

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-029487**Date Inspected:** 30-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:** Andrew Keech, 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-201304-014

ESW N-041, "N"-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 and gas torch to aid on the exterior. Welding was performed on tower Electroslag Weld "ESW" designated as "N"- Face A, Original Y=5775mm, Repair length 5600mm~5975mm. ABF Quality Control Inspector (QC) Bernie Docena was observed monitoring the welding parameters throughout the shift. 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.

Ultrasonic Testing of Tower Electroslag Welds (ESW)

RWR-201304-004

ESW E-045, Location "F"- Face A, B:

QA performed Ultrasonic Testing (UT) on approximately 750mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as ESW "F" face A, B. Location -Y(Original)=8580mm &

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

8240mm~8980mm of this weld was inspected using this testing method.

QA observed two (2) recordable planar indications at the time of testing.

RWR-201304-018

ESW E-044, Location "B"- Face A:

QA performed UT on approximately 490mm of Tower Electroslag CJP shear plate weld designated as ESW "B" face A. Location Y=3850mm & 3550mm~4040mm of this weld was inspected using this testing method.

No recordable indications were observed at the time of testing.

RWR-201208-015

ESW E-045, Location "F"- Face B:

QA performed UT on approximately 660mm of Tower Electroslag CJP shear plate weld designated as ESW "F" face B. Location Y=3920mm & 3620mm~4280mm of this weld was inspected using this testing method.

QA observed three (3) recordable planar indications at the time of testing.

QA observed four (4) recordable transverse indications at the time of testing.

QA performed UT of the above mentioned ESW locations in accordance with the approved supplemental procedure for confirmation and evaluation of planar type 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. Please see TL-6027 for complete listing of QA recorded indications.

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
Reviewed By:	Mertz,Robert	QA Reviewer
