

**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-028906**Date Inspected:** 13-Dec-2012

**Project Name:** SAS Superstructure  
**Prime Contractor:** American Bridge/Fluor Enterprises, a JV  
**Contractor:** American Bridge Manufacturing (ABM)

**OSM Arrival Time:** 600**OSM Departure Time:** 1630**Location:** Reedsport, OR

**CWI Name:** Harry Woodworth  
**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:** OBG Safety Cable Railings

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

This Quality Assurance Inspector (QAI), Dan Chang, arrived at American Bridge Manufacturing (ABM) as requested per TL-38 for the fabrication noted within CCO 188. This QAI observed Quality Control Inspector (QCI), Harry Woodworth, of American Bridge Manufacturing (ABM) monitor and verify the welding of 19x42 mm and 10x42 mm to 32 mm diameter gate pipe. This QAI witnessed QCI verify the amperage and voltage were within welding procedure specification (WPS) ranges. Welding was performed utilizing welding procedure specification (WPS) #ABM-SAS-7 which specified Flux Cored Arc Welding (FCAW) as the welding process with E71T-1, 1/16" diameter electrode. The welding was performed by certified welder Mike Hebert of ABM. This QAI witnessed the welding throughout the shift and noted that the QCI was within the area on a periodic basis to verify and record the welding parameters.



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# WELDING INSPECTION REPORT

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Item	Weld Identification	Applicable WPS	CWI Name	Amperage	Voltage	TravelSpeed	Preheat Temp	Remarks
1	Fillet Welds	ABM-SAS-7	Harry Woodworth	250	25	7.5 ipm	none	Welding was performed by Mike Hebert of ABM

## 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) 764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Chang,Dan	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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