

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-029783**Date Inspected:** 19-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:	As noted below		
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:**

Quality Assurance Inspector (QA) Douglas Frey 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 and Magnetic Particle Testing.

RWR-201305-012

This QA observed, at random intervals, ABF/JV welder Mike Jimenez #4671 performing carbon arc and mechanical grinding to perform excavations of electroslag weld for repair. Excavation was performed on tower Electroslag Weld "ESW" designated as S. Dimensions of the excavations were recorded as: Y+6720mm D21/W25/L125 and Y+6240mm D15/W25/L120. Upon completion of excavation operations, QC performed Magnetic Particle (MPT) Inspection of the sites and noted no relevant indications.

This QA Inspector performed 100% Magnetic Particle (MPT) testing along the length of, and the edges of the weld on the excavation sites listed above. This QA Inspector performed MT testing utilizing the yoke method in conformance with ASTM E 709 and the standard of acceptance with D1.5 section 6.26.2.1. This QA Inspector noted that no rejectable indications were found at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work at this location appeared to be in general conformance with the contract specifications.

WELDING INSPECTION REPORT

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RWR-210305-001

This QA observed, at random intervals, ABF/JV welder Donald Plumb #0891 performing carbon arc and mechanical grinding to perform excavation of an electroslag weld for repair. Excavation was performed on tower Electroslag Weld "ESW" designated as N. Excavation is in process.

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

RWR-201308-008

This QA Inspector performed an Ultrasonic (UT) inspection on Electroslag weld T face A from Y+5700mm to Y+6300mm. These welds were previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.4. The testing was performed in accordance with AWS.D1.5-2002 Section 6, table 6.4. This QA Inspector noted that no rejectable indications were found at the time of testing. This QA Inspector generated a TL-6028 UT report on this date. The completed work at this location appeared to be in general conformance with the contract specifications.

RWR-201305-002

This QA Inspector performed an Ultrasonic (UT) inspection on Electroslag weld P face A from Y+5900mm to Y+6780mm. These welds were previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.4. The testing was performed in accordance with AWS.D1.5-2002 Section 6, table 6.4. This QA Inspector noted that no rejectable indications were found at the time of testing. This QA Inspector generated a TL-6027 UT report on this date. The completed work at this location appeared to be in general conformance 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 on this date were relevant to work performed.

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:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer
