

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029451**Date Inspected:** 21-Mar-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**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:**

At the start of shift, this Quality Assurance Inspector (QAI) traveled to the project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) personnel. The inspection was performed on the various Complete Joint Penetration (CJP) groove welds of the East and West Orthotropic Box Girders (OBG's) and piping connections.

At the start of the shift this QAI observed the following:

This QAI observed the Shielded Metal Arc Welding (SMAW) of the Deck Access Hole (DAH) identified as 12E-PP116.5-E2. The welding was performed utilizing the Welding Procedure Specification (WPS) identified as WPS-ABF-1040C-Rev. 1 which was also used by the Quality Control (QC) Inspector Bonifacio Daquinag, as a reference, to monitor and perform QC inspection during the in-process welding. The welding was performed by Mike Jimenez utilizing the 4.0 mm electrode as per the WPS with the amperage was measured at 180 amps by Mr. Daquinag. The preheat was also monitored and noted as 150 degrees F. The welding, QC inspection and related work was verified by this QAI which appeared to be in compliance with the contract documents.

This QAI also observed the Complete Joint Penetration (CJP) welding of the lifting rod closure plate identified as EB-SLLH-16. The welding was performed in the flat (1G) position with the work placed in an approximately horizontal plane and the weld metal deposited from the upper side. The welding was performed by Wai Kit Lai, 2953, utilizing the Shielded Metal Arc Welding (SMAW) process as per the Welding Procedure Specification (WPS) identified as WPS-ABF-1030. The WPS was also used by the QC inspector as a reference during the in-process welding of the joint. The welding, inspection and the related work appeared to comply with the

WELDING INSPECTION REPORT

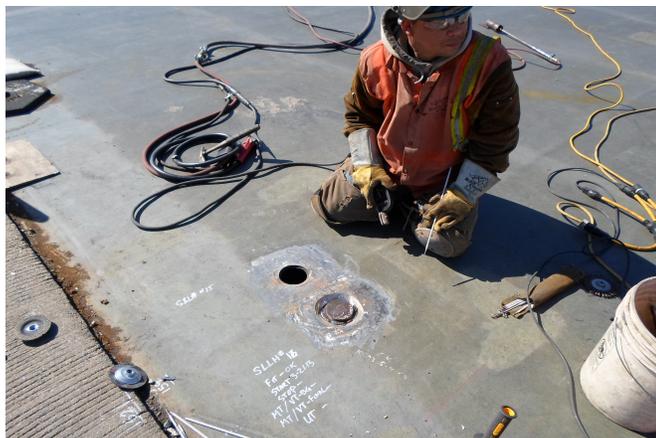
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contract documents.

Later in the shift, this QAI also observed the fit-up of the lifting rod closure plate identified as EB-SLLH-15. The welding was performed utilizing the Welding Procedure Specification (WPS) identified as WPS-ABF-1030 which was also used by the Quality Control (QC) Inspector William Sherwood, as a reference, to monitor and perform QC inspection during the in-process welding. The welding was performed by Wai Kit Lai, 2953, utilizing the 3.2 mm and 4.0 mm electrode as per the WPS. The welding, QC inspection and related work was observed and verified by this QAI which appeared to be in compliance with the contract documents.

This QAI also observed the fit-up and welding of the compressed air piping branch connections as identified by FW Spencer 1/CA2/PP87.5, 1/CA2/PP88.5, and 1/CA2/89.5. The welding was performed by Damien Llanos #6645 utilizing E6010 electrodes for root pass and E7018 electrodes for fill and cover passes as per the WPS identified as #1-12-1. This QAI verified the average welding current of 90 amps during the welding of the root pass utilizing the E6010 electrodes. The Quality Control (QC) Inspector, Bonifacio Daquinag, was present at this welding station.

The digital photographs below illustrate some of the work activities observed on this date:



Summary of Conversations:

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 , who represents the Office of Structural Materials for your project.

Inspected By: Morris, Monty

Quality Assurance Inspector

Reviewed By: Reyes, Danny

QA Reviewer