

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 #: 99.28**WELDING INSPECTION REPORT**

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-030111
Date Inspected: 03-Oct-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:	Tony Sherwood, 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 Simion Ramirez (QA Inspector) was present at San Francisco Oakland Bay Bridge (SFOBB) job site at Yerba Buena Island. QA Inspector performed random verification visual testing (VT) and non-destructive testing (NDT) of ongoing field production work performed by American Bridge/Flour (AB/F). QA Inspector random observation of quality control functions are noted below:

Tower Skirt:

Base Plate #001 CJP Butt Splice

Skirt Plate #156 W. Shaft PJP Butt Splice

At skirt plate #2 vertical weld seam #156 W. Shaft the weld reinforcing was ground flush by ABF personnel. At weld #156 W. Shaft, QAI observed QCI performed VT as required and MT of 25% of weld face. Inspection at 1400 hour. QCI deemed test results acceptable. QAI observed at skirt base plate #001, ABF personnel removed the weld run-off tabs and ground the ends of weld flush with the tips of base plate, using carbon air-arc and grinding wheel. The weld crown (1.5mm) at base plate #001 remains in the as welded condition. Weld spatter was removed from face A to facilitate non-destructive testing (NDT). QA Inspector observed QCI Tony Sherwood perform 100% VT and MT of weld #001 including the weld ends, inspection at 1500 hour. QC deemed test results acceptable. QA Inspector observed QCI Bernie Docena, perform UT inspection on 25% of CJP weld #001, QC deemed results acceptable. Inspection at 1600 hour. After observing QCI perform the specified visual and non-destructive testing noted above, QA Inspector performed verification VT, MT and UT on approximately 10% of QC inspected areas. QA test results are in general compliance with project specifications. Reference QA NDT reports for more details.

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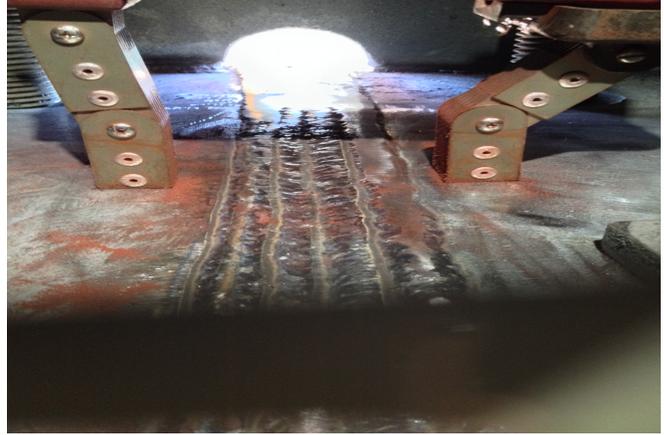
Summary of Conversations:

Only general conversation regarding the comments above.

QC 25% UT of base plate CJP weld #001.



QC MT full length of CJP base plate weld #001.



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: Ramirez, Simion

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer
