**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-027762
**Date Inspected:** 11-Jun-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:** 1630
**Location:** jobsite

**CWI Name:** Andrew Keech

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|---|---|---|---|
| **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 |

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|---|---|---|---|
| **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:

CCO 201; Tower Elevation 38; Pad eye Install

This QAI observed the removal of paint by grinding at 12 locations at Tower elevation 38. Ground areas were clean to a bright metal condition, then layout, location lines to be used during Pad eye installation were scribed on the tower columns. Per CCO 201 12 total Pad eyes were to be installed at elevation 38.

After grinding and layout this QAI observed the base metal being preheated to a QC recorded and QA verified temperature of 250F. The preheating was accomplished utilizing a rosebud torch using propane as fuel. Preheat was verified by this QA utilizing a Tempil Stick.

As soon as preheating operations ceased the Pad eye was attached to the tower column by Welder Rory Hogan using the Shield Metal Arc (SMAW) Process utilizing an E7018H4R consumable electrode at a QC recorded, QAI verified 126 amps.

This QAI performed Visual Weld Inspection of the 10 Pad eye to Tower Column welds completed on this date. Welds were found to meet the requirements of AWS D1.5 Bridge Welding Code Visual Inspection Criteria.
CCO 201; Tower Elevation 43; Pad eye Install

# WELDING INSPECTION REPORT

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This QAI observed QC Technician Andrew Keech performing Magnetic Particle Testing (MPT) at 12 locations of welds joining Pad eyes to Tower Columns at Tower Elevation 43. The testing was performed at a frequency of 100%. No Indications were noted.

This QAI performed verification Magnetic Particle Testing at a frequency of 10% of the 12 pad eye to Tower Column at Tower Elevation 43. No indications were noted. See MPT report dated 6/11/12 for details.

**Summary of Conversations:**

There were general conversations with Quality Control Inspector Andrew Keech, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift. All observations were relayed to Danny Reyes and Bill Levell.

**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 |