

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028504**Date Inspected:** 25-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:** Harry Woodward**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:** Elevator Tower Enclosure frames**Summary of Items Observed:**

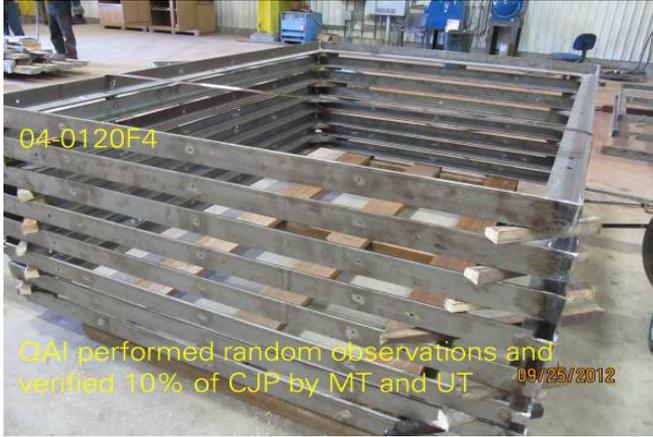
This Quality Assurance Inspector (QAI), Dan Chang, performed a random observation on fabricated Elevator Tower Enclosure frames, CCO 85. Some welds did not appear to meet weld profiles requirements of AWS were discovered. This QAI informed Welding Quality Control Inspector (WQCI), Harry Woodward, of American Bridge Manufacturing (ABM) who directed an ABM personnel to perform addition work on the welds. This QAI performed additional observations after the welds were reworked. The reworked welds appeared to meet the weld profiles requirements of AWS.

This QAI performed verification Magnetic Particle Test (MT) and Ultrasonic Test (UT) on 10% of the vertical complete joint penetration welds of the enclosure frames. MT was performed using a yoke with dry red powder for visual contrast. MT and UT equipments were within its calibration due date. The piece-mark which were tested by this QAI were 91-3, 91-4, 91-1A1, 91-1A2, 91-1A3, 91-2A1, 91-2A2, 92-1B1, 92-1B2, 101-C1, 101-1C2, 101-1C3, and 102-2B3. Please see 04-0120F4_TL-6028_B344_9-25-12_Reedsport and 04-0120F4_TL-6027_B344_9-25-12_Reedsport for more information.

WQCI informed this QAI that the fabrication of enclosure frames were welded by Matt Pascarelli, Mike Catlett, Tucker Koreiva, and Andrew Bilbrey. Welding was performed in accordance to Welding Procedure Specification (WPS), ABM-SAS-25, which specified to use Flux Cored Arc Welding (FCAW) with E71T-1JH8 and 1/16" diameter electrode. All welding parameters were within the requirements of WPS been used.

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Summary of Conversations:

All conversation relayed to this QAI was 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 Gary Thomas, 916-764-6027, who represents the Office of Structural Materials for your project.

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