

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-029655**Date Inspected:** 29-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		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	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-043, Location "Q"- Face B:

RWR-201304-011, RWR-201304-012

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 "Q" 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-5000mm~7000mm. The QA Inspector also performed a UT verification of the proposed repair locations.

QA/QC observed (5) five recordable planar indications.

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

UT of weld ESW "Q" 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 to be presented to ABF & CT METS for further review. QA/QC still need to verify Face A on this weld once suitable access is provided on the exterior of the Tower. See TL-6027 for information on items inspected on this date.

Tower Electroslag Weld Identification: ESW N-044, Location "A", ESW N-042, Location "J":

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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:

Electroslag Weld “A” – Face A, B

Type of Joint: 60-70 Trans.

From Y Location: (6855) mm. Results (1) planar Indication with planar height characteristics – “B” side

QA-PE Decibel rating (+1) / PC Decibel rating (N/A) spacing to close.

QC-PE Decibel rating (+3) / PC Decibel rating (N/A) spacing to close.

Indication not recordable on A side. PE db rating not rejectable due to length (20mm.)

Electroslag Weld “J” – Face A,B

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

From Y Location: (64300) mm. Results (1) planar Indication with planar height characteristics – “B” side PE

Decibel rating QA-PE Decibel rating (+7) / PC Decibel rating (+13).

QC-PE Decibel rating (+11) / PC Decibel rating (+20)

Indication not recordable on A side.

Tandem report for work performed on this date will be completed by QC Inspector Jesse Cayabyab and signed by both QA/QC parties to be presented to ABF & CT METS for further review.

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
