

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029903**Date Inspected:** 08-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:** Anthony Sherwood**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:** Tower ESW Welds**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

The QA inspector was called to the CALTRANS office in Vallejo California to perform documentation review and discuss report submittal requirements with Task Leader Ken Riley. After reviewing the reports submitted earlier the QA inspector submitted the documents to Senior Task Leader Mike Foerder for review. Senior Task Leader Mike Foerder was not available at the time to review the submitted work, but the QAI was informed by Task Leader Ken Riley that the QA will be notified if any questions should arise concerning the documents reviewed.

Welder Kit Lai:

The welder was observed performing weld repairs on Ultrasonic Testing rejected indications on weld ESW G at Face B between Y locations 9090 and 9500 as per Request Weld Repair (RWR) 201307-005. The indication was excavated to 310 x 60 x 30 deep. The welder was observed preheating the weld to 350 degrees Fahrenheit prior to welding using the Miller ProHeat 35 with heat induction blankets. The welder utilized the 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 Anthony Sherwood throughout the day and they appeared to be in compliance with the WPS noted above.

Non-Destructive Testing (NDT)

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The QA performed NDT on the following:

- o ESW Q, Face A at Y 6000 - 6300. (UT Reject)

See TL-6027 for UT report details.



Summary of Conversations:

As required for scope of work.

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:	Belford,Fritz	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer
