

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-029470
Date Inspected: 23-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:

Caltrans 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 201304-005

ESW L-Face B

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

ESW S -042 "L" Face B

Y= (Original) 5740mm. Excavated 5700~5400.

L= 100mm

W= 40mm

D= 45mm

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 is to be inspected with UT/MT after weld repair and the required cooling time of 48 hrs as described in section 12 of AWS D1.5-02. See TL-6028 for information on items inspected on this date.

In Process Visual Inspection

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

RWR201208-009

ESW S-045 "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 a Miller ProHeat 35 unit with heat induction blankets. Welding was performed on tower Electroslag Weld "ESW" designated as G- Face A, Original Y=4360mm, Repair length 4300mm~4900mm. ABF Quality Control Inspector (QC) Bernie Docena was observed monitoring the welding parameters throughout the shift. The weld repair was completed at approx. 1300 hrs. The repair area will be inspected with UT/MT after the required cooling time of 48 hrs as described in section 12 AWS D1.5-02.

Pre-repair Verification

RWR-201208-015

ESW F Face B

QA observed at random intervals ABF/JV QC Inspector Bernie Docena performing Ultrasonic Testing (UT) verification of designated ESW weld repair locations prior to the start of performing air carbon arc gouging for defect removal. Locations of indications for repairs were noted as:

ESW E-045 "F" Face B

Y= 3920mm, +300mm above/below

D= 30mm

L=175mm

QA also performed a UT verification of proposed repair & HAZ areas located 300 mm below of repair areas to be reinspected after welding. See TL-6027 for additional 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
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Reviewed By:	Mertz,Robert	QA Reviewer
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