

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-028806
Date Inspected: 29-Nov-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: 1730
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:

Ultrasonic Testing of ESW

ESW G:

This QA performed Ultrasonic Testing (UT) of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as ESW "G".

This testing was performed in tandem with QC Ultrasonic technician Jesse Cayabyab in accordance with supplemental procedure SE-UT-D1.5-CT-108-ESW-R5.

Testing was performed to verify presence of planar indications to be excavated and visually documented for planar height. Planar height was determined using the "6db drop amplitude" method. This QA verified location, depth, and indication ratings for assigned indications at each joint.

The following indications were observed. Y locations are recorded as:

Y= 8030mm, L= 30mm

A= 63db, B= 52db, C= 2db, D= 9db

SP= 56mm, DP= 19mm

Planar Height= 15mm~24mm

Y= 8030mm, L= 55mm

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A= 65db, B= 53db, C= 7db, D= 5db

SP= 112mm, DP= 37mm

Planar Height= 31mm~42mm

Y= 7240mm, L= 40mm

A= 62db, B= 52db, C= 4db, D= 6db

SP= 81mm, DP= 27mm

Planar Height= 23mm~33mm

Y= 2000mm, L= 35mm

A= 68db, B= 52db, C= 8db, D= 8db

SP= 132mm, DP= 44mm

Planar Height= 39mm~50mm

This QA performed observation of excavation of Electroslag Weld (ESW) designated as ESW G. Excavation was performed at location (Y= 7180mm~7400mm).

Recorded observations at depth:

-10mm

No indications observed.

Excavation has been halted at end of shift

Excavation was performed by ABF personnel Reginald Humphrey using a mechanical grinder removing approximately 1mm at a time. This QA observed Quality Control Inspector Jesse Cayabyab performing visual inspection and Magnetic Particle Testing (MT) of this excavation between passes. This QA performed visual inspection and intermittent verification MT of this excavation between passes.

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

Summary of Conversations:

Conversation was relevant to testing/excavation 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
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Reviewed By:	Reyes, Danny	QA Reviewer
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