

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-029848
Date Inspected: 22-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

ESW E-045, Location "F"-Face B

The QA Inspector observed, at random intervals, ABF/JV welder Kit Lai (WID-2953) performing weld repairs of the investigative repair excavation on Electroslag Weld (ESW) "F", at face B locations noted as:

Y= 8490~8870mm

L= 380mm

W= 60mm

D= 45mm

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. ABF Field Engineer Eric Blue stated that RWR# for the investigative excavations are pending and that CT METS are aware of the in process work.

In Process Visual Inspection

RWR201305-009

WELDING INSPECTION REPORT

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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.

Electroslag Weld Repairs at Ring Beam Layout Locations

RWR201306-002

ESW E-043 Location "Q"-Face A

The QA Inspector observed at random intervals, ABF/JV welder Don Plumb (WID-0891) performing carbon arc air gouging of ESW "Q" Face A, to verify indications observed during Ultrasonic Testing. ABF Quality Control (QC) Inspector Jesse Cayabyab was observed monitoring the work and informed the QA Inspector that all indications in these Y locations will be removed and repaired for ring beam installation. Locations of the repair excavation and indications observed are as follows:

ESW Q -Face A

Y= (Original Excavation 6400~6560), Extended excavation from 6560mm~6700mm.

43mm depth of excavation –No indication observed.

52mm depth of excavation –No indication observed.

54mm depth of excavation –No indication observed.

60mm depth of excavation –8mm long indication @ Y=-6620, X= -20.

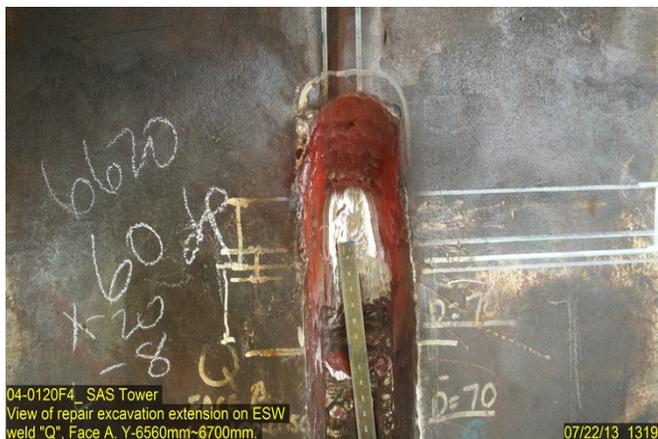
62mm depth of excavation- Indication removed.

L= 300mm, W= 75mm, D= 62mm

During excavation and after grinding to bright metal Mr. Cayabyab was observed performing MT testing at various intervals of the excavation to ensure the discontinuities were removed. The QA Inspector also performed MT inspection of the excavation and did not observe any weld defects. The QC Inspector stated that this work is a continuation from the previous excavation to remove suspected indications. See TL-6028 for information on items inspected on this date.

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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
Reviewed By:	Mertz,Robert	QA Reviewer
