

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-029552**Date Inspected:** 10-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:** As noted below.**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**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California 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

RWR201304-001

This QA observed, at random intervals, ABF/JV welder Terry McCormick #8489 performing Shielded Metal Arc Welding (SMAW) with 4.0mm diameter E7018-MH4-R electrode and implementing Welding Procedure Specification (WPS) ABF-WPS-D15-1000R-03. Welding was performed on tower Electroslag Weld "ESW" designated as T.

Face A

Y= 3570mm

L= 430mm

W= 75mm

D= 63mm

During welding, ABF Quality Control (QC) Andrew Keech was noted monitoring the welding parameters.

Ultrasonic Testing of ESW

ESW C, Face A/B:

This QA performed continued Ultrasonic Testing (UT) on Tower Electroslag Complete Joint Penetration (CJP)

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shear plate weld designated as “ESW C” face A/B.

Location (Y=5400~5700) of this weld was inspected using this testing method.

Face A

This QA observed one (1) recordable longitudinal indication at the time of testing.

This QA observed one (1) recordable transverse indication at the time of testing.

Face B

This QA observed no recordable longitudinal indication at the time of testing.

This QA observed no recordable transverse indication at the time of testing.

Location (Y=4700~4950) of this weld was inspected using this testing method.

Face A

This QA observed no recordable longitudinal indication at the time of testing.

This QA observed no recordable transverse indication at the time of testing.

Face B

This QA observed no recordable longitudinal indication at the time of testing.

This QA observed no recordable transverse indication at the time of testing.

ESW B, Face A/B:

This QA performed continued Ultrasonic Testing (UT) on Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as “ESW B” face A/B.

Location (Y=3800~4200) of this weld was inspected using this testing method.

Face A

This QA observed no recordable longitudinal indication at the time of testing.

This QA observed no recordable transverse indication at the time of testing.

Face B

This QA observed no recordable longitudinal indication at the time of testing.

This QA observed no recordable transverse indication at the time of testing.

Location (Y=6270~6600) of this weld was inspected using this testing method.

Face A

This QA observed no recordable longitudinal indication at the time of testing.

This QA observed no recordable transverse indication at the time of testing.

Face B

This QA observed no recordable longitudinal indication at the time of testing.

This QA observed no recordable transverse indication at the time of testing.

Location (Y=7720~8250) of this weld was inspected using this testing method.

Face A

This QA observed one (1) recordable longitudinal indication at the time of testing.

This QA observed no recordable transverse indication at the time of testing.

Face B

This QA observed no recordable longitudinal indication at the time of testing.

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This QA observed no recordable transverse indication at the time of testing.

Location (Y=8300~8500) of this weld was inspected using this testing method.

Face A

This QA observed one (1) recordable longitudinal indication at the time of testing.

This QA observed no recordable transverse indication at the time of testing.

Face B

This QA observed no recordable longitudinal indication at the time of testing.

This QA observed no recordable transverse indication at the time of testing.

This QA performed UT of welds 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.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversation was relevant to testing 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:	Clifford,William	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer
