**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-027656
**Date Inspected:** 23-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

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|---|---|---|---|---|---|---|---|
| **CWI Name:** | See Body of Report | | | **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 6W-PP46. 5-W2 access hole repair locations are as follows: Y:3315 D:17 W:20 L:120 (all measurements from top of deck plate). The welding was performed by the welder Eric Sparks (3040) utilizing the Shield Metal Arc Welding (SMAW) process, 7018H4R filler, at 125 amps with a preheat of 150F.
QC Bernard Docena 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 Bernard Docena after the above mentioned repair had been excavated and ground to a bright clean metal condition. Mr. Docena 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.

This QA observed the excavation and welding of the following repairs on the circumference welds of 6E-PP46. 5-E5 access hole repair locations are as follows:(All measurements from the bottom of the deck plate)

* Y:1185 D:8 W:20 L:50

* Y:2170 D:6 W:25 L:30

The welding was performed by the welder Michael Jiminez (4671) utilizing the Shield Metal Arc Welding (SMAW) process, 7018H4R filler, at 125 amps with a preheat of 200F.
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 the welding of repairs on stiffener 8E-PP61.5-E5 repair weld location is as follows:

* Y25, D15, W18, L:80

The welding was performed by the welder Todd Jackson utilizing the Shield Metal Arc Welding (SMAW) process, 9018filler, at 125 amps with a preheat of 200F.

QA observed Magnetic Particle Testing (MT) performed by William Sherwood after the above mentioned repair 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.

**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.

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