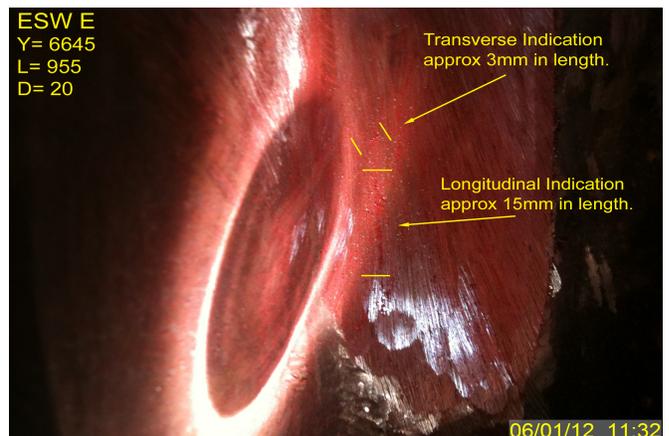
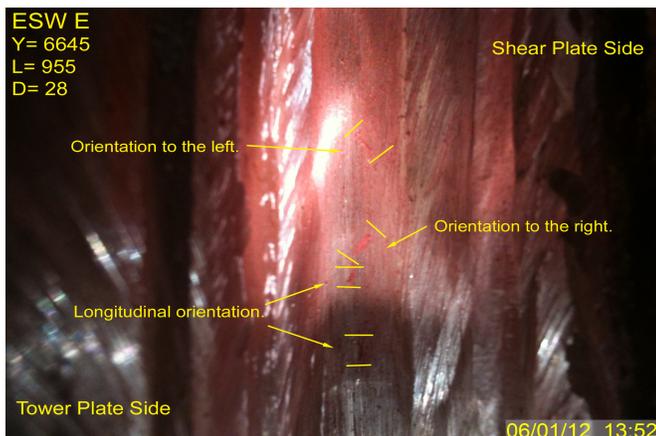
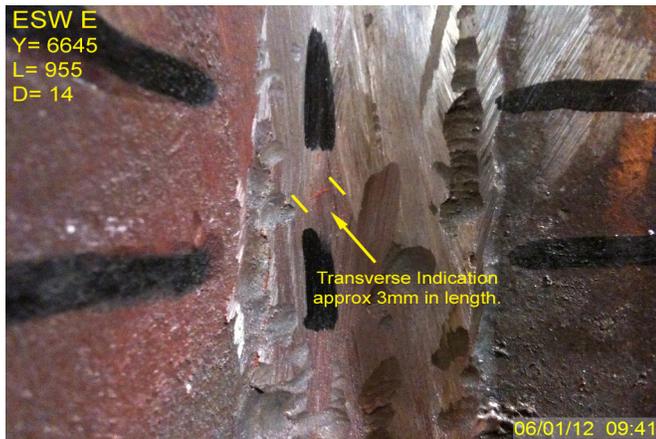
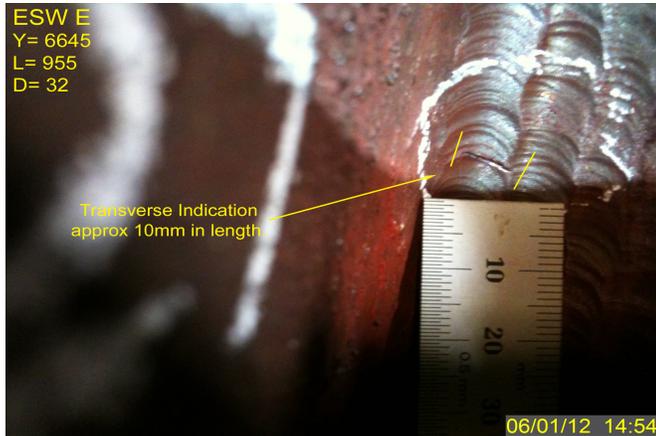
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Please see attached photographs for representative samples of indications observed.

QC MT and data recording was performed by Jesse Cayabyab and Steve McConnell. Others in attendance were Mazen Wahbeh, Robert Mertz, Aaron Prchlik, Bill Casey, Jim Bowers, Mohammad Awal, and Bob Turbin.

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



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Summary of Conversations:

Conversations were relevant to testing performed and indications discovered during excavation.

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
