

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-027894**Date Inspected:** 29-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:	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 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:

This QA was present for a pre-inspection procedural discussion together with Caltrans QA Level III Robert Mertz and QA Rodney Patterson, in order to discuss the Ultrasonic Testing (UT) performed at scanning level (+29db) of the Tower Electroslag Welds (ESW) Shear Plate Connections. It was determined, through the pitch-catch method, as well as with a 45 degree angled probe, that the signals observed on the screen throughout the entire length of the weld were likely caused by grain boundaries between the base material and the course grain electroslag weld. The supplemental procedure SE-UT-D1.5-CT-108-ESW-R3 used for testing the Tower Shear Plate connections is to be revised to reflect these new findings. The welds that were tested today were B, C, F, and G.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversations were relevant to testing performed.

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

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

for your project.

Inspected By:	Clifford, William	Quality Assurance Inspector
----------------------	-------------------	-----------------------------

Reviewed By:	Levell, Bill	QA Reviewer
---------------------	--------------	-------------