

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-029894
Date Inspected: 01-Aug-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 Dcoena	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) JV job site between the times noted above in order to monitor ABF Quality Control functions and the in process work being performed by ABF production personnel. The following items were observed:

Investigative excavation

ESW E-045,"F"-Face A:

The QA Inspector and ABF Quality Control Inspector Jesse Cayabyab were present to discuss an issue regarding a 180mm long toe crack indication located on the surface of the ESW weld F @ 8520mm~8700mm ABF Field Engineer Eric Blue was also present to observe the indication and determine a corrective a plan of action to repair the area. The toe crack had previously been excavated to a depth of 3mm and the indication still remained when inspected with Magnetic Particle Testing (MT) at the location noted above. Mr. Blue stated that he would have ABF draft a request for weld repair report to excavate that indication further and weld repair the location. Mr. Blue stated that this repair will be on hold until ABF and Tower SMR Aaron Prchlik have a chance to review and approve the weld repair request.

In Process Visual Inspection

RWR201305-009

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

The QA Inspector observed, at random intervals, ABF welder Mike Jimenez (WID-4671) performing Shield Metal Arc Welding (SMAW) of the repair excavation on Electroslag Weld (ESW) "V", at face B location noted as:
Y= 6200~7000mm

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L= 800mm

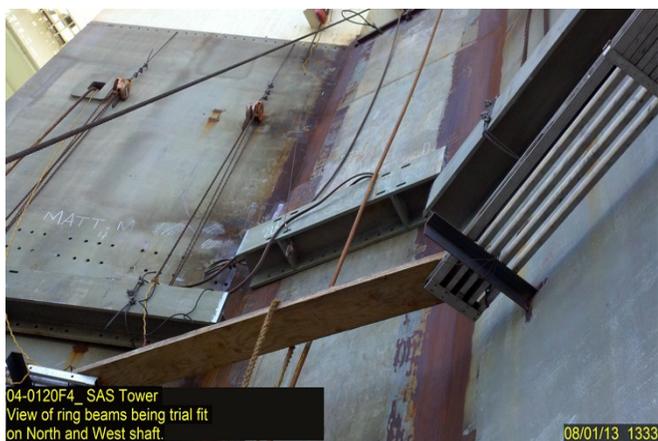
W= 80mm

D= 70mm

Prior to welding, 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 (E7018-1 HR4) per ABF Welding Procedure Specification (WPS) ABF-WPS-D15-1000-Repair Rev.3. The welding parameters were verified by ABF Quality Control (QC) Inspector Jesse Cayabyab with a Flukemeter and preheat was verified with temperature indicators. QC performed welding variable verifications at random interval throughout the shift. The welding observed appeared to be in compliance with the WPS noted above.

Tower Skirt Ring Beams

The QA Inspector was informed by ABF QC Inspector Bernie Docena that ABF Ironworker crew are installing and trail fitting ring beams at the exterior of the west and north shaft of the Tower. Mr. Docena stated that the beams are having access weld holes cut and bevels prepped at the ends where the beams will splice. The rings beams are being positioned where they will be installed and are having bolt access holes reamed and temporary bolts installed. The QC Inspector stated that ABF ironworker crew production plan to start SMAW welding ring beam exterior corners the week of 8-05-13.



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