

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-029841
Date Inspected: 20-Jul-2013

Project Name: SAS Superstructure **OSM Arrival Time:** 700
Prime Contractor: American Bridge/Fluor Enterprises, a JV **OSM Departure Time:** 1530
Contractor: American Bridge/Fluor Enterprises, a JV **Location:** Job Site

CWI Name:	Jesus Cayabyab, Bernie Docena			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:	SAS Tower		

Summary of Items Observed:

Caltrans Quality Assurance Inspector (QA) Joe Adame arrived at the American Bridge/Fluor (ABF) job site between the times noted above in order to monitor ABF Quality Control functions and the in work being performed by ABF personnel. The following items were observed:

Tower Electroslag Welds (ESW):

RWR-201307-003

ESW S-041, Location "S"- Face A, B:

The QA Inspector performed Ultrasonic Testing (UT) on approximately 750mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld repair designated as ESW "S" Face A, B. QC Inspector Jesse Cayabyab performed UT on the repair location and 300mm above and below the repair (Listed below).

Location -Excavation Y= (Original Y 8620mm) 8580mm ~8730mm

8280mm~8580mm

8730mm~9030mm

No rejectable or recordable indications were observed.

QA performed UT of the above mentioned ESW location in accordance with the ABF approved supplemental procedure for confirmation and evaluation of planar type defects. Tandem report for work performed on this date will be completed by QC technician and signed by both QA/QC parties. Items listed on tandem report reflect indications agreed upon by QA/QC. Please see TL-6027 for items inspected on this date.

Tower Electroslag Welds (ESW):

The QA Inspector was present to perform Ultrasonic Testing (UT) verification on Electroslag (ESW) welds on the

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interior of the Tower. The purpose of the UT inspection was for the detection of planar indications utilizing both the “pulse echo” (PE) technique and the “pitch and catch” (PC) technique for further discontinuity evaluation on ESW welds. The QA Inspector performed joint UTSW Pitch/Catch with QC Inspector Jesse Cayabyab on the items listed below.

ESW E-043 Location “Q”-80mm/100mm Thick, 70° Angle:

Y: 7700mm, X: N/A Face A

-PEUT: Ind. Lvl (A): Non Recordable Indication.

-PCUT: Ind. Lvl (A): Non Recordable Indication.

ESW pitch & catch UT was performed per ABF Sup. Procedure 3 UT of ESW Groove Welds Pitch- Catch. The tandem UT report for work performed on this date will be completed by QC Inspector Jesse Cayabyab and signed by both QA/QC parties to be presented to ABF & CT METS for further review.

In Process Visual Inspection

RWR201305-009

ESW W-041, Location “V”-Face B

The QA Inspector observed, at random intervals, ABF/JV welder Mike Jimenez (WID-4671) performing weld repairs of the repair excavation on Electroslag Weld (ESW) “V”, at face B locations noted as:

Y= 5250~5710mm

L= 460mm

W= 70mm

D= 73mm.

The welder was observed preheating the weld to over 300° Fahrenheit prior to welding using the Miller ProHeat 35 with heat induction blankets. The welder was using 4.0mm diameter electrode (E7018-MH4-R) per ABF Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3 for Shield Metal Arc Welding (SMAW). The welding parameters were verified by QC Inspector Bernie Docena throughout the day and appeared to be in compliance with the WPS noted above.



Summary of Conversations:

Only general conversations with ABF/JV QC NDT personnel relevant to work and testing performed during this shift.

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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:	Adame,Joe	Quality Assurance Inspector
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Reviewed By:	Mertz,Robert	QA Reviewer
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