

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 #: 99.28**WELDING INSPECTION REPORT**

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-028214
Date Inspected: 17-Aug-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge

OSM Arrival Time: 1100
OSM Departure Time: 2130
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 performed magnetic particle testing, dry method with dry powder, on 100% of the fillet and partial joint penetration (pjp) weld length of the Jacking Saddle Shim Block. This QAI performed magnetic particle test verification at 25% weld length and observed surface discontinuities were not detected. Refer to Magnetic Particle test report for additional information. Magnetic particle test was performed after 48 hours of waiting time.

Upon completion of magnetic particle test, this QAI observed Tucker Koreiva, of AB perform fillet weld shim block plate to shim block. All steel material were A709 HPS 70W (485W) steel material per approved drawing in accordance to Welding Procedure Specification (WPS) ABM-SAS-022. Shielded Metal Arc Welding (SMAW) process was utilized with E9018M-H4R 5/32" diameter electrode as the filler metal. It was noted that electrodes were stored in a heated oven and were not exposed to atmosphere for more than one hour. This QAI observed QCI monitored amperage, preheat temperature, and joint fit-up. QCI informed this QAI that amperage is 165 amps and preheat is above 150°F as specified in welding procedure specification (wps). This QAI verified joint fit-up and verified preheat temperature with Extech min-infrared thermometer Model 42500. Additionally, amperage was also verified using Amprobe Model ACDC-100. These instruments were noted to be within calibration due date. This QAI reviewed WPS, welder's qualification record, Special Provision, and AWS D1.5.

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Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	SMAW: fillet weld	ABM-SAS-022	Harry Woodworth	120	N/A	19 ipm	150 F	Tucker Koreiva completed welding Jacking Saddle Shim Block

Summary of Conversations:

As noted above.

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.

Inspected By: Chang, Dan Quality Assurance Inspector

Reviewed By: Riley, Ken QA Reviewer