

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-027859**Date Inspected:** 28-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:	N/A	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	

Summary of Items Observed:

Quality Assurance Inspector (QAI) Rodney Patterson 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:

The QAI was present for a pre-inspection procedural discussion together with ABF QC and Caltrans QA management and inspection teams, in order to discuss the revisions made to the supplemental Ultrasonic Testing (UT) procedure SE-UT-D1.5-CT-108-ESW-R3. The procedure has been utilized for the testing of the Tower Electro slag welding (ESW) shear plate connections to date. The topics of discussion included the additions to the procedure for the detection of transverse indications as well as procedural changes in the sizing of recordable indications. The QAI was informed that all future testing of these welds will be done together with the ABF QC inspectors to ensure comparable data between the inspection teams.

Ultrasonic Testing (Tower ESW-E-045- "B" Y=140~1500)

This QAI performed 100% Joint Ultrasonic Testing (UT), together with ABF QC inspector John Pagliero, on the Tower Complete Joint Penetration (CJP) butt joint shear plate connection designated as ESW-E-045- "B". During the QA/QC joint Ultrasonic Testing, scanning for longitudinal planar indications in accordance with supplemental procedure SE-UT-D1.5-CT-108-ESW-R3, multiple indications were noted at scanning level that appeared to measure near the grain boundaries/Heat affected zone of the tested Electro slag weld. The results of the joint inspection were deemed to be inconclusive in regards to recordable indications by the Caltrans QA Level III Robert Mertz using the revised criteria of the supplemental procedure. Additional Testing will be performed at a later date to determine the relevance of the indications found and to then revise the recordable indications section

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of the supplemental procedure to suit. The QAI did not observe any transverse indications from Y=140~1500 (face A) at the time of inspection.

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 Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
