

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-029091**Date Inspected:** 31-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**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 Q, Face B:**

This QA performed Ultrasonic Testing (UT) on approximately 300mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as "ESW Q" face B. Location (Y=8400~8700) of this weld was inspected using this testing method.

This QA observed no 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 for recordable planar/transverse indications at the time of concurrence.

Due to joint configuration and weld cap shape the transverse indications could not be evaluated for length or "X" location.

Indication #1: Y= 8675mm

Sizing – A=72db, B= 51db, C= 4db, D= 18db

Sound Path= 71mm, Depth= 24mm

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Indication #2: Y= 8660mm

Sizing – A=80db, B= 51db, C= 8db, D= 21db

Sound Path= 126mm, Depth= 43mm

Indication #3: Y= 8650mm

Sizing – A=80db, B= 51db, C= 8db, D= 21db

Sound Path= 122mm, Depth= 42mm

Indication #4: Y= 8610mm

Sizing – A=76db, B= 51db, C= 5db, D= 19db

Sound Path= 105mm, Depth= 36mm

Indication #5: Y= 8605mm

Sizing – A=75db, B= 51db, C= 7db, D= 17db

Sound Path= 119mm, Depth= 41mm

Indication #6: Y= 8570mm

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

Sound Path= 100mm, Depth= 34mm

Indication #7: Y= 8420mm

Sizing – A=80db, B= 51db, C= 4db, D= 25db

Sound Path= 78mm, Depth= 27mm

ESW A, Face B:

This QA performed Ultrasonic Testing (UT) on approximately 1850mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as “ESW A” face B. Location (Y=8000~9850) of this weld was inspected using this testing method.

This weld has been confirmed by QC Ultrasonic technicians in accordance with supplemental procedure SE-UT-D1.5-CT-108-ESW-R5.

This QA/QC observed one (1) recordable longitudinal indication at the time of testing.

This QA generated a TL-6027 UT report on this date.

Depth is recorded from face A.

Indication #1: Y= 6855mm

Sizing – A=69db, B= 51db, C= 10db, D= 8db

X= -10mm, L= 15mm

Sound Path= 156mm, Depth= 5mm

This QA performed UT of weld designated as ESW Q and ESW A in accordance with the approved supplemental procedure for confirmation and evaluation of planar type defects. 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

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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:	Mertz,Robert	QA Reviewer
