

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029975**Date Inspected:** 29-Aug-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Jesse 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) JV job site between the times noted above in order to monitor ABF Quality Control activities and the in process work being performed by ABF production personnel. The following items were observed:

ESW Repair excavation

RWR-201308-004

ESW S-043, Location "T"- B:

The QA Inspector was later present to observe ABF welder Mike Jimenez (WID-4671) performing Shield Metal Arc Welding (SMAW) of the repair excavation on Electroslag Weld (ESW) "T", at face B. Locations are listed as detailed in Request for Weld Repair (RWR) 201308-004 from Ultrasonic Testing indications designated for repair.

The repair locations were noted as:

Y= 4100m~4410mm

L= 310mm

W= 68mm

D= 70mm

Prior to welding, Welder -4671 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 process in use was the Shielded Metal Arc Welding process (SMAW). The welding parameters were verified by QC Inspector Bernie Docena with a Fluke 337 current clampmeter and preheat was verified with temperature indicators. Mr. Docena performed welding parameters verifications at random intervals throughout the shift. The

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welding repair is approximately 30% complete at this location. The welding observed appeared to be in compliance with the WPS noted above.

ESW Repair excavation

RWR-201308-003

ESW E-043, Location "Q"-Face A:

The QA Inspector was later present to observe ABF welder Donald Plumb (WID-0891) performing Shield Metal Arc Welding (SMAW) on the repair excavation on Electroslag Weld (ESW) "Q", at face A. The locations and repair information are listed in Request for Weld Repair (RWR) 201308-003 from Ultrasonic Testing indications designated for repair. The repair locations were noted as:

Y= 3800mm~4300mm

L= 500mm

W= 80mm

D= 70mm

Prior to welding, Mr. Plumb was observed preheating the weld to over 350° 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 process in use was the Shielded Metal Arc Welding process (SMAW). The welding parameters were verified by ABF QC Inspector Bernie Docena with a Fluke 337 current Clampmeter and preheat was verified with temperature indicators. The QC Inspector performed welding parameters verifications at random intervals throughout the shift. Repair welding at this location at this location is approx. 75% complete. The welding observed appeared to be in compliance with the WPS noted above.

NDT Inspection of Electroslag Welds (ESW)

ESW E-043, Location "Q"-Face A,B:

ABF-RFI-003457R00

RWR-201306-002

The QA Inspector observed ABF QC Inspector Jesse Cayabyab perform Ultrasonic Testing (UT) on Tower Electroslag Complete Joint Penetration (CJP) weld designated as ESW "Q" face A, B. The inspection was being performed on SMAW repairs. Y Locations were noted as: Y=5800mm~6150mm and additional HAZ areas located 300mm above and below the prosed repair.

No rejectable or recordable indications were observed.

The QA Inspector also performed UT of the above mentioned ESW location in accordance with the ABF approved supplemental procedure for confirmation and evaluation of planar type defects. Tandem report for work performed on this date will be completed by Mr. Cayabyab and signed by both QA/QC parties. Items listed on tandem report reflect indications agreed upon by QA/QC. See TL-6027 for additional details on the 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
