

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-029869
Date Inspected: 24-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

RWR201307-004

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.

In Process Visual Inspection

RWR201306-002

WELDING INSPECTION REPORT

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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

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.

In Process Visual Inspection

RWR201305-009

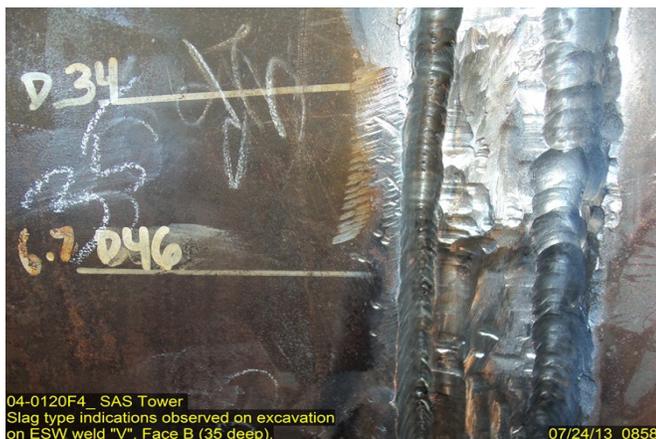
ESW W-043, Location "V"-Face B

The QA Inspector observed, at random intervals, ABF/JV welder Mike Jimenez (WID-4671) performing carbon arc air gouging of ESW "V" Face B, to verify and remove 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:

Excavation Y= 6200~7000

Slag type indications were observed at random depths from 10mm to 40mm deep.

Mr. Cayabyab performed informational MT testing at various intervals of the excavation to aid in identifying discontinuities to be removed. The QC Inspector stated that the excavation work performed on ESW "V"-Face B will continue throughout the shift into the next day. ABF QC were instructed by ABF Field Engineer Eric Blue to photograph document all indications observed in repair excavations.



Summary of Conversations:

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

WELDING INSPECTION REPORT

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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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