

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-029849
Date Inspected: 23-Jul-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

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

RWR201306-002

ESW E-043 Location "Q"-Face A

The QA Inspector observed, at random intervals, ABF/JV welder Don Plumb (WID-0891) performing weld repairs of the repair excavation on Electroslag Weld (ESW) "Q", at face A locations noted as:

Y= 6560mm~6700mm

L= 300mm

W= 75mm

D= 62mm

Prior to the repair work, ABF Quality Control (QC) Inspector Jesse Cayabyab 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 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 Jesse Cayabyab throughout the day and appeared to be in compliance with the WPS noted above.

WELDING INSPECTION REPORT

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In Process Visual Inspection

RWR201305-009

ESW W-043, 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. The weld repair at this location was completed on this date. Welder 4671 move to Y= 6200~6950 to commence another repair in the ring beam location.

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 and ABF QC Engineer Chris Chew stated that RWR# for the investigative excavations are pending and that CT METS are aware of the in process work.



WELDING INSPECTION REPORT

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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
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Reviewed By:	Mertz,Robert	QA Reviewer
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