

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-027703**Date Inspected:** 05-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**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:

Tower

Electroslag Weld Repairs

This QA observed, at random intervals, ABF/JV qualified welder Xiao Jian Wan #9677 performing Flux Core Arc Welding (FCAW) implementing Caltrans approved Welding Procedure Specification Specification (WPS) ABF-WPS-D15-3000-3Repair. The joint being welded was tower shear plate designated as ESW weld, location "H" from face B.

Dimensions excavated for this repair were: (Y=7200mm~7530mm)

During welding, ABF Quality Control (QC) Jesse Cayabyab was noted monitoring the welding parameters. Welding parameters were recorded as (A=233, V=22.5).

Electroslag Weld Excavations

This QA randomly observed ABF/JV welding personnel performing excavation of a weld previously repaired from face A. Quality Control (QC) Inspector Jesse Cayabyab performed Magnetic Particle (MT) and visual confirmation of the excavation. QC observed no rejectable indications at the time of testing.

Excavations were recorded as follows:

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Weld "H" – Y=7200mm, L=330mm, W=35mm, D=20mm

This QA Inspector performed confirmation Magnetic Particle Testing (MT) of weld repair excavation on the above mentioned tower electroslag weld. This QA observed no rejectable indications at the time of testing.

This QA randomly observed ABF/JV welding personnel performing excavation of a weld previously repaired from face A. Quality Control (QC) Inspector Bernard Docena performed Magnetic Particle (MT) and visual confirmation of the excavation. QC observed no rejectable indications at the time of testing.

Excavations were recorded as follows:

Weld "P" – Y=780mm, L=700mm, W=50mm, D=64mm

This QA Inspector performed confirmation Magnetic Particle Testing (MT) of weld repair excavation on the above mentioned tower electroslag weld. This QA observed no rejectable indications at the time of testing.

Magnetic Particle Testing

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of 13m diaphragm to shear plate Partial Joint Penetration (PJP) weld designated as "Weld #111". This weld was previously accepted by QC Magnetic Particle technicians. This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

This QA tested approximately 15% (320mm) of 1840mm total.

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
