

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-028983
Date Inspected: 10-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:

-39mm depth
One (1) indication observed.
(Longitudinal)
Y= 3780mm
L= 75mm

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

Ultrasonic Testing of ESW

WELDING INSPECTION REPORT

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ESW V, Face B:

This QA performed Ultrasonic Testing (UT) on approximately 1000mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as "ESW V" face B. Location (Y=7000~8000) of this weld was inspected using this testing method.

This weld was previously accepted by QC Ultrasonic technicians in accordance with supplemental procedure SE-UT-D1.5-CT-108-ESW-R5.

This QA observed no recordable indications at the time of testing.

This QA generated a TL-6027 UT report on this date.

The following indications were observed as having a transverse orientation. Due to joint configuration and weld cap shape these indications could not be evaluated for length or "X" location.

Indication #1: Y= 7740mm

Sizing – A=74db, B= 51db, C= 9db, D= 14db

Sound Path= 135mm, Depth= 34mm

Indication #2: Y= 7820mm

Sizing – A=80db, B= 51db, C= 7db, D= 22db

Sound Path= 110mm, Depth= 42mm

This QA performed UT of weld designated as ESW V in accordance with the approved supplemental procedure. This testing was performed in tandem with QC technician Jesse Cayabyab. Tandem report for work performed on this date will be completed by QC technician and signed by both QA/QC parties. Items listed on tandem report reflect indications agreed upon by QA/QC. Due to QA/QC disagreement on indication interpretation, tandem report may not reflect all indications discovered by QA at time of testing. Please see TL-6027 for complete listing of QA recorded indications.

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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