

**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-027905**Date Inspected:** 04-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Andrew Keech**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:** S.A.S. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI paired with the QCI Andrew Keech and continued surveying ESW weld H (W-045). The QAI noted that during the Ultrasonic Testing (UT) examination, multiple indications were observed. The QAI noted that the majority of indications are located while performing scanning pattern E and generally appear to have a transverse planar orientation. The QAI also identified planar indications (normal to the weld axis) that appear to be recordable according to the ABF ESW inspection procedure. The QAI will verify these indications again with the QCI present. The QAI noted that the weld cap is not ground flush and could affect the 1st leg examination of the planar recordable indications. The UT inspection was performed using 70 degree shear wave. The indications did not have a rating that qualifies as rejectable or recordable according to AWS D1.5 2002. The QAI and QCI were in general agreement regarding the location and nature of UT indications reported for ESW weld H (W045). The weld inspection was reported on the joint ESW inspection report and a TL-6027 report. Reference those documents for additional information. The QAI completed examining ESW weld H above the 9 meter diaphragm Y= 6000 to top of weld (approximately 9860) from face B, and began examining the weld below the 9 meter diaphragm Y= 5880 towards 0. These areas will be scanned by the QCI at a later time. The work was in progress at the end of the shift.

**Summary of Conversations:**

The QAI relayed the status of the UT inspections to the QAI Lead Bill Levell and Danny Reyes. There were other conversations between the QAI and ABF personnel regarding the access to welds and repairs in progress. The QAI and the QCI Andrew Keech had conversations regarding the ESW scanning and identification of indications.

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The QAI did not monitor any welding or repairs during this shift. Except as described above, there were no other notable 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.

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<b>Inspected By:</b>	Croff, Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

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