

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-028994
Date Inspected: 17-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: jobsite

CWI Name:	Andrew Keech	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:	SAS project	

Summary of Items Observed:

This Quality Assurance (QA) Inspector, Craig Hager was on site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and /or monitor American Bridge/Fluor (ABF) welding operations. This Quality Assurance (QA) Inspector, Craig Hager observed the following.

This QA Inspector randomly observed QC Inspector Andrew Keech performing Ultrasonic Testing (UT) for UT indications both parallel and transverse to the weld. The area of inspection was the Electro Slag Weld (ESW) on the shear plates, weld joint "K", face A, 150° Tee Joint configuration. Ultrasonic testing was performed from Y-8000 to Y-9810.

This QA Inspector performed a verification UT of the same area and within this area a total of 3 indications were observed; all transverse.

This QA Inspector compared the UT data obtained with that obtained by QC Inspector Andrew Keech; the results were basically the same.

The UT performed was with a 70 degree shearwave transducer. For specific details see Ultrasonic Testing Report (TL-6027) this date.

This QA Inspector randomly observed as QC Inspector Andrew Keech performed UT at ESW-N from both face-A and face-B, at approximately Y-5460 to Y-5575. This QA Inspector was informed repair welding had been

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performed at this location the previous day and ABF welding foreman Erick Sparks had requested the areas be inspected. Prior to the completion of the inspections QC Inspector Andrew Keech was pulled from this location to attend a meeting with ABF personnel regarding the priority of work. Per ABF personnel the current priority was all ESW welds located at Y-7300 and greater. QC Inspector Andrew Keech did not return to the previous locations to complete the inspection, but was assigned the following location; weld ESW-V, Y-7610 and Y-7725. ABF foreman Erick Sparks requested the UT to verify the location of several recordable indications. This QA Inspector observed as the UT was performed and the as the locations of the indications was marked on the B-face (outside face) of the weld. In general the work observed appeared to comply with the contract requirements.

Summary of Conversations:

This QA Inspector had general conversations with American Bridge/Fluor (ABF) personnel, QC personnel and Caltrans personnel during the shift. Except as described above there were no notable conversations.

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) 674-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer
