

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-027920**Date Inspected:** 05-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Pier 7 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 reviewed contract documents at pier 7. The QAI used approved weekly welding report submittals and cross referenced the welding and inspection status as reported with QA records to identify the overall weld status. The QAI completed reviewing submittal 1905R97, reference the TL-20 report for additional information. The QAI began reviewing the contractor's weekly welding reports. The QAI noted that welding report packages 117 - 122 have been provided for informal review. This work was in progress until the end of the shift.

The QAI met with Quality Control Inspector (QCI) Andrew Keech. The QCI has completed surveying ESW weld H (W-045) areas that were previously examined by the QAI. The QAI and QCI noted that during the Ultrasonic Testing (UT) examination, multiple indications were observed. The QAI and QCI 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 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) face B Y=6000-9850. The weld inspection was reported on the joint ESW inspection report and a TL-6027 report. Reference those documents for additional information.

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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. The QAI did not monitor any welding or repairs during this shift. The QAI relayed the status of the document reviews to the QAI Lead Bill Levell. 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.

Inspected By:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
