

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-027849**Date Inspected:** 25-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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 Excavation

At approximately 10:00am this QA had a meeting in the Tower ESW work area at the 9m elevation. Those in attendance were Mazen Wabeh, Bill Casey, Don Rager, Dave McQuaid, Mohammad Awal, Jim Bowers, Aaron Prchlik, Robert Mertz, and Leonard Cross.

In this meeting the attendees observed the excavation of QCUT rejectable indications as well as suspected transverse indications.

At approximately 15mm in depth longitudinal indications were observed. These indications were discovered both visually and through the Magnetic Particle Testing (MT) process.

The excavation was continued using a combination of carbon arc gouging and mechanical grinding. Several longitudinal and transverse indications were observed at varying lengths throughout.

Excavation was stopped at approximately 40mm in depth. Indications could still be observed at that time.

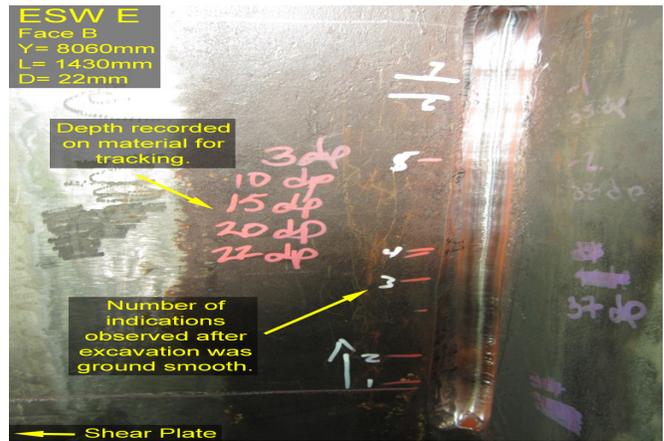
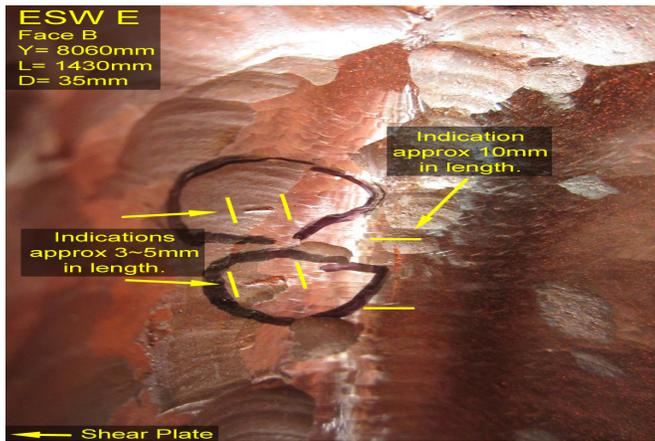
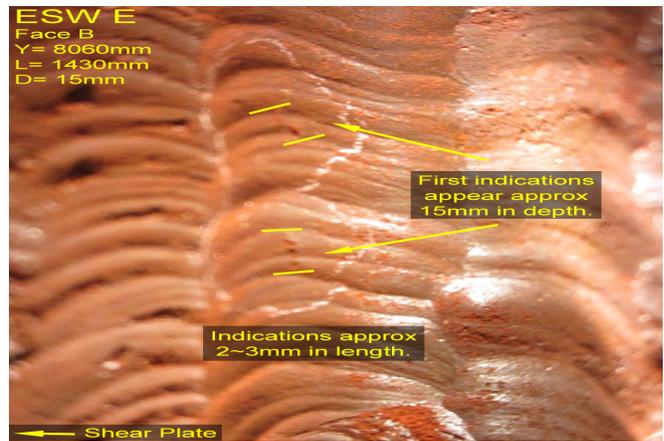
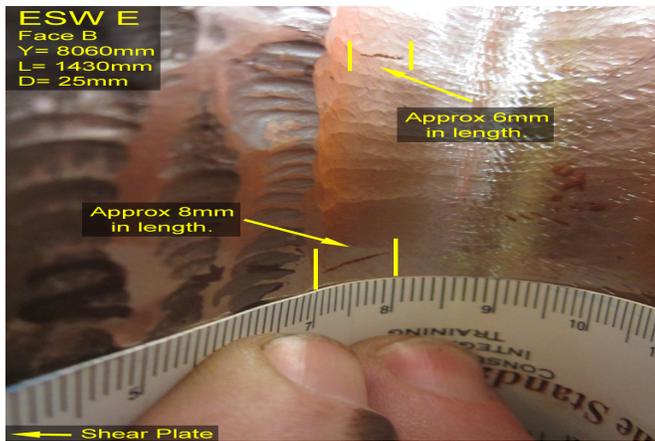
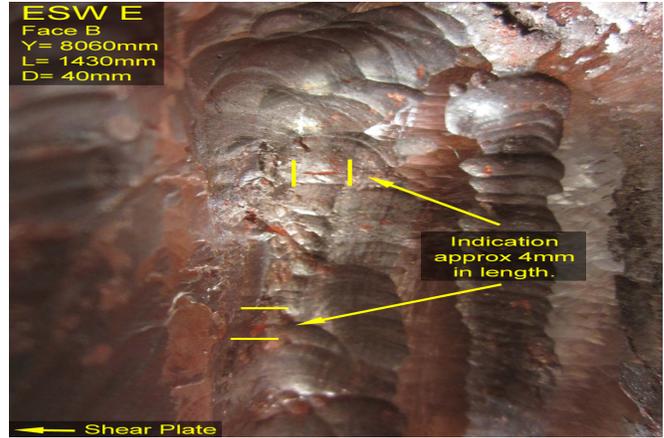
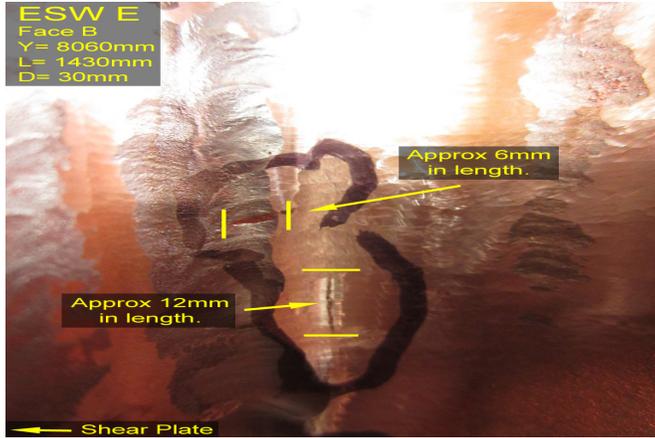
Please see photographs attached to this report for examples of indications observed

QC MT and data recording was performed by Bernard Docena and Jesse Cyabyab..

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.

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Inspected By:	Clifford, William	Quality Assurance Inspector
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Reviewed By:	Levell, Bill	QA Reviewer
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