**DEPARTMENT OF TRANSPORTATION**
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

# WELDING INSPECTION REPORT

**Resident Engineer:** Casey, William
**Address:** 333 Burma Road
**City:** Oakland, CA 94607

**Report No:** WIR-028973
**Date Inspected:** 14-Jan-2013

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

**OSM Arrival Time:** 700
**OSM Departure Time:** 1730
**Location:** jobsite

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|---|---|---|---|
| **CWI Name:** | See Body of Report | **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:** OBG

**Summary of Items Observed:**

This QAI observed the welder Mike Jiminez grinding to a bright clean metal condition base metal gouges, in the Deck Plate at the following locations: (RWR 201301-019)

8W-PP66.7-W2.2

8W-PP67-W3.8

8W-PP61-W2.3

8W-PP61W2.5

Prior to welding, Quality Control Technician Sal Merino, performed Visual and Magnetic Particle Testing on the above base metal gouges. This Quality Assurance Inspector verified the results of the test. No indications were noted.

The welder spent part of the shift depositing the root passes and fill passes with approximately 100% being completed at the end of the shift. QC inspector Merino was noted to be present in order to monitor the progress and ensure the welding was within the established Welding Procedure Specification (WPS) noted as ABF-WPS-D15-1001R Rev 0 and supporting Procedure Qualification Records (PQR). Prior to and during the welding at this location the QC inspector observed the preheat temperature using a Raytek non-contact Thermometer, was sufficient and compliant to the above-mentioned WPS. Using a Tempil Stick, (temperature

indicating crayon) the pre-heat was then verified by this QA inspector to be greater than 150F. Using a Fluke brand Tong style meter, the parameters were verified to be 115 amps.

13W-PP119 (CCO-238)

This QAI observed Rick Clayborn grinding and laying out the eight locations at 13W-PP119. The stiffeners were delivered on to the project palletized in sets upon test fit it was discovered that the stiffeners were not beveled correctly. At the time of this report the Contractor has decided to order replacement material.

8E-74-E4/9E-74-E4

This QAI observed Quality Control Technician Sal Merino performing Magnetic Particle Testing at the following locations:

8E-74-E4

9E-74-E4

The contractor had removed welded attachments from these locations that had connected the temporary supporting steel to the outer surface of the above mentioned OBG's. The areas were then ground to a bright clean metal condition and revealed a good workmanship appearance. The Magnetic Particle Testing revealed zero defects at the tested locations.

**Summary of Conversations:**
See body of report.

**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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|---|---|---|
| **Inspected By:** | Daggett,Matt | Quality Assurance Inspector |
| **Reviewed By:** | Reyes,Danny | QA Reviewer |