

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-027704
Date Inspected: 04-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: 1900
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**Ultrasonic Testing**

This QA performed Ultrasonic Testing (UT) on approximately 2230mm of Electroslag (ESW) Complete Joint Penetration (CJP) weld at "ESW W". Locations (Y=2100~3100 and 6500~7730) of this weld was inspected using this testing method. Testing was performed using 45 degree and 70 degree angles from both face A and face B.

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

This QA observed no rejectable 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 2230mm of Electroslag (ESW) Complete Joint Penetration (CJP) weld at "ESW N". Locations (Y=2200~3200 and 6500~7730) of this weld was inspected using this testing method. Testing was performed using 45 degree and 70 degree angles from both face A and face B.

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

This QA observed no rejectable indications at the time of testing. This QA generated a TL-6027 UT report on

WELDING INSPECTION REPORT

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this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

Observation of QCUT:

QC Bernard Docena performed Ultrasonic Testing (UT) of the completed welds designated as EWS T. Mr. Docena tested per AWS D1.5 Table 6.4. Testing is currently in-process.

QC John Pagliero performed Ultrasonic Testing (UT) of the completed welds designated as EWS F. Mr. Pagliero tested per AWS D1.5 Table 6.4. Testing is currently in-process.

QC Andrew Keach performed Ultrasonic Testing (UT) of the completed welds designated as EWS G. Mr. Keach tested per AWS D1.5 Table 6.4. Testing is currently in-process.

QC Bernard Docena performed Ultrasonic Testing (UT) of the completed welds designated as EWS N. Mr. Docena tested 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
