

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-028223**Date Inspected:** 19-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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**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:

ESW RWR Tracking

This QA was instructed by Task Leader Bill Levell to generate a spread sheet for the tracking of Request for Weld Repair (RWR) forms submitted by ABF for the repair of Electroslag Welds located at the base of the Tower. This assigned task requires review of all submitted RWR's as well as review of approved QA TL-6031 daily report forms applicable to this welding, testing, and repair. In addition to review of applicable QA Ultrasonic Testing Reports (TL-6027), Magnetic Particle Testing Reports (TL-6028), and Daily Reports this QA produced duplicate tracking and forms to be stored in the job-site "connex" for QA Task Leader Bill and QA Lead Inspector Daniel Reyes. This QA used the balance of time not dedicated for in-process inspection and testing to work on this task. This task is currently on going.

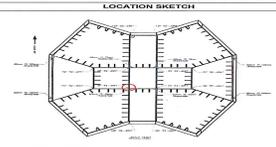
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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REQUEST FOR WELD REPAIR APPROVAL

Project: SFOOB Self-Anchored Suspension Bridge | Contract No.: 04-03004 | Rev 0

Inspector: J. Dowser	Date: 16 May 2012	Weld Repair Report No: 201205-011
Repair Type: <input checked="" type="checkbox"/> Weld Metal <input checked="" type="checkbox"/> Base Metal <input type="checkbox"/> SPM <input type="checkbox"/> Yes <input type="checkbox"/> No <input checked="" type="checkbox"/> Critical <input type="checkbox"/> Non-Critical <input checked="" type="checkbox"/>	NDT Report No.: n/a	
Weld Specifications Drawing No: n/a Part No: Tower Slender Plate Weld No: S-045 Welder ID: 3232 Welder ID: n/a Process(es): SMAW <input checked="" type="checkbox"/> FCAW <input type="checkbox"/> SMAW <input type="checkbox"/> SAW <input type="checkbox"/> ESW <input checked="" type="checkbox"/> Date Welded: 13/02/2011 Layer: Root <input type="checkbox"/> Surface <input type="checkbox"/> Other <input checked="" type="checkbox"/> Intermediate <input type="checkbox"/> Date Inspected: 20/01/2011 Position: XC Joint: Joint Designation: ESW-NG1 Square Groove		
REPAIR PROCEDURE Repair Process(es): SMAW <input checked="" type="checkbox"/> FCAW <input type="checkbox"/> GMAW <input type="checkbox"/> SAW <input type="checkbox"/> ESW <input checked="" type="checkbox"/> Repair WPS: ABE-WPS-1313-1001-Repair Production WPS: n/a Total Weld Length: 2835 mm Total Repair Length Indicated: 23mm Excavation Method(s): Chipping Only <input checked="" type="checkbox"/> Carbon Arc Gouge (CAG) <input type="checkbox"/> Other <input type="checkbox"/> Excavation Footprint Required: Yes <input checked="" type="checkbox"/> No <input type="checkbox"/> Minimum Trench Requirement: n/a Repair Weld Front(s): Pair Repair WPS: <input checked="" type="checkbox"/> Additional: <input type="checkbox"/> Temp: n/a Post Weld Heat Required: Yes <input type="checkbox"/> No <input checked="" type="checkbox"/> Temp: n/a		
LOCATION SKETCH 		

Form No: ABE-OC-117 Page 1 of 3

Approval (Tracking Log)																
Contract No: 04-03004																
4	Designation	Critical	Submitted	WPS Used	Exploratory Excavation	Initial Inspection Date:	Submitted Excavation Length:	QA or QC Indication	Rejectable or Recordable	MT or UT Indication Y:	Indication X:	Indication Depth from Face A:	Actual Excavated Length:	Excavated Depth:	From Face:	Report Complete Date:
5	ESW B	No	1001-Repair			6/7/2012	50mm	QC	Rec	UT	810mm	+30mm	52mm	240mm	17mm	B
6	ESW B	No	1001-Repair			6/10/2012	60mm	QC	Rec	UT	760mm	N/A	N/A	610mm	40mm	A
7	ESW B	No	1001-Repair			6/29/2012	50mm	Both	Rec	UT	1095mm	10mm	55mm	190mm	40mm	B
8	ESW B	No	1001-Repair			7/1/2012	20mm	Both	Rec	UT	3940mm	3mm	59mm	170mm	19mm	A
9	ESW B	No	1001-Repair			7/2/2012	30mm	Both	Rec	UT	6430mm	+110mm	49mm	200mm	34mm	A
10	ESW B	No	1001-Repair			7/1/2012	60mm	Both	Rec	UT	960mm	+112mm	53mm	150mm	38mm	A
11	ESW C	No	1001-Repair			6/6/2012	60mm	QC	Rec	UT	920mm	0mm	25mm	150mm	33mm	A
12	ESW C	No	1001-Repair			7/1/2012	10mm	Both	Rec	UT	400mm	+12mm	29mm			
13	ESW C	No	1001-Repair			7/2/2012	10mm	Both	Rec	UT	520mm	+12mm	26mm	150mm	33mm	B
14	ESW E	No	1001-Repair			6/20/2012	2250mm	QC	Both	UT	760mm			2250mm	40mm	B
15	ESW E	No	1001-Repair			6/20/2012	2250mm	QC	Rec	UT	760mm	N/A	20mm	2250mm	40mm	B
16	ESW F	No	1001-Repair			6/5/2012	120mm	QC	Rec	UT	180mm	0mm	59mm			
17	ESW F	No	1001-Repair			6/5/2012	110mm	QC	Rec	UT	340mm	0mm	42mm			
18	ESW F	No	1001-Repair			6/5/2012	80mm	QC	Rec	UT	840mm	6mm	37mm			
19	ESW F	No	1001-Repair			7/2/2012	65mm	QC	Rec	UT	3920mm	+135mm	51mm			
20	ESW G	No	1001-Repair			6/1/2011	95mm	QC	Rec	UT	4360mm	+130mm	42mm			
21	ESW G	No	1001-Repair			7/13/2012	70mm	QC	Rec	MT	5600mm	N/A	N/A			
22	ESW G	No	1001-Repair			7/13/2012	180mm	QC	Rec	UT	2800mm	+17mm	41mm	670mm	49mm	A
23	ESW H	No	1001-Repair			7/13/2012	90mm	QC	Rec	UT	370mm	+110mm	34mm	35mm	53mm	A

Summary of Conversations:

Conversations were relevant to work performed.

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