

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-029077**Date Inspected:** 26-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See 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:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford 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 QAI performed Ultrasonic Testing Shear Wave (UTSW), in tandem with ABF QC inspector Mr. Scott Kortum, on Tower Complete Joint Penetration Electroslag welds. The weld joint ESW N-045 "E" (90 Tee) was inspected at face "A" for longitudinal planar indications and transverse indications in accordance with supplemental procedure SE-UT-D1.5-CT-108-ESW-R5. A total of 14 indications were found, 12 of the transverse indications in the weld were equal to or greater than 29 dBs above the reference level, and 2 longitudinal planar indications were found equal to or greater than 19dBs above the reference level. The UT inspection was performed using a 69 degree shear wave wedge at Y location 0 to 1000mm. No rejectable indications were noted in the weld as per AWS D1.5 Table 6.4.

Non-Destructive Testing (NDT)

This QA performed Ultrasonic Testing on the following:

Weld ESW N-045 "E" (Face A):

- Y 0 to 1000mm. (Indication details below)

See Form TL-6027 for additional information.

The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

WELDING INSPECTION REPORT

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

ESW N-045 "E" (Fc A): Y 0 to 1000mm											
Mat'l Thickness: 60 mm (Tee Joint - Fc A)											2013.01.26
Location	Indication	Indication	Transducer	Sound	Depth	Leg	Indication	Reference	Attenuation	Indication	
Y	X	Length	Orientation	Angle	Path		Level	Level	Factor	Rating	
220	-20		T	69	84	30	1	75	49	5	21
240	-20		T	69	80	29	1	76	49	4	23
285	-20		T	69	114.5	41	1	76	49	7	20
420	-30	20	Planar	69	41.8	15	1	53	49	1	3
490	-30		T	69	90	32	1	77	49	5	23
575	-30		T	69	91	33	1	77	49	5	23
675	-40		T	69	72	26	1	73	49	4	20
710	-40		T	69	78.7	28	1	75	49	4	22
740	-25		T	69	106	38	1	73	49	6	18
820	-35		T	69	104	37	1	73	49	6	18
860	-20	30	Planar	69	73	26	1	66	49	4	13
875	-5		T	69	79	28	1	74	49	4	21
890	-15		T	69	104	38	1	77	49	6	22
965	-5		T	69	106	36	1	73	49	6	18

No rejectable indications noted as per AWS D1.5 Table 6.4.

Summary of Conversations:

Conversations this day as required for scope of work.

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: Belford,Fritz

Quality Assurance Inspector

Reviewed By: Mertz,Robert

QA Reviewer