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-028069
Date Inspected: 27-Jul-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: 1530
Location: jobsite

CWI Name:	Steve Jensen/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:

13W/14W Drop-In

This QAI observed Rick Clayborn (2773) excavating weld 13W-W2.1 utilizing a Carbon Arc Gouging. During gouging operations a 250F preheat was maintained using induction heating blankets. At the conclusion of gouging the joint was ground to a U-Joint profile that exhibited a bright clean shiny metal condition.

After Grinding, QAI witnessed William Sherwood Quality Control Technician perform Magnetic Particle Testing to the above listed excavation of weld 13W-W2.1. Mr. Sherwood performed testing at a frequency of 100%. No indications were noted.

This QAI observed Rick Clayborn welding the above-mentioned repair excavations utilizing the Shield Metal Arc Welding to the parameters set forth in the approved Welding Procedure Specification using E7018 consumable electrode. During welding operations a Quality Control recorded Quality Assurance verified 350F preheat was maintained using induction heating blankets. At the conclusion of welding operations post heat was initiated utilizing induction heating blankets at 450F for four hours.

This QAI observed Welder Xiao Juan Wan (ID#9677) using a rosebud torch to preheat Stiffeners 12W/13W LS-7,

and LS-8 to a QC recorded, QA verified temperature of 250F. Preheat temperature was measured using a Tempil Stick. This QAI noted QC Tony Sherwood recording preheat temperature whenever there was a stop in work.

QAI observed Mr. Wan using the Shield Metal Arc Welding process to deposit E9018 consumable electrode to the parameters set forth by the approved Welding Procedure Specification in Stiffeners 12w/13W LS-7 and LS-8. This QAI observed the welder Mr. Wan using good workmanship practices cleaning between weld passes.

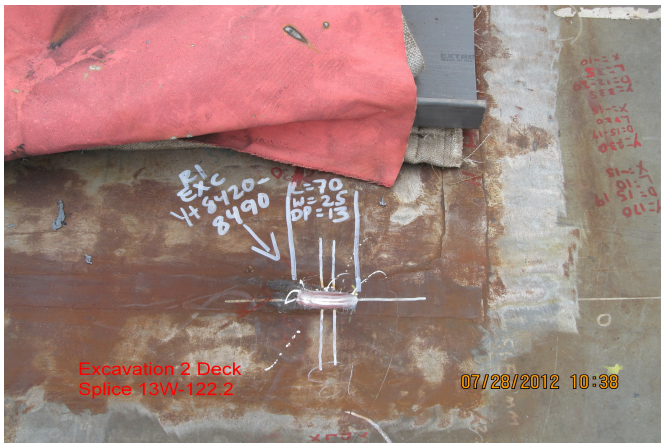
This QAI observed Welder Eric Sparks (ID#3040) excavating at the following locations in weld 13W-W122.2:

Excavation # Y L W DP
1 5850mm-5920mm 70mm 25mm 13mm
2 8420mm-8490mm 70mm 25mm 13mm

The weld metal excavation was being accomplished utilizing the Carbon Arc Gouging Process. During gouging operations a 250F preheat was maintained using induction heating blankets. At the conclusion of gouging the joint was ground to a U-Joint profile that exhibited a bright clean shiny metal condition.

After Grinding, QAI witnessed William Sherwood Quality Control Technician perform Magnetic Particle Testing to the above listed excavation of weld 13W-W2.1. Mr. Sherwood performed testing at a frequency of 100%. No indications were noted.

This QAI observed Mr. Sparks welding the above-mentioned repair excavations utilizing the Shield Metal Arc Welding to the parameters set forth in the approved Welding Procedure Specification using E7018 consumable electrode. During welding operations a Quality Control recorded Quality Assurance verified 350F preheat was maintained using induction heating blankets. At the conclusion of welding operations post heat was initiated utilizing induction heating blankets at 450F for four hours. The repairs are first time repairs, so no RWR is required.



WELDING INSPECTION REPORT

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Summary of Conversations:

There were general conversations with Quality Control Inspector Steve Jensen, at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift. All observations were relayed to 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.

Inspected By:	Daggett,Matt	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer