

**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-029754  
**Date Inspected:** 21-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

<b>CWI Name:</b>	As noted below.	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	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-210305-001

This QA observed, at random intervals, ABF/JV welder Mike Jiminez #4671 performing carbon arc and mechanical grinding to perform excavation of an electrosag weld for repair. Excavation was performed on tower Electrosag Weld "ESW" designated as T.

Excavation is in process.

Length at this time is recorded as (5850mm~6250mm)

During welding, ABF Quality Control (QC) Bernard Docena was noted monitoring this excavation.

RWR-201308-008

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 Electrosag Weld "ESW" designated as R.

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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Face B

Y= 5400~5800mm

L= 400mm

W= 60mm

D= 37mm

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

## Ultrasonic Testing of ESW

ESW S, Face A/B:

This QA performed Ultrasonic Testing (UT) on approximately 1835mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as "ESW S" face B. Location (Y=5250~7085) of this weld was inspected using this testing method.

This weld was previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.4. and supplemental procedure SE-UT-D1.5-CT-108-ESW-R5.

This QA observed no recordable indications at the time of testing.

This QA observed no rejectable indications at the time of testing.

This QA generated a TL-6027 UT 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 work 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.

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<b>Inspected By:</b>	Clifford,William	Quality Assurance Inspector
<b>Reviewed By:</b>	Mertz,Robert	QA Reviewer

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