

**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-029507**Date Inspected:** 07-May-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**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**

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 was observed checking the temperature with a Tempilstick temperature indicator. 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. The welding repair was completed on this 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)**

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

QC Inspector Andrew Keech and the QA Inspector performed Ultrasonic Testing (UT) on approximately 1230mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as ESW "F" face B. Location

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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-Y 6670mm~7900mm of this weld was inspected using this testing method.

QA observed nine(9) recordable planar indications at the time of testing.

QA observed ten (10) recordable transverse indications at the time of testing.

QA performed UT of ESW "F" Face B location 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.

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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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