

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-028648**Date Inspected:** 26-Oct-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:

This QA met with Caltrans QA Robert Mertz and QC Representative Leonard Cross to discuss establishing an Ultrasonic Testing (UT) procedure for determining the "height" of planar indications discovered in the tower electroslag (ESW) shear plate welds. QC technician Andrew Keech and QA Fritz Belford performed testing in order to determine if the "6db drop" method could be used to ascertain a "height". Other methods for determining planar height were discussed as well. The need for a correction factor was also suggested and will require more research to determine to what extent it would be necessary.

Mr. Cross is to submit method suggestions to Mr. Mertz in the coming weeks as research testing is continued.

ESW RWR Tracking

This QA was instructed by Task Leader Daniel Reyes to perform a visual accounting of current tower electroslag weld status (ie: repair, completion of QA/QC testing). This QA previously generated an excel 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 QA continued review of all submitted RWR's as well as review of approved QA TL-6031 report forms applicable to this welding, testing, and repair to supplement current status information. This QA used the balance of time not allocated for in-process inspection and testing to work on this task.

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

WELDING INSPECTION REPORT

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Summary of Conversations:

As noted above.

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 Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William	Quality Assurance Inspector
Reviewed By:	Reyes, Danny	QA Reviewer
