

**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  
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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-029053  
**Date Inspected:** 26-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

<b>CWI Name:</b>	Steve Jensen	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Tower W-044 #25 D	

**Summary of Items Observed:**

On this date, Quality Assurance Inspector (QAI) Robert A. DeArmond was present at the San Francisco Oakland Bay Bridge job site at Yerba Buena Island to observe and perform Non-Destructive testing for the San Francisco Oakland Bay Bridge (SFOBB) project. This Quality Assurance Inspector (QAI) observed the following work performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below:

Ultrasonic Testing Tower ESW  
Weld No. W-044 #25  
Location D  
Face "A" (Y+8100~9850)

This QAI performed Ultrasonic Testing (UT), in tandem with ABF QC inspector Mr. Andrew Keech, on Complete Joint Penetration Electroslag welds. Weld joint is designated as 60~70 mm transition butt joint Weld No. W-044 #25 location D. During the QA/QC tandem Ultrasonic Testing, scanning was performed for longitudinal planar indications and transverse indications; in accordance with supplemental procedure SE-UT-D1.5-CT-108-ESW-R5. The UT inspection was performed using a 70 degree shear wave from face A; (21) transverse indications were discovered at locations noted below. The remaining length of weld tested with indications did not appear to have a rating that qualifies as rejectable or recordable according to AWS D1.5 2002 and supplemental procedure SE-UT-D1.5-CT-108-ESW-Revision: 5.

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# WELDING INSPECTION REPORT

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Transverse Recordable Indications discovered

Face A

Y+

7780, 7825, 8740, 8760, 8780, 8905, 8930, 8980, 8990, 9041, 9095, 9105, 9160, 9170, 9200, 9285, 9300, 9335, 9410, 9585, and 9600

(See Ultrasonic Testing Report for additional information)

**Summary of Conversations:**

As mentioned above between QA and QC concerning this project

**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.

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<b>Inspected By:</b>	DeArmond,Robert	Quality Assurance Inspector
<b>Reviewed By:</b>	Mertz,Robert	QA Reviewer

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