

**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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018436**Date Inspected:** 01-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**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). Deck Access Hole-TS
- B). Field Splice W7/W8
- C). Pipe Supports
- D). QC Inspection Request

A). Deck Access Hole-TS

The QAI observed the excavation of the unacceptable discontinuity on the transverse stiffener field splice identified as WN: 1E-PP10.5-E2-TS, repair cycle # R1. The rejectable discontinuities was discovered by the QAI during the verification of the QC Ultrasonic Testing (UT) performed by the QC technician, John Pagliero, and the discontinuity appeared to travel in the longitudinal direction of the weld axis. The excavation of the rejected area was performed by the welder Xiao Jian Wan, ID-9677, utilizing a high cycle grinder to remove the defects and a rotary file to bring the excavated area into compliance with the Weld Procedure Specification (WPS) ABF-WPS-D15-1001 Repair, Rev. 0. At the conclusion of the excavations the QAI observed the QC inspector performed a visual inspection and a Magnetic Particle Test (MPT) of the excavated areas and no rejectable indications were noted. At the conclusion of the VT and MPT, the welder commenced the welding of the repair which was identified with the following Y coordinate; 15 mm. The welding was performed by Xiao Jian Wan utilizing the Shielded Metal Arc Welding (SMAW) process as per the above mentioned WPS which was also

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utilized by the QC inspector to monitor the welding and to verify the DC welding parameters. The QC inspector verified the DC welding parameters as 120 amps and the minimum preheat temperature of 40 degrees Celsius and the maximum interpass temperature of 230 degrees Celsius appeared to comply with the contract documents. The welding was performed in the vertical (3G) position utilizing an E7018, 3.2 mm low hydrogen electrode. The welding of the repair was completed during the scheduled shift. The QAI also verified the dimensions of the excavation and were noted and recorded as follows; Y=15 mm, L=75 mm, d=6 mm.

### B). Field Splice W7/W8

The QAI observed the excavation of the unacceptable discontinuity on the transverse stiffener field splice identified as WN: 7W-8W-A1, repair cycle # R4. The rejectable discontinuity was discovered by QC technician Steve McConnell utilizing a G.E./Krautkramer USN 35X and a 70 degree probe and the discontinuity appeared to travel in the longitudinal direction of the weld axis. The excavation of the rejected area was performed by the welder Wai Kitlai ID-2953 utilizing a high cycle grinder to remove the defects and a rotary file to bring the excavated area into compliance with the Weld Procedure Specification (WPS) ABF-WPS-D15-1001 Repair, Rev. 0. At the conclusion of the excavation the QAI observed the QC inspector performed a visual inspection and a Magnetic Particle Test (MPT) of the excavated areas and no rejectable indications were noted. The QAI verified the dimensions of the excavation and were noted and recorded as follows; Y=0 mm, L=330 mm, d=20 mm.

The QAI also observed the Flux Cored Arc Welding (FCAW-G) of the weld joint identified as Weld Number (WN) W7-W8-C1. The Complete Joint Penetration (CJP) welding was performed by welding personnel Song Tao Huang, ID-3794 utilizing the WPS ABF-D15-3040B-1, Rev. 0. The WPS was also used by the QC inspector William Sherwood as a reference to monitor the welding and to verify the DC welding parameters which were noted and recorded by the QC as follows; 250 amps, 23.3 volts and a travel speed measured at 270 mm/m. The welding was performed in vertical position (3G) at approximate incline of 22 degrees with the weld progression up. The QC inspector also verified the minimum preheat temperature of 100 degrees Celsius and the maximum interpass temperature of 230 degrees Celsius. Later during the shift the QAI observed, at random intervals, the QC inspector monitoring the in process welding, the surface temperatures and verifying the welding parameters. The CJP welding was not completed during this shift.

### C). Pipe Supports

The QAI observed the fillet welding of the pipe supports located along the pier column at W2-W1, which was performed by David Garcia ID-8789 utilizing a 3.2 mm electrode as per the Welding Procedure Specification (WPS) identified as Fillet Murex. The fillet welding was performed in vertical (3F) position utilizing a 3.2 mm electrode. The QC inspection was performed by Mike Johnson utilizing the WPS to monitor the welding and to verify the amperage.

### D). QC Inspection Request

At the request of Quality Control Field Supervisor, Bonifacio Daquinag, the QAI randomly verified the visual appearance of the Complete Joint Penetration (CJP) welding of the following; Deck Access Hole Insert Plate (DAHIP) WN: 3E-PP22-E4-W1/W3 and 2E-PP17.5-E3-W1/W3. The verification was performed on the "B" face of the weld only. The QAI verification was performed to verify that the welding and visual inspection performed

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by the QC inspector meet the requirements of the contract documents. At the conclusion of the QAI verification it appeared that the weld and the QC inspection complies with the contract documents.

## 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 welding 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 photograph below illustrate the work observed during this scheduled shift.



## Summary of Conversations:

There were general conversations with Quality Control Inspector Bonifacio Daquinag, Jr. at the start of the shift regarding the location of American Bridge/Fluor welding, inspection and N.D.E. testing personnel 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 Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

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**Inspected By:** Reyes, Danny

Quality Assurance Inspector

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**Reviewed By:**      Levell,Bill

QA Reviewer