

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028349**Date Inspected:** 14-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 Manufacturing (ABM) monitoring the welding operations of the Jacking Saddle Shim Block.

This QAI observed that ABM was continuing the welding operations on the shim block by welder Tucker Koreiva from the first shift welders. It was observed that the welder was using the Shielded Metal Arc Welding (SMAW) for the Partial Joint Penetration (PJP) welds on A709 HPS 70W (485W). The material thickness being welded was 1-1/2" to 1-1/2" with electrode E9018M-H4R, and a 5/32" diameter. The welding Procedure Specification (WPS) being used by the welder was, ABM-SMAW. This QAI observed that the QCI was using Amp probe Model ACDC-100 to verify the welding parameters and appeared to be within the WPS range of 165 amps. Prior to the start of the welding process the welder preheated the material to 150°F which was verified by the QCI using an Extech mini-infrared thermometer Model 42500. It was relayed to this QAI that the welder was informed of the atmospheric requirements for this electrode of no more than one (1) hour of exposure. This QAI also noted that the QCI was monitoring the inter-pass temperatures for both weld joints that were in process. The welder was alternating between two (2) weld joints. At the time of the observation the in process welding appeared to be within general compliance of the contract documents.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	SMAW: fillet and pjp	ABM-SAS-023	Harry Woodworth	174	N/A	19 ipm	150 F	QA random observed in process welding

Summary of Conversations:

QC informed this QAI that inter-pass temperature was monitored by welding alternately between two different joints

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:	Chang, Dan	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer