

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-027939**Date Inspected:** 09-Jul-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job site**CWI Name:** John Pagliero**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:

Electroslag Weld Excavations

This QA observed ABF/JV welding personnel Wai Kitlai #2953 performing an exploratory excavation of an Electroslag Weld ESW "F" from face A. The exploratory excavation was performed to determine the presence of transverse indications observed during the joint Ultrasonic Testing (UT) performed by the QAI and ABF QC inspector John Pagliero. Due to the presence of weld reinforcement the QAI was unable to size the length and measure the "X" location on the welds in way of the indications observed that were oriented transverse to the weld.

The carbon arc gouging process as well as grinding was used to excavate approximately 2mm-5mm at a time, once near the indications depth. In between excavation passes both QA and QC performed Magnetic Particle Testing (MT) and photographed any observed indications found at that depth. The weld ESW "F" was excavated at the following Y locations on this date. The details of the QA/QC findings are as follows;

ESW "F" Face A from Y=1180~1330 for a transverse indication ultrasonically detected at approximately Y=1245 (+4 AWS db rating.) The existing excavation was widened by 15mm at the beginning of the shift.

Existing excavation widened 10mm in depth-No Indications found

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- 15mm in depth-No Indications found
- 17mm in depth- No Indications found
- 19mm in depth- One (1) Transverse indication- Length 5mm.
- 20mm in depth- One (1) Transverse indication- Length 4mm.
- 21mm in depth-No Indications found.

ESW "F" Face A from Y=960~1180 for a transverse indication ultrasonically detected at approximately Y=1090 (+10 AWS db rating.)

- Initial Excavation 12mm in depth- No Indications found
- 14mm in depth- No Indications found

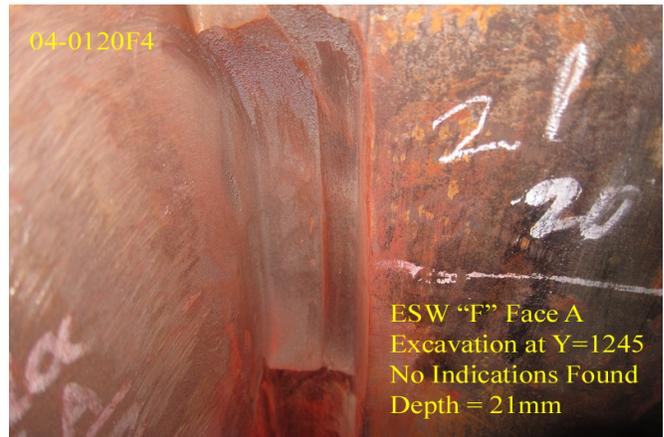
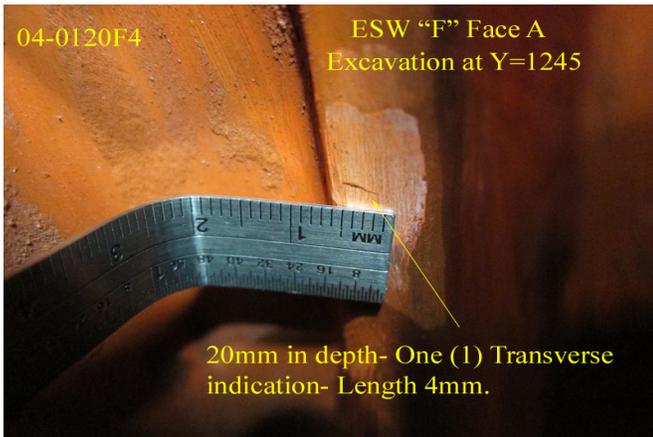
The sought depth of the indication was not reached during the QAI's shift. Further excavation will be required at a later shift.

Please see attached photographs for representative samples of indications observed.

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

Summary of Conversations:

No relevant conversations.



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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
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Reviewed By:	Levell,Bill	QA Reviewer
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