

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-029659
Date Inspected: 07-Jun-2013

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Job Site

CWI Name:	See 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 ESW Welds		

Summary of Items Observed:

Quality Assurance Inspector (QA) Fritz Belford 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:

Non-Destructive Testing (NDT)

This QA performed joint UTSW Pitch/Catch with QC Inspector Jesse Cayabyab on the following:
ESW J (Face B) 60mm Thick, 70 Degree Angle (Results below):

Y 1470, X: -5

Sound Path: 85, Depth (Fc A): 31, Length: 60,

- PEUT: Ind.Lvl (A): 61, Ref.Lvl(B): 50, Att.Factor(C): 4, Ind.Rating (D): 7 Surface Distance: 80

- PCUT: Ind.Lvl (A): 60, Ref.Lvl(B): 50, Att.Factor(C): 12, Ind.Rating (D): -2 Transducer Spacing: 185

Y 1530, X: -10

Sound Path: 92, Depth (Fc A): 29, Length: 100,

- PEUT: Ind.Lvl (A): 69, Ref.Lvl(B): 50, Att.Factor(C): 5, Ind.Rating (D): 14, Surface Distance: 87,

- PCUT: Ind.Lvl (A): 52, Ref.Lvl(B): 50, Att.Factor(C): 12, Ind.Rating (D): -10, Transducer Spacing: 170,

Y 1530, X: -20

Sound Path: 47, Depth (Fc A): 44, Length: 100,

- PEUT: Ind.Lvl (A): 62, Ref.Lvl(B): 50, Att.Factor(C): 1, Ind.Rating (D): 11, Surface Distance: 44,

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- PCUT: Ind.Lvl (A): 54, Ref.Lvl(B): 50, Att.Factor(C): 12, Ind.Rating (D): -8, Transducer Spacing: 207,

Y 1645, X: -5

Sound Path: 67, Depth (Fc A): 37, Length: 25,

- PEUT: Ind.Lvl (A): 64, Ref.Lvl(B): 50, Att.Factor(C): 3, Ind.Rating (D): 11, Surface Distance: 63,

- PCUT: Ind.Lvl (A): 59 Ref.Lvl(B): 50, Att.Factor(C): 12, Ind.Rating (D): -3, Transducer Spacing: 200,

Y 2410, X: -10

Sound Path: 125, Depth (Fc A): 17, Length: 70,

- PEUT: Ind.Lvl (A): 65, Ref.Lvl(B): 50, Att.Factor(C): 7, Ind.Rating (D): 8, Surface Distance: 119,

- PCUT: Ind.Lvl (A): 80, Ref.Lvl(B): 50, Att.Factor(C): 12, Ind.Rating (D): 18, Transducer Spacing: 104,

Y 3460, X: -5

Sound Path: 83 Depth (Fc A): 32, Length: 25

- PEUT: Ind.Lvl (A): 58, Ref.Lvl(B): 50, Att.Factor(C): 4, Ind.Rating (D): 4 Surface Distance: 78

- PCUT: Ind.Lvl (A): 68, Ref.Lvl(B): 50, Att.Factor(C): 12, Ind.Rating (D): 6 Transducer Spacing: 175

Y 3550, X: -5

Sound Path: 92 Depth (Fc A): 29, Length: 70

- PEUT: Ind.Lvl (A): 66, Ref.Lvl(B): 50, Att.Factor(C): 5, Ind.Rating (D): 11 Surface Distance: 87

- PCUT: Ind.Lvl (A): 68, Ref.Lvl(B): 50, Att.Factor(C): 12, Ind.Rating (D): 6 Transducer Spacing: 170

Y 4220 X: -5

Sound Path: 115 Depth (Fc A): 21, Length: 20

- PEUT: Ind.Lvl (A): 68, Ref.Lvl(B): 50, Att.Factor(C): 7, Ind.Rating (D): 11, Surface Distance: 109,

- PCUT: Ind.Lvl (A): 83, Ref.Lvl(B): 50, Att.Factor(C): 11, Ind.Rating (D): 22 Transducer Spacing: 120

Y 5000 : Indication is non recordable at side B.

Y 5210 : Indication is non recordable at side B.

Y 5780, X: -15

Sound Path: 115, Depth (Fc A): 13, Length: 20

- PEUT: Ind.Lvl (A): 68, Ref.Lvl(B): 50, Att.Factor(C): 8, Ind.Rating (D): 10, Surface Distance: 87,

- PCUT: Spacing for receiver too close to evaluate.

The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

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

Summary of Conversations:

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Conversations this day as required for scope of work.

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:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer
