

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-029585**Date Inspected:** 22-May-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**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:

Ultrasonic Testing of Tower Electroslag Welds (ESW)

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

RWR-201208-015

ABF Quality Control Inspector (QC) Bernie Docena and the QA Inspector commenced Ultrasonic Testing (UT) on Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as ESW "F" Face A. The locations designated for the UT verification was: Y-3630mm~4230mm. Due to access issues on the opposite face QC/QA did not complete UT inspection on this date and will continue on 5-23-13. ABF QC will complete final tandem UT report upon completion of testing of ESW "F" Face B and present to ABF & Caltrans QA for further review.

Ultrasonic Testing of Tower Electroslag Welds (ESW)

ESW S-043, Location "T"- Face A:

RWR-201305-008

The QA Inspector observed ABF Quality Control Inspector (QC) Jesse Cayabyab performing Ultrasonic Testing (UT) on Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as ESW "T" Face A. ABF have directed QC to verify and document all transverse and planar indications in the ring beam location of this weld for possible future repairs. The Y locations designated for the UT verification was:

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Y-6000mm~7250mm. The QA Inspector also performed a UT verification of the proposed repair locations.

QA/QC observed (1) one recordable planar indication.

QA/QC observed (7) seven recordable transverse indications.

UT of weld ESW "T" was 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. UT verification of Face B will be performed at a later date. See TL-6027 for information on items inspected on this date.

Ultrasonic Testing of Tower Electroslag Welds (ESW)

ESW W-043, Location "V"- Face A:

RWR-201305-009

The QA Inspector observed ABF Quality Control Inspector (QC) Jesse Cayabyab performing Ultrasonic Testing (UT) on Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as ESW "V" Face A. ABF have directed QC to verify and document all transverse and planar indications in the ring beam location of this weld for possible future repairs. The Y locations designated for the UT verification was:

Y-6000mm~7250mm. The QA Inspector also performed a UT verification of the proposed repair locations.

QA/QC observed (3) three recordable transverse indications.

UT of weld ESW "V" was 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. UT verification of Face B will be performed at a later date. See TL-6027 for information on items inspected on this date.

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
