DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-029660
Date Inspected: 03-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: 1530
Location: Job Site

CWI Name:	As noted 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

Summary of Items Observed:

Quality Assurance Inspector (QA) William Clifford 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:

In Process Visual Inspection
RWR-201305-001

This QA observed, at random intervals, ABF/JV welder Donald Plumb #0891 performing Shielded Metal Arc Welding (SMAW) with 4.0mm diameter E7018-MH4-R electrode and implementing Welding Procedure Specification (WPS) ABF-WPS-D15-1000R-03. Welding was performed on tower Electroslag Weld "ESW" designated as N.
Face A
Y= 6400mm
L= 390mm
W= 60mm
D= 42mm

During welding, ABF Quality Control (QC) Bernard Docena was noted monitoring the welding parameters.

RWR-201308-008

This QA observed, at random intervals, ABF/JV welder Mike Jiminez #4671 performing Shielded Metal Arc Welding (SMAW) with 4.0mm diameter E7018-MH4-R electrode and implementing Welding Procedure

WELDING INSPECTION REPORT

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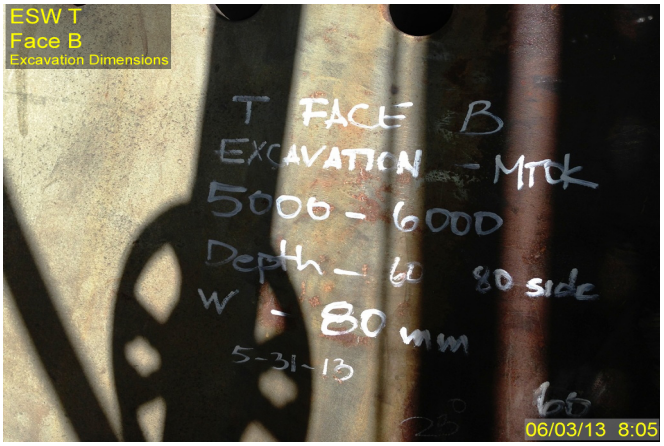
Specification (WPS) ABF-WPS-D15-1000R-03. Welding was performed on tower Electroslag Weld "ESW" designated as T.
Face B
Y= 5000~6000mm
L= 1000mm
W= 80mm
D= 60mm

During welding, ABF Quality Control (QC) Bernard Docena was noted monitoring the welding parameters.

Magnetic Particle Testing

This QA Inspector performed Magnetic Particle Testing (MT) on base plate to diaphragm 6mm fillet welds designated as 13M elevator platform stairs. This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed 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:

Conversation was relevant to 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:	Clifford,William	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer