

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-029842
Date Inspected: 18-Jul-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:	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:

In Process Visual Inspection

RWR201307-003

ESW "S"-Face A

The QA Inspector observed, at random intervals, ABF/JV welder Kit Lai (WID-2953) performing weld repairs of the repair excavation on Electroslag Weld (ESW) "S", at face A original Y location 8670mm. Locations are listed as detailed in Request for Weld Repair (RWR) 201307-003 from pitch catch Ultrasonic Testing indications designated for repair. Prior to the repair work, ABF Quality Control (QC) Inspector Bernie Docena performed a preliminary MT verification of in-process weld passes to verify the weld was clear of any discontinuities. 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 utilized 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. See TL-6028 for information on items inspected.

Exploratory excavation

ESW E-043,"Q"-Face A:

The QA Inspector was present to observe ABF welder Don Plumb (WID-0891) performing exploratory excavation

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of ESW "Q" Face A, to verify indications observed during Ultrasonic Testing with pulse/echo & pitch/catch. QC Inspector Jesse Cayayab stated that Mr. Plumb will excavate every 5mm deep and allow QC/QA to inspect the excavation. After grinding to bright metal the QC Inspector performed MT testing of the excavation to inspect for the indications at each hold point. The QA Inspector also performed MT inspection throughout the process and the final excavation. Details of the repair excavation are as follows:

ESW "Q", Face A

Indication originally reported at Y's= 6460mm, 6470mm, 6560mm, X=varies

WeId excavated at 22mm-No indication observed.

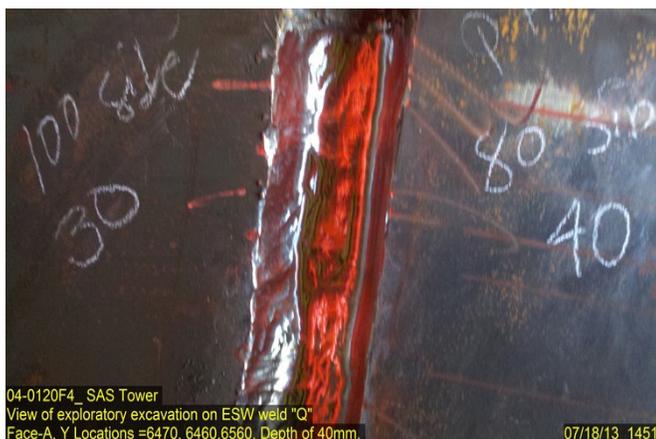
WeId excavated at 32mm-No indication observed.

WeId excavated at 35mm-No indication observed.

WeId excavated at 40mm-No indication observed

Excavation still in progress at the end of this shift. Length- 6430mm~6650mm,

The QC Inspector stated that Mr. Plumb will continue with excavation on 7-19-13 and excavate beyond 50mm where they expect to see longitudinal and transverse indications. ABF QC Representative Chris Chew stated that ABF do not have approval to weld the ESW PC excavation locations at this time and will only be excavating to verify the indications and remove them. ABF will also submit ABF QC Inspector Jesse Cayayab stated that he would complete ABF daily inspection report and magnetic particle testing report to detail the findings. See TL-6028 for additional details on items inspected.



Summary of Conversations:

Only general conversations with ABF/JV QC NDT personnel relevant to work and 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: Adame,Joe

Quality Assurance Inspector

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Reviewed By: Mertz,Robert

QA Reviewer