

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-029457**Date Inspected:** 18-Apr-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:** 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

RWR201208-004

ESW G-Face A

This QA observed, at random intervals, ABF/JV welder Mike Jimenez (WID-4671) performing Shielded Metal Arc Welding (SMAW) with 4.0mm diameter E7018-MH4-R electrode and in accordance with ABF Welding Procedure Specification (WPS) ABF-WPS-D1.5-1000R-03. Prior to welding preheat was being maintained to over 300° degrees Fahrenheit using the Miller ProHeat 35 with heat induction blankets. Welding was performed on tower Electroslag Weld "ESW" designated as G- Face A, Original Y= 7840 mm. During welding, ABF Quality Control Inspector (QC) Andrew Keech was observed monitoring the welding parameters.

Ultrasonic Testing of ESW

ESW N- Face B:

This QA performed continued Ultrasonic Testing (UT) on approximately 900mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate welds designated as "ESW N" face B. Locations (Y=5210 & Y=2100) of these welds were inspected using this testing method.

QA observed one (1) rejectable indication at the time of testing @ Y=5190.

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QA observed no recordable indications at time of testing @ Y=2100.

QA performed UT of welds designated as ESW N 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. See TL-6027 for information on items inspected on this date.

In Process Visual Inspection

RWR 201206-44

ESW V-Face A

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 V. Location of excavation was noted as:

Face A

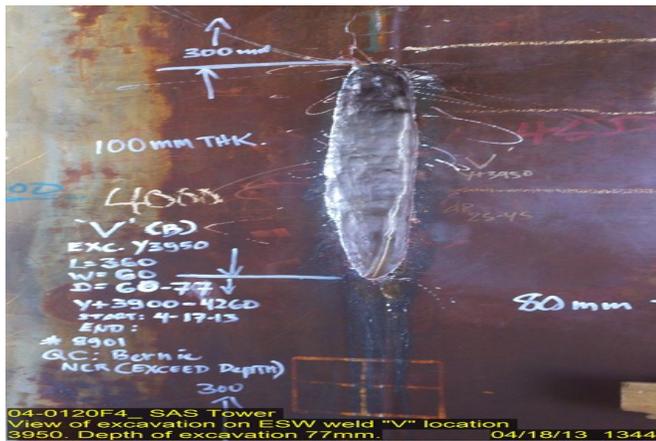
Y= (Original) 3550mm. Excavated 3900~4260.

L= 360mm

W= 60mm

D= 77mm*

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. The QA Inspector also performed MT inspection of the excavation and did not observe any weld defects. Repair area will be reinspected with UT/MT after welding and the required cooling time of 48 hrs as detailed in section 12.*Note- ABF QC Inspector Bernie Docena issued a Non-Conformance report for Welder #8981 exceeding the maximum depth of excavation (85% of weld thickness) for the 80mm to 100mm transition weld V as described in the request for welding repair. QA informed QA Lead Inspector Robert Mertz of this discrepancy. See TL-6028 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

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your project.

Inspected By:	Adame,Joe	Quality Assurance Inspector
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Reviewed By:	Mertz,Robert	QA Reviewer
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