

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

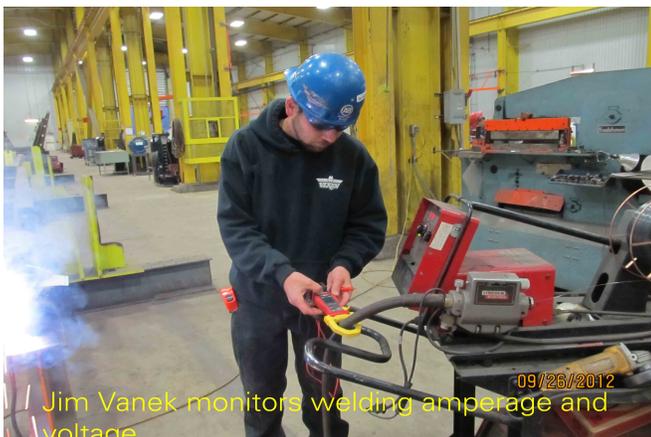
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028505**Date Inspected:** 26-Sep-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** American Bridge Manufacturing**Location:** Reedsport, OR

CWI Name:	Jim Vanek		
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
Component:	Bike Path Divider Rail Modification		

Bridge No: 34-0006**Summary of Items Observed:**

This Quality Assurance Inspector (QAI), Dan Chang, observed Welding Quality Control Inspector, Jim Vanek, of American Bridge Manufacturing monitored the welding of divider rails, CCO 189. The welding consisted of splice complete joint penetration (CJP) rail and CJP rail to base plates. WQCI informed this QAI that the average amperage was 200 and average voltage was 25. Welding was performed utilizing welding procedure specification (WPS) #ABM-SAS-24 which specified Flux Cored Arc Welding (FCAW) as the welding process with E71T-1 1/16" diameter as the electrode. Welding was performed by Brian Moore of ABM. This QAI verified his average travel speed is 9 inch per minute. At the time of random observations, Brian Moore was noted to be welding on piece-mark # NS-26.



WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	NS-26	ABM-SAS-24	Jim Vanek	200	25	9 ipm	N/A	QAI performed regular random observation intervals

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 Gary Thomas, 916-764-6207, who represents the Office of Structural Materials for your project.

Inspected By:	Chang,Dan	Quality Assurance Inspector
----------------------	-----------	-----------------------------

Reviewed By:	Riley,Ken	QA Reviewer
---------------------	-----------	-------------