

**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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016303**Date Inspected:** 19-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See Below**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:** Orthotropic Box Girders**Summary of Items Observed:**

At the start of the shift the Quality Assurance Inspector (QAI) traveled to the project site and observed the following work performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below:

- A). Field Splice E2/E3
- B). Weld Repair Re: AB/F-SUB-001503 R00
- C). Field Splice E4/E5

A). Field Splice E2/E3

The QAI observed the welder, James Zhen, perform the Complete Joint Penetration (CJP) welding on the longitudinal field splice identified as WN: 2E-3E-A-LS5. The welding was performed on the "A" face of the weld joint utilizing the Shielded Metal Arc Welding (SMAW) as per the Welding Procedure Specification (WPS) identified as ABF-WPS-D15-1012-3, Rev.0 and the weld inspection was performed by John Pagliero utilizing the WPS as a reference. The QC inspector verified the DC welding parameters and were observed and recorded by the QAI as 128 amps.

The QAI observed the welder, Xiao Jian Wan ID-9677 performing the CJP welding on the "A" face of the weld joint utilizing the SMAW process as per the Welding Procedure Specification (WPS) identified as ABF-WPS-D15-1012-3, Rev.0. This work was performed and completed on the "A" Face of the longitudinal stiffener field splice identified as WN: 2E-3E-A-LS3 and the inspection was performed by the QC inspector utilizing the WPS as a reference. The welder performed the backgouging utilizing a rotary file and at the

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conclusion of the back gouging the QC technician Steve McConnell performed a Magnetic Particle Test (MPT) of the excavation and no rejectable indications were noted. The application and evaluation of the MPT appeared to comply with the MPT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. The QC inspector verified the DC welding parameters and were observed and recorded by the QAI as 124 amps.

The welding of the longitudinal stiffeners was performed in the vertical (3G) position with the work placed in an approximately vertical plane and the groove approximately vertical. The minimum preheat temperature of 100 degrees Celsius and the interpass temperature of 230 degrees Celsius appeared to comply with the contract documents. The electrodes were stored in electrically heated, thermostatically controlled oven after removal from sealed containers. The exposure limits of the electrodes identified as E9018-H4R and the minimum storage oven temperature of 250 degrees Celsius appeared to be in compliance with the contract documents. The welder completed the correcting of the root opening and the QAI observed the QC inspector perform a dimensional survey of the root opening and the included angle prior to the CJP welding. No issues were noted by the QC inspector and the welder commence the welding of the groove joint.

### B). Weld Repair, Re: AB/F-SUB-001503 R00

The QAI observed the assembly fit-up process of the new longitudinal shear plate located west of PP13 at the Orthotropic Box Girder (OBG) identified as lift 2W. The new plate appeared to have the upper corner cut at a 50mm radius and a weld access hole at the bottom of the weld joint.. No welding was performed during this shift.

### C). Field Splice E4/E5

The QAI observed the Ultrasonic Testing (UT) of the side plate field splice identified as WN: 4W-5W-E1 and E2. The testing was performed by the QC technician Steve McConnell utilizing a G.E./Krautkramer USM 35X and the UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4. The QC technician performed the required longitudinal wave testing for base metal soundness followed by the shear wave technique during the testing for weld soundness which was performed utilizing a .75 x .75 rectangular transducer. The UT was completed on this date and no rejectable indications were noted by the QC technician.

### QA Observation and Verification Summary

The QA inspector observed the QC activities and the welding of the field splices utilizing the WPS as noted above, which appeared to be posted at the weld station. The welding parameters and surface temperatures were verified by the QC inspector and utilizing a Fluke 337 clamp meter for the electrical welding parameters and a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. The ESAB consumables utilized for the SMAW process appeared to comply with the AWS Specification and AWS Classification. The QC inspection, testing and welding performed on this shift appeared to be in general compliance with the contract documents. At random intervals, the QAI verified the QC inspection, testing, welding parameters and the surface temperatures utilizing various inspection equipment and gages which included a Fluke 337 Clamp Meter and Tempilstik Temperature indicators.

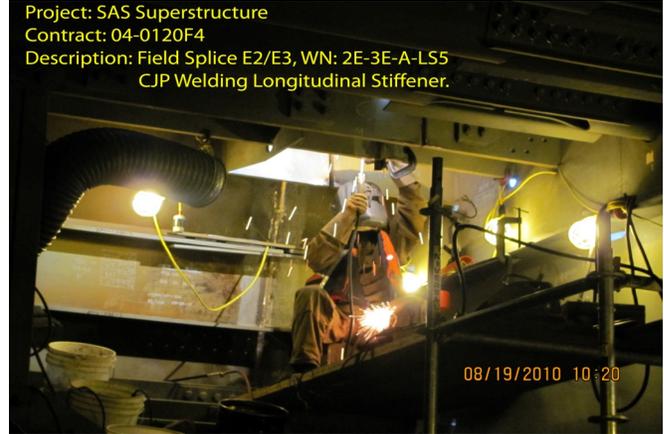
The digital photographs on page 3 of this report illustrate the work observed during this scheduled shift.

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## Summary of Conversations:

There were general conversations with Quality Control Inspector John Pagliero and Steve McConnell at the start of the shift regarding the location of American Bridge/Fluor welding personnel and inspection/ N.D.E. testing scheduled for 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 Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

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**Inspected By:** Reyes, Danny

Quality Assurance Inspector

**Reviewed By:** Levell, Bill

QA Reviewer