

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-028145**Date Inspected:** 08-Aug-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:** 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 / OBG**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:

Electroslag Weld Repair Welding

This QA observed, at random intervals, ABF/JV qualified welder James Zhen #6001 continue performing Flux Core Arc Welding (FCAW) implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3000-3Repair. The joint being welded was tower shear plate designated as ESW weld, location "B" from face A.

Weld "B" - Y= 7800mm, L= 680mm, W= 67mm, D= 40mm

During welding, ABF Quality Control (QC) Andrew Keech were noted monitoring the welding parameters.

Electroslag Weld Excavation

This QA observed, at random intervals, ABF/JV welding personnel Wen Han Yu #6317 performing excavation of an Electroslag Weld (ESW) previously Ultrasonic Tested (UT) by Quality Control (QC) technicians.

The UT discovered indication was found to be oriented in the longitudinal position. The indication was found to be rejectable per AWS D1.5 Table 6.4).

The weld being excavated is designated as "ESW G" and was excavated on Face A at location:

Weld "C" - Y= 5485mm, L= 150mm, W= 40mm, D= 33mm

13W

