

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-027689**Date Inspected:** 02-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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:

Electroslag Weld Excavations

This QA observed, at random intervals, ABF/JV qualified welder Jimmy Zhang #6001 performing Flux Core Arc Welding (FCAW) implementing Caltrans approved Welding Procedure Specification (WPS)

ABF-WPS-D15-3000-3Repair. The joint being welded was tower shear plate designated as ESW weld, location "H" from face A.

Dimensions excavated for this repair were: (Y=7200mm~7490mm)

During welding, ABF Quality Control (QC) Jesse Cayabyab was noted monitoring the welding parameters.

Welding parameters were recorded as (A=245, V=22.0).

This QA randomly observed ABF/JV qualified welder Xiao Jian Wan #9677 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification's (WPS) ABF-WPS-D15-1001. The joint being welded was tower shear plate designated as ESW weld, location "H" from face A.

Dimensions excavated for this repair were: (Y=4900mm~5140mm)

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During welding, ABF Quality Control (QC) Jesse Cayabyab was noted monitoring the welding parameters. Welding parameters were recorded as (A=129).

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. Excavations have been recorded and are to be submitted to engineer for further review.

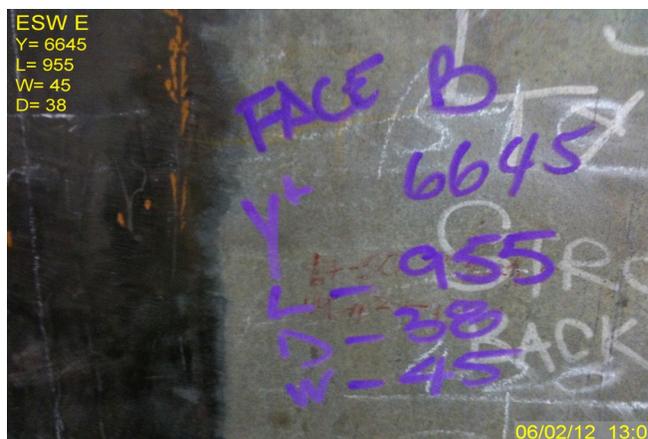
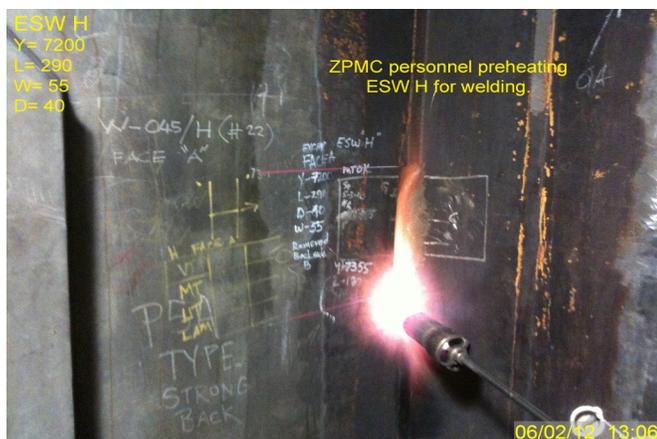
Excavations were recorded as follows:

Weld "E" – Y=6645mm, L=955mm, W=45mm, D=38mm (final excavation measurements)

Observation of QCUT:

QC Bernard Docena and QC Jesse Cayabyab performed Ultrasonic Testing (UT) of the completed welds designated as EWS R, ESW S, ESW N, and ESW W. Mr. Docena and Mr Cayabyab are testing per AWS D1.5 Table 6.4. Testing is currently in-process.

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