

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-029454**Date Inspected:** 20-Apr-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:** Tower**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:

Non-Destructive Testing (NDT)

This QA performed NDT on the following:

Seal Cover Plate Welds at 12E PP119 (-1500) as per ABF-RFI-003256R00:

- VT 100% (VT Accept).
- MPT 100% (MPT Accept).
- See report form TL-6028 for details.

Electroslag Weld ESW M, W042:

- Pitch Catch Shear Wave at Y 3960, 4130 & 4400. (See report below)

Weld ESW M, W042 (Face B), 60mm Thick, Transducer Angle 69 Degrees:

Y: 3960 X: -20, Sound Path: 55, Depth (Fc A):40.

PEUT: Ind.Lvl (A): 70, Ref.Lvl(B): 60, Att.Factor(C): 2, Ind.Rating (D): 8, Surface Distance: 51

PCUT: Ind.Lvl (A): 86, Ref.Lvl(B): 60, Att.Factor(C): 12, Ind.Rating (D): 15, Transducer Spacing: 212

Y: 4130 X: -15, Sound Path: 77, Depth (Fc A):33.

PEUT: Ind.Lvl (A): 78, Ref.Lvl(B): 58, Att.Factor(C): 4, Ind.Rating (D): 17, Surface Distance: 72

PCUT: Ind.Lvl (A):81, Ref.Lvl(B): 58, Att.Factor(C): 12, Ind.Rating (D): 12, Transducer Spacing: 189

Y: 4400 X: -10, Sound Path: 114, Depth (Fc A):22.

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PEUT: Ind.Lvl (A): 73, Ref.Lvl(B): 58, Att.Factor(C): 7, Ind.Rating (D): 9, Surface Distance: 106
PCUT: Ind.Lvl (A): 82, Ref.Lvl(B): 58, Att.Factor(C): 12, Ind.Rating (D): 13, Transducer Spacing: 120

Pitch Catch Ultrasonic Testing performed in tandem with QC Inspector Andrew Keech this day was for informational purposes only. Welds inspected are to be reinspected with an approved inspection procedure at a later date.

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

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

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
