

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-029482
Date Inspected: 18-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:	Andrew Keech	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 W-042 #18 "M"	

Summary of Items Observed:

On this date, Quality Assurance Inspector (QAI) Robert A. DeArmond was present at the San Francisco Oakland Bay Bridge job site at Yerba Buena Island to observe and perform Non-Destructive testing for the San Francisco Oakland Bay Bridge (SFOBB) project. This Quality Assurance Inspector (QAI) observed the following work performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below:

This QAI performed ultrasonic testing in tandem with ABF-QC personnel; during a joint venture pulse echo ultrasonic testing (PEUT) and indirect pitch catch ultrasonic testing (PCUT) of Electroslag welds. The purpose of this additional non-destructive weld evaluation is to further evaluate previously documented planar indications, therefore PEUT and PCUT test methods were utilized. All test locations were selected by ABF personnel, it should be noted; no specific PEUT and /or PCUT rejection, acceptance, and calibration criteria was specified, therefore this testing is for informational purposes only.

The following locations were scanned utilizing the PEUT and PCUT scanning technique.

1. Location: M (Weld No.: W-042 # 18 Face B)
Joint: 60 mm 150-degree T-Joint, Y Location: 6570
(Actual Y location: 6550)

PEUT Indication Rating: +17db
Depth 20 mm Surface Distance: 109 mm
PCUT Indication Rating: +18db

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Spacing: 110 mm

2. Location: M (Weld No.: W-042 # 18 Face B)

Joint: 60 mm 150-degree T-Joint, Y Location: 6690

(Actual Y location: 6650)

PEUT Indication Rating: +16db

Depth 16 mm Surface Distance: 122 mm

PCUT Indication Rating: +21db

Spacing: 90 mm

3. Location: M (Weld No.: W-042 # 18 Face B)

Joint: 60 mm 150-degree T-Joint, Y Location: 7210

Transverse Indication

4. Location: M (Weld No.: W-042 # 18 Face B)

Joint: 60 mm 150-degree T-Joint, Y Location: 7460

(Actual Y location: 7550 through 7570)

PEUT Indication Rating: +15db

Depth 35 mm Surface Distance: 68 mm

PCUT Indication Rating: +11db

Spacing: 188 mm

5. Location: M (Weld No.: W-042 # 18 Face B)

Joint: 60 mm 150-degree T-Joint, Y Location: 7650

PEUT Indication Rating: +16db

Depth 37 mm Surface Distance: 64 mm

PCUT Indication Rating: +7db

Spacing: 200 mm

6. Location: M (Weld No.: W-042 # 18 Face B)

Joint: 60 mm 150-degree T-Joint, Y Location: 7670

Transverse Indication

7. Location: M (Weld No.: W-042 # 18 Face B)

Joint: 60 mm 150-degree T-Joint, Y Location: 7950

(Actual Y location: 8030)

PEUT Indication Rating: +12db

Depth 22 mm Surface Distance: 104 mm

PCUT Indication Rating: +9db

Spacing: 120 mm

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Summary of Conversations:

As mentioned above between QA and QC concerning this project

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:	DeArmond,Robert	Quality Assurance Inspector
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Reviewed By:	Mertz,Robert	QA Reviewer
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