DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-028981
Date Inspected: 08-Jan-2013

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:

This QA performed observation of excavation of Electroslag Weld (ESW) designated as ESW T, Face A. Excavation was performed at location (Y= 3600mm~4000mm).

Recorded observations at depth:

-27mm depth
Two (2) indications observed.
(Longitudinal)
Y= 3790mm
L= 30mm
(Longitudinal)
Y= 3800mm
L= 40mm

-28mm depth
One (1) indication observed.
(Longitudinal)

Y= 3800mm
L= 50mm
* This indication had a 15mm transverse indication connected to the bottom.

-29mm depth
Two (2) indications observed.
(Longitudinal)
Y= 3775mm
L= 75mm

-30mm depth
(Longitudinal)
Y= 3775mm
L= 75mm

Per ABF instruction. Excavation rate has been increased to 3mm at a pass.
1mm pass will be reinstituted at discovery of planar type indication.

This QA performed observation of excavation of Electroslag Weld (ESW) designated as ESW T, Face B.
Excavation was performed at location (Y= 3250mm~3500mm).

-10mm depth.
No indications observed.

-11mm depth.
No indications observed.

-16mm depth.
No indications observed.

-17mm depth.
No indications observed.

-18mm depth.
No indications observed.

-19mm depth.
No indications observed.

-20mm depth.
No indications observed.

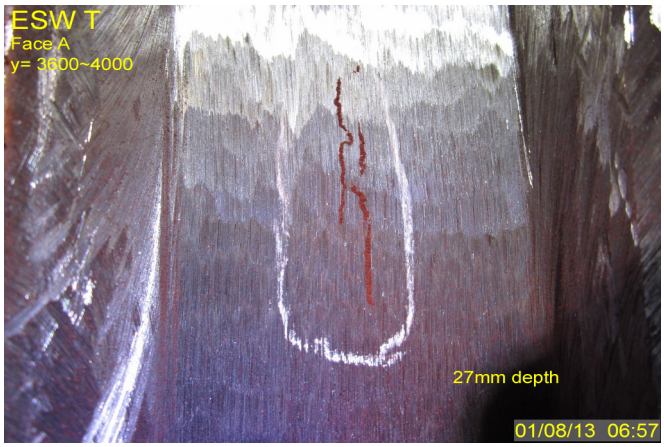
-21mm depth.
No indications observed.

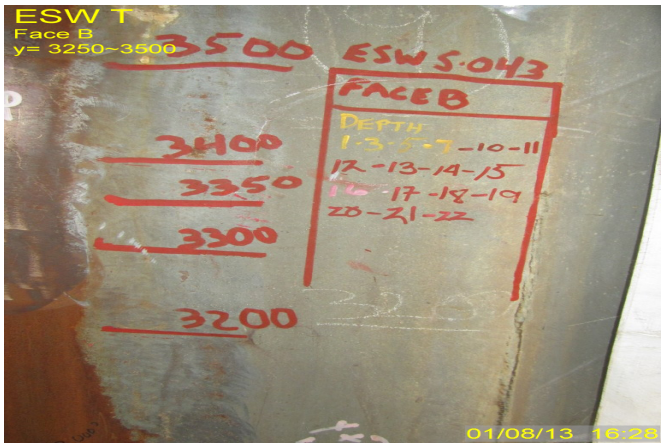
-22mm depth.
No indications observed.

Excavation efforts have been halted due to end of shift.

Excavation was performed by ABF welding personnel using a mechanical grinder removing approximately 1-3mm at a time. This QA observed Quality Control Inspectors Andrew Keech and Jesse Kayabyab 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 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