

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-029416
Date Inspected: 16-Apr-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:	Bernie Docena	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 Tower	

Summary of Items Observed:

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Quality Assurance Inspector (QA) Joe Adame was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island 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:

In Process Visual Inspection

RWR 201304-007

QA observed at random intervals, ABF/JV welder Chris Bruce #8981 performing carbon arc air gouging of ESW welds for defect removal on ESW weld designated as N. Location of excavation was noted as:

Face A

Y= 5210mm

L= 140mm

W= 40mm

D= 31mm

After excavation and grinding to bright metal ABF Quality Control (QC) Inspector Bernie Docena was observed performing MT testing of the excavation to ensure all discontinuities were removed prior to welding. Mr. Docena and the QA Inspector also performed a UT verification of HAZ areas located 300 mm above and below of the excavation to be reinspected after welding. See TL-6027 for additional information on items inspected on this date.

Ultrasonic Testing of ESW

WELDING INSPECTION REPORT

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ESW N- Face B, ESW Q-Face A:

This QA performed continued Ultrasonic Testing (UT) on approximately 1000mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate welds designated as "ESW N" face B. Location (Y=7840) & ESW Q Location (Y=9425) of this weld was inspected using this testing method. No recordable indications were observed at the time of testing. QA performed UT of welds designated as ESW N & ESW Q in accordance with the approved supplemental procedure for confirmation and evaluation of planar & transverse 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. Please see TL-6027 for information on items inspected on this date.

Summary of Conversations:

Only general conversations with ABF/JV QC NDT personnel relevant to testing and work 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:	Adame,Joe	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer
