

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
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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-027940
Date Inspected: 10-Jul-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1930
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.

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

17mm in depth- One (1) Transverse indication- Length 5mm.

20mm in depth- One (1) Transverse indication- Length 4mm.

21mm in depth- No Indications found.

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

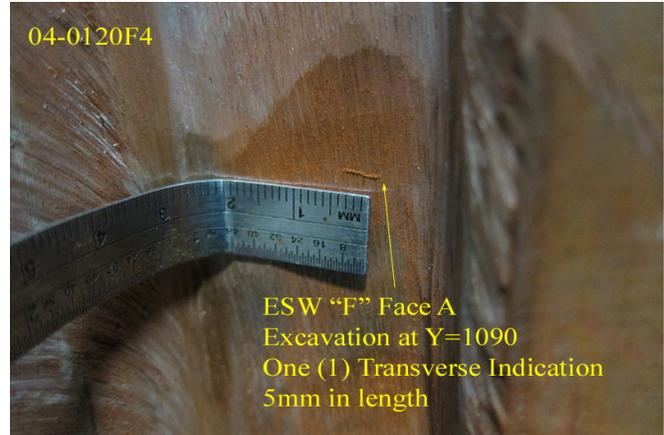
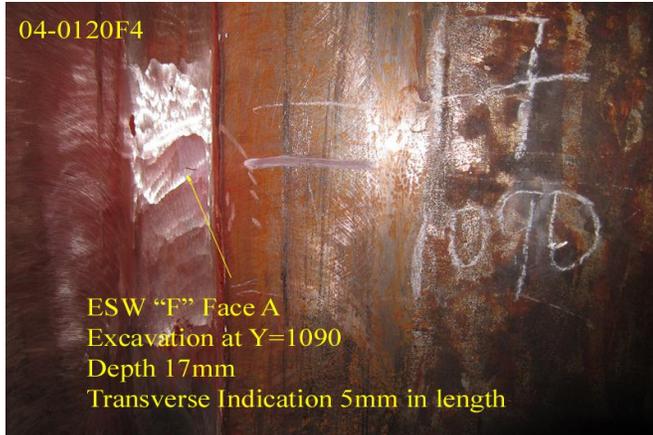
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documents.

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