

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-029508**Date Inspected:** 08-Apr-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:****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 performed the Magnetic Particle Testing (MPT) inspection of Lifting Rod closure plate weld at location WB-SLLH-1 and of Lifting Lug removal areas of the longitudinal stiffener at location WB-SLL-1. These welds were also MT inspected previously by the AB/F Quality Control (QC) Inspector William Sherwood. There were no indications noted at this time. See the attached TL-6028 MT report for details. The welding, QC inspection and related work was observed and verified by this QAI and appeared to be in compliance with the contract documents.

This QAI performed the Magnetic Particle Testing (MPT) inspection at WB-SLLH-16 of Lifting Rod closure plate weld. There were no indications noted at this time. This weld was previously MT inspected by the AB/F Quality Control (QC) Inspector William Sherwood. See attached TL-6028 MT report for details. The welding, QC inspection and related work was observed and verified by this QAI and appeared to be in compliance with the contract documents.

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This QAI witnessed the preheat to 150F and the backgouging to sound metal in progress of the weld root at location WB-SLLH-14 Lifting Rod closure plate by welder Wai Kit Lai #2953. The AB/F Quality Control (QC) Inspector William Sherwood was present, monitoring the backgouging activities.

This QAI performed the Ultrasonic Testing (UT) inspection at location WB-SLLH-1 of the Lifting Rod closure plate weld. This weld was previously UT inspected by the AB/F Quality Control (QC) Inspector Bernard Docena. There were no indications noted at this time. See the attached TL-6027 UT report for details. The welding, QC inspection and related work was observed and verified by this QAI and appeared to be in compliance with the contract documents.

This QAI performed the Ultrasonic Testing (UT) inspection of the Lifting Rod closure plate weld at location WB-SLLH-16. There were no indications noted at this time. This weld was previously tested by the AB/F Quality Control (QC) Inspector Bernard Docena. See the attached TL-6027 UT report for details. The welding, QC inspection and related work was observed and verified by this QAI and appeared to be in compliance with the contract documents.

This QAI performed the Ultrasonic Testing (UT) inspection at of the Deck Access Hole (DAH) closure plate weld at location 12E-PP116.5-E2. The R2 repair areas of the weld as well as the remainder of the entire weld length were UT verification inspected by this QAI. This weld had been previously tested and accepted by the AB/F Quality Control (QC) Inspector Bernard Docena. There were 6 (six) total rejectable areas of this weld that were found by this QAI. See the attached TL-6028 UT report for details.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

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



Summary of Conversations:

No significant conversations took place.

Comments

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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
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Reviewed By:	Reyes, Danny	QA Reviewer
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