

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-028988
Date Inspected: 12-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: 1530
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 J, Face A:

This QA performed Ultrasonic Testing (UT) on approximately 2200mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as "ESW J" face A. Location (Y=7000~9200) 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 longitudinal 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= 7060mm

Sizing – A=79db, B= 51db, C= 6db, D= 22db

Sound Path= 102mm, Depth= 35mm

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Indication #2: Y= 7100mm

Sizing – A=79db, B= 51db, C= 5db, D= 23db

Sound Path= 87mm, Depth= 29mm

Indication #3: Y= 7190mm

Sizing – A=79db, B= 51db, C= 4db, D= 24db

Sound Path= 80mm, Depth= 27mm

Indication #4: Y= 7380mm

Sizing – A=79db, B= 51db, C= 6db, D= 22db

Sound Path= 106mm, Depth= 36mm

Indication #5: Y= 7520mm

Sizing – A=76db, B= 51db, C= 6db, D= 19db

Sound Path= 94mm, Depth= 32mm

Indication #6: Y= 8260mm

Sizing – A=70db, B= 51db, C= 7db, D= 12db

Sound Path= 119mm, Depth= 40mm

Indication #7: Y= 8400mm

Sizing – A=72db, B= 51db, C= 6db, D= 15db

Sound Path= 94mm, Depth= 32mm

Indication #8: Y= 8470mm

Sizing – A=76db, B= 51db, C= 6db, D= 19db

Sound Path= 106mm, Depth= 36mm

Indication #9: Y= 8625mm

Sizing – A=77db, B= 51db, C= 6db, D= 20db

Sound Path= 104mm, Depth= 35mm

Indication #10: Y= 8635mm

Sizing – A=79db, B= 51db, C= 6db, D= 22db

Sound Path= 99mm, Depth= 34mm

Indication #11: Y= 8680mm

Sizing – A=73db, B= 51db, C= 8db, D= 14db

Sound Path= 129mm, Depth= 44mm

Indication #12: Y= 8770mm

Sizing – A=74db, B= 51db, C= 5db, D= 18db

Sound Path= 85mm, Depth= 29mm

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

Indication #13: Y= 8810mm

Sizing – A=74db, B= 51db, C= 4db, D= 19db

Sound Path= 77mm, Depth= 26mm

Indication #12: Y= 8850mm

Sizing – A=71db, B= 51db, C= 7db, D= 13db

Sound Path= 111mm, Depth= 38mm

Indication #13: Y= 9035mm

Sizing – A=76db, B= 51db, C= 5db, D= 20db

Sound Path= 87mm, Depth= 29mm

Indication #14: Y= 9090mm

Sizing – A=78db, B= 51db, C= 5db, D= 22db

Sound Path= 93mm, Depth= 32mm

Indication #15: Y= 9100mm

Sizing – A=77db, B= 51db, C= 4db, D= 23db

Sound Path= 73mm, Depth= 25mm

Indication #16: Y= 9190mm

Sizing – A=77db, B= 51db, C= 3db, D= 24db

Sound Path= 64mm, Depth= 22mm

Indication #17: Y= 9160mm

Sizing – A=76db, B= 51db, C= 7db, D= 18db

Sound Path= 108mm, Depth= 37mm

This QA performed UT of weld designated as ESW P 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.

Summary of Conversations:

Conversation was relevant to testing 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.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

Inspected By: Clifford, William

Quality Assurance Inspector

Reviewed By: Reyes, Danny

QA Reviewer