

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-028947**Date Inspected:** 02-Jan-2013**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:** 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:

This QA observed, at random intervals, an ABF/JV welder, Chris Bruce #8901, performing Shielded Metal Arc Welding (SMAW) with 4.0mm diameter E7018-MH4-R electrode and implementing Caltrans Welding Procedure Specification (WPS) ABF-WPS-D15-1000R. Welding was performed on the longitudinal seam location designated as 13W-W2.1-C1.

This weld is not a Seismic Performance Critical Member (SPCM) member.

Y= 29485mm, D=11mm, W=25mm, L=100mm

Y= 29865mm, D=13mm, W=30mm, L=110mm

Y= 30060mm, D=13mm, W=30mm, L=220mm

Y= 30300mm, D=13mm, W=25mm, L=150mm

Y= 30470mm, D=10mm, W=20mm, L=100mm

Y= 30560mm, D=10mm, W=20mm, L=80mm

Y= 30830mm, D=12mm, W=25mm, L=110mm

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters.

Ultrasonic Testing

This QA Inspector performed Ultrasonic Testing (UT) of approximately 100% of the area previously tested by

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QC Ultrasonic technicians. The joint is a Complete Joint Penetration (CJP) welded utilizing the Shielded Metal Arc Welding (SMAW) with 1/8" diameter E9018-MH4-R electrode and implementing Caltrans Welding Procedure Specification (WPS) ABF-WPS-D15-1012-3. The joints welded was internal longitudinal stiffener butt splice designated as 12E-pp116.5-E5-LSW.

This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

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

Summary of Conversations:

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