

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-029740**Date Inspected:** 20-Jun-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:** 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 Electroslag 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 Andrew Keech on the following:

ESW T, Face A, 80/100mm Butt Joint, 70 Degree Angle (Details below):

Y 6040: Non recordable indication.

Y 6100, / X 20.

Sound Path: 10, Depth (Fc A): 68, Length: 45.

PEUT: Ind. (A): 59, Ref. (B): 44, Att. (C): 15, Rating (D): 0, SD: 188.

PCUT: Ind. (A): 72 Ref. (B): 44, Att. (C): 13, Rating (D): 15, Spc: 75.

Y 6600, / X 10.

Sound Path: 90, Depth (Fc A): 31, Length: 25.

PEUT: Ind. (A): 58, Ref. (B): 44, Att. (C): 5, Rating (D): 9, SD: 84.

PCUT: Ind. (A): 72, Ref. (B): 44, Att. (C): 16, Rating (D): 12, Spc: 260.

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ESW G, Face B, 80/100mm T-Joint, 70 Degree Angle (Details below):

Y 6040 Non recordable indication.

Y 6100 Non recordable indication.

Y 6600 Non recordable indication.

UTSW Inspection noted above was performed with collaboration of QC Inspector Andrew Keech utilizing one (1) scope. Scope used was the QC Inspector's Sonatest 1001264 calibrated on 2013/06/15.

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:

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
