

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-027996
Date Inspected: 17-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:	As noted below.	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 Component	

Summary of Items Observed:

Quality Assurance Inspector (QA) William Clifford 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:

Ultrasonic Testing of ESW

ESW J, Face B:

This QA performed Ultrasonic Testing (UT) on approximately 430mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as "ESW J" face B. Location (Y=1920~2350) of this weld was inspected using this testing method.

This weld was previously accepted by QC Ultrasonic technicians in accordance with supplemental procedure SE-UT-D1.5-CT-108-ESW-R5.

This QA observed no recordable indications at the time of testing.

This QA generated a TL-6027 UT report on this date.

The following indications were observed as having a transverse orientation. Due to joint configuration and weld cap shape these indications could not be evaluated for length or "X" location.

Indication #1: Y= 1940mm

Sizing – A=78db, B= 54db, C= 9db, D= 15db

Sound Path= 145.0mm, Depth= 46.75mm

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Indication #2: Y= 2010mm

Sizing – A=80db, B= 54db, C= 6db, D= 20db

Sound Path= 105.5mm, Depth= 34.0mm

Indication #3: Y= 2045mm

Sizing – A=71db, B= 54db, C= 5db, D= 12db

Sound Path= 88.21mm, Depth= 28.42mm

Indication #4: Y= 2070mm

Sizing – A=75db, B= 54db, C= 6db, D= 15db

Sound Path= 105.0mm, Depth= 33.85mm

Indication #5: Y= 2105mm

Sizing – A=83db, B= 54db, C= 7db, D= 22db

Sound Path= 118.5mm, Depth= 38.21mm

Indication #6: Y= 2180mm

Sizing – A=83db, B= 54db, C= 8db, D= 21db

Sound Path= 131.3mm, Depth= 42.31mm

Indication #7: Y= 2270mm

Sizing – A=79db, B= 54db, C= 6db, D= 19db

Sound Path= 106.3mm, Depth= 34.27mm

Indication #8: Y= 2300mm

Sizing – A=79db, B= 54db, C= 5db, D= 20db

Sound Path= 93.12mm, Depth= 30.01mm

Indication #9: Y= 2320mm

Sizing – A=79db, B= 54db, C= 6db, D= 19db

Sound Path= 98.89mm, Depth= 32.86mm

This QA performed UT of weld designated as ESW H in accordance with the approved supplemental procedure. This testing was performed in tandem with QC technician Scott Kortum. Tandem report for work performed on this date will be completed by QC technician and signed by both QA/QC parties. Items listed on tandem report reflect indications agreed upon by QA/QC. Due to QA/QC disagreement on indication interpretation, tandem report may not reflect all indications discovered by QA at time of testing. Please see TL-6027 for complete listing of QA recorded indications.

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

Summary of Conversations:

Conversations were relevant to testing performed.

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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 SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford,William	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
