

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028213**Date Inspected:** 15-Aug-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 1100**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2130**Contractor:** American Bridge**Location:** Reedsport, OR**CWI Name:** Harry Woodworth**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:** Jacking Saddle Shim Block**Summary of Items Observed:**

During the second work shift, this Quality Assurance Inspector (QAI) observed Quality Control Inspector (QCI), Harry Woodworth, of American Bridge (AB) Manufacturing continued to monitor the welding of Jacking Saddle Shim Block, 90% completed, from previous two days of work. This Jacking Saddle Shim Block has been welding during first work shift by AB personnel. A welder, Tucker Koreiva, of AB continued welding on the shim block from first work shift. Tucker Koreiva performed a Partial Joint Penetration (PJP) on a 1-1/2" to 1-1/2" plate of A709 HPS 70W (485W) steel material per approved drawing in accordance to Welding Procedure Specification (WPS) ABM-SMAW. Shielded Metal Arc Welding (SMAW) process was utilized with E9018M-H4R 5/32" diameter electrode as the filler metal. This QAI noted electrodes were stored in a heated oven and were not exposed to atmosphere for more than one hour. Also noted Tucker Koreiva preheated the joint prior to welding. This QAI verified joint fit-up and verified preheat temperature with Extech min-infrared thermometer Model 42500. This QAI verified amperage, 165 amps, during welding using Amprobe Model ACDC-100. These instruments were noted to be within calibration due date.

This QAI performed visual observation and randomly verified weld size using a fillet weld gauge at on the shim block upon welding completion. This QAI noted weld size seemed to meet approved drawing and meet weld profile.

# WELDING INSPECTION REPORT

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Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	SMAW: fillet and pjp	ABM-SAS-023	Harry Woodworth	170	N/A	18 ipm	150 F	QA randomly verified joint fit-up and weld profile

### Summary of Conversations:

QC informed this QAI that inter-pass temperature was monitored by welding alternately between two different joints. QC informed this QAI that Tucker Korelva completed welding PJP joints of the Jacking Shim Block at 5:30 pm. QC will perform magnetic particle testing on Friday 5:30 pm.

### 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 Bahjat Dahger, 510-577-8250, who represents the Office of Structural Materials for your project.

<b>Inspected By:</b>	Chang, Dan	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer