

**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-027863**Date Inspected:** 29-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

<b>CWI Name:</b>	Fred Michaels/William Sherwood			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	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:

QAI witnessed the welding of Floor Beam Splice PP124-W2.2-BW1 by welder Steven Davis (ID#7889) utilizing the Shield Metal Arc Welding Process in the 3G position using E7018 consumable electrodes to the QC recorded QA verified parameters of Welding Procedure Specification ABF-WPS-D15-1030-1. Welder Davis was depositing weld metal using the stringer technique post weld cleaning was accomplished using a chipping hammer and power wire brush.

This QAI performed a Visual Weld Inspection at the conclusion of welding operations, the Inspection revealed no weld defects. After the weld has cooled to ambient conditions for 48 hours, it will be tested using the Magnetic Particle Testing method, followed by Ultrasonic Testing to check for internal defects.

This QAI witnessed Welder Wen Han Yu welding floor beam splice PP124.5-W2.2-BW1 to completeness utilizing the Shield Metal Arc Welding Process in the 3G position using E7018 consumable electrode. The welding is being performed to the QC recorded, QA verified parameters of Welding Procedure Specification ABF-WPS-D15\_1030-1. Welder Yu was using good workmanship techniques to clean between passes and attempt to not trap slag left from the previous weld pass.

QAI witnessed the welding of Floor Beam Splice PP123-W2.8-BF3 by welder Tran Chau (ID#7889) utilizing the

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Shield Metal Arc Welding Process in the 1G/4G position using E7018 consumable electrodes to the QC recorded QA verified parameters of Welding Procedure Specification ABF-WPS-D15-1030-1. Welder Chau was depositing weld metal using the stringer technique post weld cleaning was accomplished using a chipping hammer and power wire brush.

This QAI performed a Visual Weld Inspection at the conclusion of welding operations, the Inspection revealed no weld defects. After the weld has cooled to ambient conditions for 48 hours, it will be tested using the Magnetic Particle Testing method, followed by Ultrasonic Testing to check for internal defects.

This QAI witnessed the welding of Floor Beam Splice PP123-W2.1-BF1 by welder Mike Jiminez (ID# (ID#7889)utilizing the Shield Metal Arc Welding Process in the 1G/4G position using E7018 consumable electrodes to the QC recorded QA verified parameters of Welding Procedure Specification ABF-WPS-D15-1030-1. Welder Jiminez was depositing weld metal using the stringer technique post weld cleaning was accomplished using a chipping hammer and power wire brush.

This QAI performed a Visual Weld Inspection at the conclusion of welding operations, the Inspection revealed no weld defects. After the weld has cooled to ambient conditions for 48 hours, it will be tested using the Magnetic Particle Testing method, followed by Ultrasonic Testing to check for internal defects.

This QAI witnessed the welding of Floor Beam Splice PP123-W2.1-BF1 by welder Eddie Brown (ID#9331)utilizing the Shield Metal Arc Welding Process in the 1G/4G position using E7018 consumable electrodes to the QC recorded QA verified parameters of Welding Procedure Specification ABF-WPS-D15-1030-1. Welder Brown was depositing weld metal using the stringer technique post weld cleaning was accomplished using a chipping hammer and power wire brush.

This QAI performed a Visual Weld Inspection at the conclusion of welding operations, the Inspection revealed no weld defects. After the weld has cooled to ambient conditions for 48 hours, it will be tested using the Magnetic Particle Testing method, followed by Ultrasonic Testing to check for internal defects.



## Summary of Conversations:

There were general conversations with Quality Control Inspector Fred Michaels, 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.

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