

**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-029472**Date Inspected:** 25-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 witnessed lifting lug removal areas of the longitudinal shear plate identified as EB-SLL-11 and weld root grinding of EB-SLLH-11. The Quality Control (QC) Inspector, William Sherwood, was present during this operation.

This QA inspector observed the backgouging of the root on the Deck Access Hole (DAH) identified as 12E-PP16. 5-E2. The welder, Mike Jimenez, ID-4671 performed the backgouging utilizing the manual cutting process. Once the backgouging process was complete, Mr. Jimenez performed the grinding to remove cutting slag and carbon residue. At the conclusion of the grinding of the backgouged surface this QAI observed the Quality Control (QC), Bonifacio Daquinag, performed the Magnetic Particle Testing (MPT) and at the completion of the testing no rejectable indications were noted. At this time the welder commence the welding of the Complete Joint Penetration (CJP) of this weld joint.

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# WELDING INSPECTION REPORT

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This QA inspector also observed the Complete Joint Penetration (CJP) groove welding of the root on the lifting rod closure plate identified as EB-SLLH-14. The welding was performed in the flat (4G) position with the work placed in an approximately horizontal plane and the weld metal deposited from the underneath side of the weld joint. 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 contract documents.

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.

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<b>Inspected By:</b>	Morris, Monty	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes, Danny	QA Reviewer

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