DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-029429
Date Inspected: 20-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: 1530
Location: Job Site

CWI Name: As noted below

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ 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:
This QA observed the following welders working on the Tower at the following locations:

This QA Inspector reported to the 160m elevation of the Tower to randomly observe ABF welder Jose Torres #6235 and welding personnel use a combination of mechanical means and the application of localized heat to align each of the connection plates (lugs) that are attached to each of the Tower shafts of the Tower head for the attachment of the hand-ropes. This QA Inspector observed the welder heat lug #2 along the length of, and just above, the weld connection with QC Inspector William Sherwood monitoring the temperature to ensure the lug did not exceed 595°C (1100°F) in accordance with RWR-201304-10. Upon completion of heating, lugs #1 and #2 were spanned with a push beam and hydraulic jack to move lug #2 approximately ½" in accordance with RFI-003248R01. Upon achieving ½", the lug was allowed to cool to ambient temperature. This QA Inspector observed QC perform Magnetic Particle (MT) Inspection of the heat site and weld of the lug and noted that no indications were present.

This QA Inspector randomly observed ABF welder Jose Torres and welding personnel utilize a pulling come along on lugs #3 and #4 to move each plate inward approximately ½" in accordance with RFI-003248R01. Prior to the application of mechanical force, each plate was heated along the length of, and just above, the weld connection with QC Inspector William Sherwood monitoring the temperature to ensure the lugs did not exceed 595°C (1100°F) in accordance with RWR-201304-10. Upon achieving ½", the lug was allowed to cool to ambient temperature. This QA Inspector observed QC perform Magnetic Particle (MT) Inspection of the heat site and weld of the lug and noted that no indications were present.

WELDING INSPECTION REPORT

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Summary of Conversations:

This QA Inspector discussed with Caltrans Construction Engineer Loraine Woo that the 1/2" lug #2 was moved, appeared to be inadequate and may require further 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:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer