

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-027695**Date Inspected:** 29-May-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**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:

This QA observed the welding of the back gouged areas on deck splice weld W2.2 at splice 13W and 14W. The welding was being performed by Rich Garcia utilizing the Shield Metal Arc Welding (SMAW) Process at 130 amps using E7018H4R consumable electrode. Preheat was verified by QA at 210F prior to welding.

QC William Sherwood was observed performing the in process weld inspection and QC verification using WPS ABF-WPS D15-1030 Rev1. This QA observed and verified the welding and QC inspection at random intervals.

QA observed the removal by carbon arc gouging and welding of the following repairs on deck access hatch 5W-PP36.5-W2:

- Y: 3570, D:50, W:25, L:40mm
- Y:3765, D:14, W:25, L:250mm
- Y:4040, D:12, W:20, L:90mm

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. No

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indications noted.

QA observed Magnetic Particle Testing (MT) performed by John Pagliero on stiffener weld DAH-S-6W-PP46. 5-W2-L8-E (R2). Mr. Pagliero 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.

QA observed Magnetic Particle Testing (MT) performed by John Pagliero on stiffener weld DAH-S-6W-PP46. 5-W2-L8-W (R2). Mr. Pagliero 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.

QA performed a verification Magnetic Particle Test at a frequency of 10% of the area tested by QC. QA 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.

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
