

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-028685**Date Inspected:** 31-Oct-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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:

There was no joint Ultrasonic Testing (UT) performed during this shift. Quality Control technician Andrew Keech assisted QC representative Leonard Cross and QC technician Jesse Cayabyab in performing exploratory UT of planar defects previously discovered in the tower electroslag shear plate welds (ESW). Along with QA technician Rodney Patterson, testing was being performed to determine if an accurate "height" for planar indications could be ascertained using the "6dB drop" method of sizing. Testing is on-going at this time.

ESW RWR Tracking (Continued)

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.

Update:

ESW K

WELDING INSPECTION REPORT

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Initial welding and repair welding complete.
Requires QA testing. UT/MT
Have not been officially released to us.

ESW L

Initial welding and repair welding complete.
Requires QA testing. UT/MT
Have not been officially released to us.

ESW M

Initial welding and repair welding complete.
Requires QA testing. UT/MT
Have not been officially released to us.

ESW N

Two QC UT Rejects.
Has not been addressed by ABF.

ESW P

Process breakdown at top not completed.
(Y=8750mm)
Some grinding performed on surface.

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

Summary of Conversations:

Conversation was relevant to inspection performed during this shift.

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
