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-027696
Date Inspected: 31-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

Inspected CWI report:	☐	Yes	☑	No	☐	N/A		
Electrode to specification:	☑	Yes	☐	No	☐	N/A		
Qualified Welders:	☑	Yes	☐	No	☐	N/A		
Approved Drawings:	☑	Yes	☐	No	☐	N/A		

CWI Present:	☑	Yes	☐	No				
Rod Oven in Use:	☑	Yes	☐	No	☐	N/A		
Weld Procedures Followed:	☑	Yes	☐	No	☐	N/A		
Verified Joint Fit-up:	☑	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 West Drop-in Splice W13/W14

This QAI observed the welding of the back gouged backside of weld joint 13W-14W-A2.2. The welding was being performed by Michael Jiminez in the 4G position using the Shield Metal Arc Welding (SMAW) Process at 124 amps using an E7018H4R consumable electrode.

QC William Sherwood was observed by this QAI performing in-process weld inspection and QC verification using the applicable Welding Procedure Specification. This QAI observed and verified the welding and QC inspection at random intervals.

OBG Suspender Brackets

QAI performed Magnetic Particle Testing (MPT) on 10% of the QC tested area on the circumference weld of Deck Access Hole 6W-PP46.5-W2. This QAI used Parker Contour Probe Model DA400 bearing serial number 16991, with a calibration date of 5/10/12. Testing was performed from the top and bottom of the deck plate/weld. No rejectable indications noted.

WELDING INSPECTION REPORT

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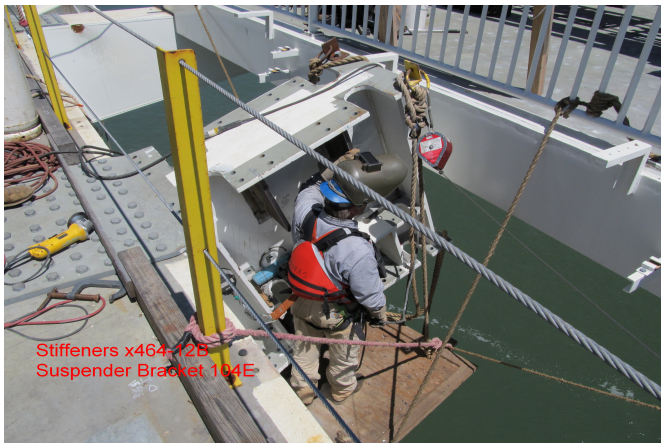
This QAI observed the fitting of stiffeners X464-12A on Suspender Bracket PPE-104E. The fitting was performed per unapproved drawing FW464-01 dated 5/29/12 by Eric Sparks. No out of tolerance gaps were noted, stiffeners fit tight to the web and flanges. (see photo)

QAI observed the welding of stiffeners x464-12A on the west side of Suspender Bracket PPE-104E. The welding was being performed by Eric Sparks in the 3G and 4G position using the Shield Metal Arc Welding (SMAW) Process at 124 amps using an E7018H4R consumable electrode.

The copy of the drawing FW464-01 dated 5/29/12 covering the additional stiffeners on Suspender Bracket 104 and 106 does not contain an Engineers approval stamp.

Stiffener material pictured does not have the proper CALTRANS tag to verify witness of cutting and sampling at it's place of origin. (see photo)



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