

**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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021075**Date Inspected:** 26-Mar-2011**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

<b>CWI Name:</b>	See Items Observed		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Component:</b>	Orthotropic Box Girders		

**Bridge No:** 34-0006**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). QC Magnetic Particle and Ultrasonic Testing
- B). QAI Non-Destructive Testing Verification
- C). Miscellaneous Task

## A). QC Magnetic Particle and Ultrasonic Testing

The QAI observed the Magnetic Particle Testing (MPT) and the Ultrasonic Testing (UT) of the of the side plate field splice identified as WN: 8W-9W-C1 and C2. The MPT and UT testing was performed by the QC technician Jesse Cayabyab utilizing a G.E./Krautkramer USM 35X and a Parker Contour Probe. The examination of the CJP weld joint was conducted utilizing UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4, the MT Procedure identified as SE-MT-D1.5-CT-100 Rev. 4 and the applicable contract documents. The QC technician performed the required longitudinal wave technique, utilizing a 25.4mm diameter transducer, to perform the examination for base metal soundness and the shear wave technique for the examination of weld soundness which was performed utilizing a 16mm x 19mm rectangular transducer. The testing of the field splice was not completed during this shift.

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# WELDING INSPECTION REPORT

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## B). QAI Non-Destructive Testing Verification

The QAI performed an Ultrasonic Test (UT) and a Magnetic Particle Test (MPT) on the edge plate field splices identified as WN: 8W-9W-B1, F1 and WN: 9W-10W-B1. The welds were tested 10% to verify the welds and testing by QC meet the requirements of the contract documents. The examination was performed as per the contract documents and a UT report, TL-6027 and a MPT report , TL-6028 was generated on this date.

## C). Miscellaneous Task

The QAI also performed a review and update of the project progress utilizing QA field reports and NDT reports. The updated project information was documented into the various QA tracking logs.

The digital photographs below illustrate some of the work observed during this scheduled shift.



## Summary of Conversations:

There were general conversations with Quality Control Inspector Jesse Cayabyab and William Sherwood 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

**Reviewed By:** Levell,Bill

QA Reviewer