

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-029452**Date Inspected:** 22-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).

The welding was performed utilizing Shielded Metal Arc Welding (SMAW) process as per the Welding Procedure Specifications (WPS's).

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 Salvador Merino, as a reference, to monitor and perform QC inspection during the in-process welding. The Complete Joint Penetration (CJP) groove welding was performed by Mike Jimenez, ID # 4671, utilizing the 4.0 mm electrode as per the WPS and 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 minimum pre-heat was also monitored and noted as 150 degrees F. The welding and QC inspection was observed and verified by this QAI and appeared to be in compliance with the contract documents.

This QAI observed welding of compressed air piping branch connection welds 1/CA2/86.5, 1/CA2/85.5, 1/CA2/84.5, and 1/CA2/83.5 by welder Damian Llanos #6645 using E6010 electrodes for root pass, and E7018 electrodes

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for fill and cap passes as per WPS#1-12-1. AB/F QC Bonifacio Daquinag was present.

This QAI observed compressed air piping welds of branch connections 1/CA2/53.5/BE, 1/CA2/54.5/BE by welder Rick Kiikvee #5319 using E6010 electrodes for root passes and E7018 electrodes for the fill and cap passes. AB/F QC Bonifacio Daquinag was present.

This QAI observed the removal of the lifting lugs on the bike path panels. This QAI also observed the QC technician, Fred Michels perform Magnetic Particle Testing (MPT) at following designated panel points: PP43.5 (North & South), PP64.5 (North & South), and PP63.5 (North & South). At the completion of the QC testing and at the request of the QC technician this QAI performed MPT of the above mentioned locations. At the conclusion of QA verification no rejectable indications were noted. For details regarding the testing and testing results see MPT report identified as TL-6028, which was generated on this date.

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
