

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-027975**Date Inspected:** 11-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:** Scott Kortem**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:

The QAI performed exploratory Ultrasonic Testing (UT) of the existing weld excavations for the Tower Complete Joint Penetration (CJP) Tee joint, shear plate connection designated as ESW- E-045 #24 "F" from Face A. The exploratory (UT) was performed in order to determine if the excavated weld was gouged sufficiently enough to remove the sought indications. The QAI's 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 terminated at 21mm in depth on a previous shift, after a 5mm visible transverse crack was removed. The ultrasonic response during testing in leg II from face A on this date shows the indication depth remains at 22mm. The QA engineer was notified that further grinding would be required in order to remove the discontinuity.

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

The existing excavation was terminated at 21mm in depth on a previous shift, after a 5mm visible transverse crack

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was removed. The ultrasonic response during testing in leg II from face A on this date shows the sought indication has been removed.

ESW "F" Face A from Y=790~960 for a transverse indication ultrasonically detected at approximately Y=900/940 (+16 and +23 AWS db rating.)

The existing excavation was terminated at 31mm in depth on a previous shift, after a total of three (3) 2~5mm visible transverse cracks were removed. The ultrasonic response during testing in leg II from face A on this date shows the indication depth at Y=900 remains at a depth of 32mm. The QA engineer was notified that further grinding would be required in order to remove the discontinuity.

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