

**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-027831**Date Inspected:** 26-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**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 QAI observed the back gouging and grinding to bright clean metal of stiffener 13W-PP120.5-TS1. The back gouging was performed by welder Wen Han Yu (ID#6317). At the conclusion of operations the back gouge depth and ground profile met the requirements of AWS D1.5-02.

Immediately after joint had cooled to ambient condition Quality Control Inspector William Sherwood performed Magnetic Particle Testing at a frequency of 100% to the back gouged area no indications noted. Mr. Sherwood's testing was witnessed by this QAI, also a verification Magnetic Particle Test was performed at a frequency of 10% by this QAI. No indications noted. See MT report dated 6-26-12.

QAI randomly verified and QC recorded the preheat to 150F of deck plate splice W121.6. The proper preheat is being obtained by use of induction heating blankets located on the top of the bridge deck plate. The preheat temperature is being checked by Tempil Sticks.

This QAI observed welder Mike Jiminez (ID#4671) welding W121.6 utilizing the Shield Metal Arc Welding Process, in the 4G position, at a QC recorded QA randomly verified, 125 amps. The verified 125 amps are within the parameters of the applicable Welding Procedure Specification ABF-WPS-D15-1040C-CV. Mr. Jiminez is using a power wire brush and chipping hammer to remove slag after each pass. The weld splice is complete.

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

This QAI observed welder Tran Chau welding Stiffener 13W-PP120-TS-1 utilizing the Shield Metal Arc Welding Process, in the 3G position, at a QC recorded QA randomly verified, 125 amps. The verified 125 amps are within the parameters of the applicable Welding Procedure Specification ABF-WPS-D15-1030. Mr. Chau is using a power wire brush and chipping hammer to remove slag after each pass. The weld splice is complete.

QAI observed the preparation and fit up of 2.5" pipe at PP114-12W by welder LLamos. Prior to tack welding, the ends of the pipe were ground to a bright metal condition. A 1/16" root opening was achieved by the use of a shim, and the pipe was tacked in location using The Shield Metal Arc Welding Process utilizing E7018 consumable electrodes. No finish welding has been performed on this joint at the time of this report



### 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. 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.

---

<b>Inspected By:</b>	Daggett, Matt	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

---