

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:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027658**Date Inspected:** 25-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/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** Salvador Merino**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 Splice 13E-14E

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:

This QA observed the excavation and welding of the following repair on weld A1 of the East Drop-in at Splice 13E-14E. The repair location and size is as follows: Y: 4300 W: 45 L: 300 D: 13mm. (all measurements from top of deck plate).

QA observed Magnetic Particle Testing (MT) performed by Salvador Merino after the above mentioned repair had been excavated and ground to a bright clean metal condition. Mr. Merino 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. No indications noted.

The welding was being performed utilizing the Shield Metal Arc Welding (SMAW) Process at 190 amps using a 4mm diameter E7018H4R consumable electrode. Preheat was verified by QA at 325F prior to gouging and

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welding.

QC Salvador Merino was observed performing the in process weld inspection and QC verification using repair WPS ABF-WPS-D15-1001R Rev 0. This QA observed and verified the welding and QC inspection at random intervals.

QA observed the repair welding of transverse stiffener 13E-PP120-E2.3. The excavation of the repair area had been done prior to QA arrival. The welding was being performed by qualified welder Khit Lounecheney (ID#4985) utilizing the Shield Metal Arc Welding (SMAW) Process at 125 amps using E7018H4R consumable electrode.

QC Salvador Merino was observed performing the in process weld inspection and QC verification using repair WPS ABF-WPS-D15-1030R Rev 0. This QA observed and verified the welding and QC inspection at random intervals.

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
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Reviewed By:	Levell, Bill	QA Reviewer
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