DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

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

Report No: WIR-027640
Date Inspected: 22-May-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: jobsite

CWI Name:	William Sherwood			**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: OBG

Summary of Items Observed:

At the start of the shift this Quality Assurance Inspector (QA) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) welding and Quality Control (QC) personnel. The observations and inspections were performed as noted below:

OBG:

This QA observed the excavation and welding of the following repairs on the circumference welds of 8W-PP61. 5-W2 access hole repair locations are as follows: Y 2640 D 11 W 18 L 140 (all measurements from bottom). The welding was performed by the welder Eric Sparks (3040) utilizing the Shield Metal Arc Welding (SMAW) process, 7018H4R filler, at 127 amps with a preheat of 150F. QC William Sherwood was observed performing the in process weld inspection and QC verification using repair WPS ABF-WPS-1001R Rev 0. This QA observed and verified the welding and QC inspection at random intervals.

QA observed Magnetic Particle Testing (MT) performed by William Sherwood after the above mentioned repairs had been excavated and ground to a bright clean metal condition. Mr. Sherwood used Parker brand yoke #19881 with a calibration date of 3/22/12. Red powder was used to provide contrast to the base material and weld.

QA observed William Sherwood perform Magnetic Particle Testing (MT) on the following backgouged deck splice welds of OBG W13 West Drop-In: W2.5, W2.8, A0, W2.2, W2.1, and PPW 121.6. All welds were tested 100% using Parker Yoke #19881 having a calibration date of 3/22/12.

QA performed verification testing using Magnetic Particle Testing at a frequency of 10% of the above-mentioned welds. No indications noted.

The Contractor is in the process of removing the backing bar, grinding the surrounding base metal and back gouging/grinding the root of the weld to sound metal on the remainder of the Deck Splices of OBG W13 West Drop-In. All operations are in progress, when complete QC will perform Magnetic Particle Testing, at a frequency of 100%, to the root of the weld. QA will then perform a verification Magnetic Particle Test at a frequency of 10%.

Summary of Conversations:

There were general conversations with Quality Control Inspector William Sherwood, at the start of the shift regarding the location of welding, inspection 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.

Inspected By:	Daggett,Matt	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer