

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-029570**Date Inspected:** 21-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:	Jesse Cayabyab, 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:

The QA Inspector was present to perform Ultrasonic Testing (UT) inspection verification on Electroslag (ESW) welds on the interior of the Tower. The purpose of the UT inspection was for the detection of planar indications utilizing both the "pulse echo" (PE) technique and the "pitch and catch" (PC) technique for further discontinuity evaluation on ESW welds where previous discontinuities were detected by the single pulse echo search unit. The data collected from utilizing the P/C technique is for information only and the UT inspection was performed as a joint inspection with ABF/JV Quality Control (QC) Smith Emery NDT personnel. The summary of the joint Ultrasonic inspection performed on this date was as follows:

Tower Electroslag Weld Identification: W-042

Electroslag Weld "M" – Face A side only of weld.

Type of Joint: 150° T, 60 mm thick weld.

From Y Location: (4400) mm. Results (1) planar Indication with planar height characteristics – "A" side PE Decibel rating (-1) / PC Decibel rating-None (spacing to close to measure)

From Y Location: (4520) mm. Results (1) planar Indication with planar height characteristics – "A" side PE Decibel rating (+17) / PC Decibel rating (+19).

QA/QC also verified locations at Y-4680mm, 4840mm, 5240mm, 5560mm, 5670mm, and 5700mm and did not observe any recordable planar indications at this face. Tandem report for work performed on this date will be

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completed by QC Inspector Jesse Cayabyab and signed by both QA/QC parties to be presented to ABF & CT METS for further review.

In Process Visual Inspection

RWR201305-005

Electroslag Weld (ESW) W-043, "V"-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) "V", at face A, original Y- location 3960mm. Locations are listed as detailed in Request for Weld Repair (RWR) 201305-005. 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 Bernie Docena 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.

Summary of Conversations:

Only general conversations with ABF/JV QC NDT personnel relevant to work and 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:	Adame,Joe	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer
