

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027641**Date Inspected:** 03-May-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge**Location:** Coraopolis PA**CWI Name:** Dennis Hildebrand**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:** Anchor Plate**Summary of Items Observed:**

This Quality Assurance Inspector (QAI) arrived at American Bridge (AB), Coraopolis PA, as requested per TL 38 to monitor Repairs to Anchor Plate HK2-A7 which was damaged during welding of anchor studs at Lubrite Industries, Meadville PA, on 4/20/12.

Upon arrival at AB this QAI met with Randy Wilson, QC Supervisor AB, and Dennis Hildebrand, QC/CWI AB. Dennis supplied copies of approved Repair Procedure, approved WPS, and approved Welder Qualifications, Certification for Magnetic Particle Testing Technician and His CWI Certification.

Anchor plate was still in box used to ship from Lubrite on 4/30/12. Green sticker from Lubrite visit still attached. Plate was set up on welding table and first defect at Repair Area #2 (per AB reports), Stud location #8 was ground flush to base metal. The stud had been removed at Lubrite prior to shipping to American Bridge. Once the area was ground flush a visual inspection was performed by AB QC and witnessed by this QAI. Excessive porosity was noticed in the base metal so the area had to be excavated to remove defects. An area approximately 1 3/4" x 2 1/4" x 3/16" deep was ground till all visible signs of surface defects were removed. The area was then Magnetic Particle tested using the yoke method. The Technician performing the test is certified per ASNT level II requirements. No indications were discovered at the time of testing. The excavated was then released for welding per approved weld and repair Procedures. The welding was performed and witnessed by QC and this QAI. The surface of the welded repaired area was then ground flush with the surface of the base metal.

Defect #1 at stud location #1 was then visually inspected and then the anchor stud was removed by grinding. The area was ground flush revealing (2) burned out pockets and porosity in the base metal. An area 1 1/4" x 1 15/16" x 3/16" deep was ground to remove all signs of surface defects. Visual Inspection by AB QC and witness by this QAI verified that all visual defects had been removed. The excavation was then Magnetic Particle Tested verifying all defects had been removed. Part was then released for welding of the excavation per approved WRP and ground

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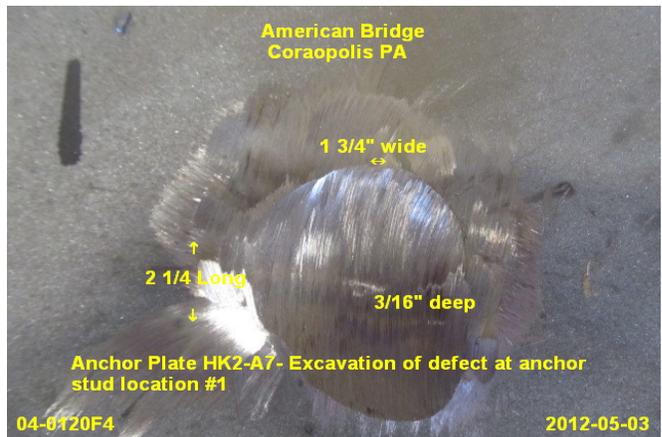
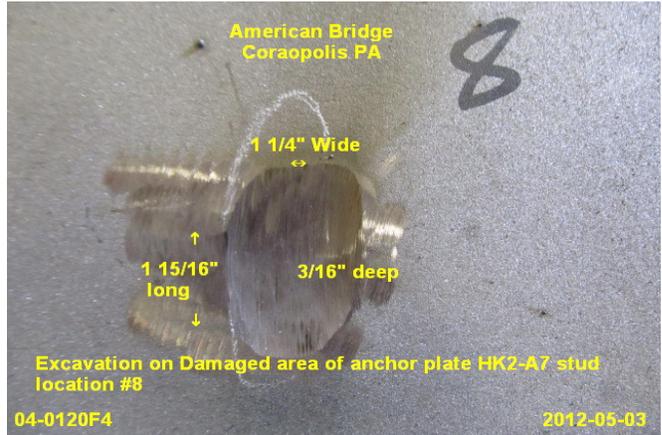
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flush with surface of base metal. Both repaired areas were then Magnetic Particle Tested for verification of sound repair metal. No indications were revealed during the test.

The anchor Plate was then Green Tagged by this QAI, S26-010-12 for return to Lubrite Industries in Meadville PA.

This QAI received copies of the Weld Repair and MT test reports from AB QC and released part for shipment.

The items observed appear in general conformance with the contract documents and approved drawings



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Summary of Conversations:

As noted above in items observed.

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 , who represents the Office of Structural Materials for your project.

Inspected By: Sullivan, Kevin

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer