

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-029012
Date Inspected: 16-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:

Ultrasonic Testing of ESW

ESW E, Face A:

This QA performed Ultrasonic Testing (UT) on approximately 2000mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as "ESW E" face A. Location (Y=6000~8000) of this weld was inspected using this testing method.

This QA observed three (3) recordable longitudinal indications at the time of testing.

This QA has not generated a TL-6027 UT report on this date. Findings have not been joint verified by Quality Control inspection personnel at this time. This QA will generate a TL-6027 at the time of concurrence.

Indication #1: Y= 6095mm

Sizing – A=72db, B= 50db, C= 7db, D= 15db

Sound Path= 109mm, Depth= 38mm

Indication #2: Y= 6110mm

Sizing – A=75db, B= 50db, C= 8db, D= 17db

Sound Path= 121mm, Depth= 43mm

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Indication #3: Y= 6185mm

Sizing – A=78db, B= 50db, C= 2db, D= 22db

Sound Path= 97mm, Depth= 34mm

Indication #4: Y= 6270mm

Sizing – A=76db, B= 50db, C= 7db, D= 19db

Sound Path= 114mm, Depth= 40mm

Indication #5: Y= 6280mm

Sizing – A=78db, B= 50db, C= 6db, D= 22db

Sound Path= 99mm, Depth= 35mm

Indication #6: Y= 6555mm

Sizing – A=79db, B= 50db, C= 8db, D= 11db

X= -10mm, L= 17mm

Sound Path= 125mm, Depth= 44mm

Indication #7: Y= 6660mm

X= -8mm, L= 15mm

Sizing – A=69db, B= 50db, C= 5db, D= 14db

Sound Path= 86mm, Depth= 30mm

Indication #8: Y= 7670mm

X= -4mm, L= 25mm

Sizing – A=61db, B= 50db, C= 4db, D= 7db

Sound Path= 70mm, Depth= 25mm

ESW A, Face B:

This QA performed Ultrasonic Testing (UT) on approximately 1000mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as “ESW A” face B. Location (Y=6000~7000) of this weld was inspected using this testing method.

This QA observed two (2) recordable longitudinal indications at the time of testing.

This QA has not generated a TL-6027 UT report on this date. Findings have not been joint verified by Quality Control inspection personnel at this time. This QA will generate a TL-6027 at the time of concurrence.

Indication #1: Y= 6865mm

X= -1mm, L= 17mm

Sizing – A=65db, B= 50db, C= 7db, D= 8db

Sound Path= mm, Depth= mm

Indication #2: Y= 6920mm

X= -1mm, L= 17mm

Sizing – A=69db, B= 50db, C= 5db, D= 14db

Sound Path= 87mm, Depth= 30mm

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This QA performed UT of weld designated as ESW A and ESW E in accordance with the approved supplemental procedure. 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 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.

Inspected By:	Clifford,William	Quality Assurance Inspector
----------------------	------------------	-----------------------------

Reviewed By:	Reyes,Danny	QA Reviewer
---------------------	-------------	-------------