

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-028390**Date Inspected:** 14-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** American Bridge Manufacturing**Location:** Reedsport, OR

CWI Name:	David Speakman		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No	
Rod Oven in Use:	Yes	No	N/A
Weld Procedures Followed:	Yes	No	N/A
Verified Joint Fit-up:	Yes	No	N/A
Approved WPS:	Yes	No	N/A
Delayed / Cancelled:	Yes	No	N/A

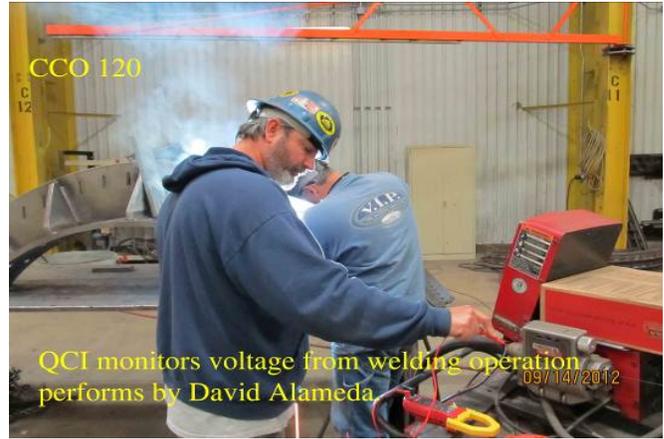
Bridge No: 34-0006**Component:** Hinge A Restraint Brackets**Summary of Items Observed:**

This Quality Assurance Inspector (QAI), Dan Chang, observed Quality Control Inspector (QCI), Tony Corsaletti, of American Bridge Manufacturing (ABM) monitored the welding of Hinge A Restraint Brackets of CCO 120S1. QCI was observed monitoring the in process welding amperage and voltage with an Amprobe Model ACDC-100 during the welding process. The welding process was performed by Mike Catlett, David Alameda, and Tom Dailey using Flux Cored Arc Welding (FACW) using E71T-1 1/16" diameter electrode for the partial penetration and fillet welds. QCI noted that the Welding Procedure Specifications (WPS) being used are ABM-SAS-07 and ABM-SAS-08. The welding parameters for the each welders were observed to be an average of 290 amp, 26.5 volt, and travel speed at 17 inch per minute (ipm) for Mike Catlett; an average of 280 amp, 26 volt and travel speed at 17 ipm for David Alameda; and 280 amp, 27.5 volt, and travel speed at 17.5 ipm for Tom Daily. The joint was preheated to 150 °F by the welder prior to the start of the welding operation which was verified by QCI using an Extech mini-infrared thermometer Model 42500. This QAI performed random observations of the welding process during this work shift and noted restraint bracket piece-mark # X01A-24, X01A-25, and X01A-26 were being welded by Mike Catlett, David Alameda, and Tom Dailey respectively. QCI was observed to be inspecting welds on the restraint brackets. At the time of the observation the in process welding appeared to be within general compliance of the contract documents.

The QA inspector performed a Magnetic Particle Testing (MT) review of the brackets in which QC had identified as acceptable. A total of 21 components were reviewed for a minimum of 10% of the associated welds with the items appearing to be in general conformance with the contract documents at the time of review. See TL-6028 for this date for more specific information.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	PJP and fillet weld	ABM-SAS-07, 08	David Speakman	290	26.5	17	150 F	Welding operation by Mike Catlett
2	PJP and fillet weld	ABM-SAS-07, 08	David Speakman	280	27.5	17.5	150 F	Welding operation by Tom Dailey
3	PJP and fillet weld	ABM-SAS-07, 08	David Speakman	280	26	17	150 F	Welding operation by David Alameda

Summary of Conversations:

No significant conversations held on this date for the item of work.

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 Gary Thomas, 916-674-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Chang, Dan	Quality Assurance Inspector
Reviewed By:	Foerder, Mike	QA Reviewer