

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-029602**Date Inspected:** 23-May-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**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:

In Process Visual Inspection

RWR 201305-004

ESW S-042,"L"-Face A:

QA observed at random intervals, ABF/JV welder Chris Bruce (WID-8901) performing carbon arc air gouging of ESW welds for defect removal on ESW weld designated as "L". Location of excavation of the R2 repair was noted as:

Y= (Original) 5750mm. Excavated 5710mm~5890mm.

L= 180mm

W= 50mm

TD=30mm

MD=32mm

BD=27mm

The QA Inspector and ABF Quality Control Inspector (QC) Bernie Docena were informed by WID-8901 that he did not observe any indications during excavation. After grinding to bright metal the QC Inspector performed MT testing of the excavation to ensure all discontinuities were removed prior to welding. The QA Inspector also performed MT inspection of the excavation and did not observe any weld defects. Welding of this repair is pending approval of the QC MT excavation report. The repair area will be reinspected with UT/MT after welding

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and cooling time of 48 hrs. Please see TL-6028 for additional details on items inspected.

Ultrasonic Testing of Tower Electroslag Welds (ESW)

RWR-201305-003

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

QA performed Ultrasonic Testing (UT) on approximately 956mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as "ESW "F" face A,B. Location (Original Y=3930mm,Repair Length 3875mm to 4155mm)of this repair weld was inspected using this testing method.

QA/QC observed two(2) recordable planar type indications.

QA/QC observed four (4) recordable transverse type indications.

The findings were previously verified by ABF Quality Control Inspector Bernie Docena on this date. QA performed UT of weld designated as ESW "F" 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 additional details on items inspected.

Ultrasonic Testing of Tower Electroslag Welds (ESW)

RWR-201305-008

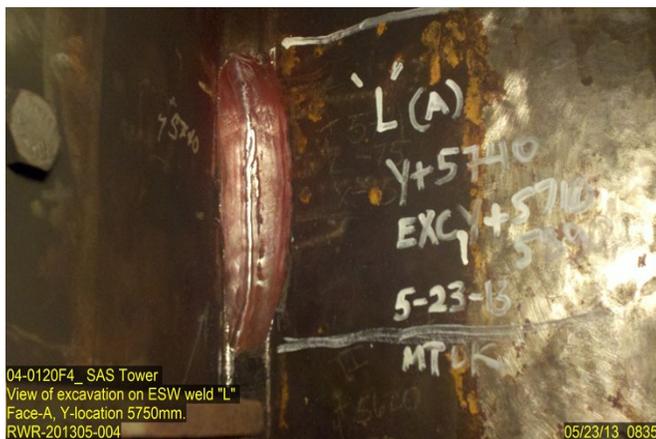
ESW S-043, Location "T"- Face B:

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 B. 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-4800mm~7280mm. The QA Inspector also performed a UT verification of the proposed repair locations.

Please see TL-6027 for recordable transverse and planar type indications observed on this date .

"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.



Summary of Conversations:

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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
