

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
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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-029490  
**Date Inspected:** 06-May-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

|                                    |              |                                  |           |        |
|------------------------------------|--------------|----------------------------------|-----------|--------|
| <b>CWI Name:</b>                   | Andrew Keech | <b>CWI Present:</b>              | Yes       | No     |
| <b>Inspected CWI report:</b>       | Yes No N/A   | <b>Rod Oven in Use:</b>          | Yes       | No N/A |
| <b>Electrode to specification:</b> | Yes No N/A   | <b>Weld Procedures Followed:</b> | Yes       | No N/A |
| <b>Qualified Welders:</b>          | Yes No N/A   | <b>Verified Joint Fit-up:</b>    | Yes       | No N/A |
| <b>Approved Drawings:</b>          | Yes No N/A   | <b>Approved WPS:</b>             | Yes       | No N/A |
|                                    |              | <b>Delayed / Cancelled:</b>      | Yes       | No N/A |
| <b>Bridge No:</b>                  | 34-0006      | <b>Component:</b>                | 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**

RWR201304-013

Electroslag Weld (ESW) S-041, "N"-Face A

The QA Inspector observed ABF/JV welder Mike Jimenez (WID-4671) performing weld repairs of the R2 repair excavation on Electroslag Weld (ESW) "N", at face A, original Y- location 5190mm. Locations are listed as detailed in Request for Weld Repair (RWR) 201304-013. The welder was observed preheating the weld to over 300° Fahrenheit prior to welding using the Miller ProHeat 35 with dual heat induction blankets. The welder utilized ABF Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3 for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Andrew Keech throughout the day and appeared to be in compliance with the WPS noted above. Welding of this repair is approx. 75% complete at the end of this shift.

**Ultrasonic Testing of Tower Electroslag Welds (ESW)**

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

QC Inspector Andrew Keech and the QA Inspector commenced Ultrasonic Testing (UT) of on Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as ESW "F" Face B. The locations designated for the UT verification was: Y-6670mm~7900mm. Due to quantity of indications to verify and large vertical area to

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# WELDING INSPECTION REPORT

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scan, QC/QA did not complete UT inspection on this date and will continue on 5-07-13. ABF QC will complete final tandem report upon completion of testing of ESW "F" Face B.

**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.

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| <b>Inspected By:</b> | Adame,Joe | Quality Assurance Inspector |
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| <b>Reviewed By:</b> | Mertz,Robert | QA Reviewer |
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