

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-028982
Date Inspected: 09-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:

-31mm depth

One (1) indication observed.

(Longitudinal)

Y= 3775mm

L= 75mm

-33mm depth

Two (2) indications observed.

(Longitudinal)

Y= 3775mm

L= 70mm

(Slag)

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Y= 3730mm

L= 3mm

-34mm depth

Two (2) indications observed.

(Longitudinal)

Y= 3775mm

L= 70mm

(Slag)

Y= 3730mm

L= 3mm

-35mm depth

Four (4) indications observed.

(Longitudinal)

Y= 3775mm

L= 75mm

(Slag)

Y= 3730mm

L= 3mm

(Longitudinal)

Y= 3730mm

L= 6mm

(Longitudinal)

Y= 3720mm

L= 15mm

-36mm depth

Three (3) indications observed.

(Longitudinal)

Y= 3780mm

L= 80mm

(Slag)

Y= 3735mm

L= 5mm

(Slag)

Y= 3850mm

L= 2mm

-37mm depth

Four (4) indications observed.

(Longitudinal)

Y= 3780mm

L= 80mm

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(Slag)

Y= 3735mm

L= 5mm

(Slag)

Y= 3850mm

L= 2mm

(Longitudinal)

Y= 3850mm

L= 2mm

-38mm depth

Two (2) indications observed.

(Longitudinal)

Y= 3780mm

L= 75mm

(Slag)

Y= 3735mm

L= 5mm

Per ABF instruction. Excavation rate has been increased to 3mm at a pass.

1mm pass will be reinstated 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).

-23mm depth.

No indications observed.

-24mm depth.

No indications observed.

-25mm depth.

(Longitudinal)

Y= 3360mm

L= 5mm

-26mm depth.

(Longitudinal)

Y= 3360mm

L= 5mm

-27mm depth.

(Longitudinal)

Y= 3360mm

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L= 5mm

-28mm depth.
(Longitudinal)

Y= 3360mm

L= 5mm

-29mm depth.
(Longitudinal)

Y= 3360mm

L= 5mm

-30mm depth.
(Longitudinal)

Y= 3360mm

L= 5mm

-31mm depth.
(Longitudinal)

Y= 3360mm

L= 5mm

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
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Reviewed By:	Reyes, Danny	QA Reviewer
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