

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-029509**Date Inspected:** 04-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:** 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. 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 the Lifting lug removal area grinding of the longitudinal shear plate surface that was in progress at location WB-SLL-5. This work has not yet been completed. The AB/F Quality Control (QC) Inspector William Sherwood was present and monitoring the work.

This QAI witnessed the lifting lug removal area grinding of the longitudinal shear plate surface that was in progress at location WB-SLL-8. This work has not yet been completed. The AB/F Quality Control (QC) Inspector William Sherwood was present and monitoring the work.

This QAI witnessed the performance of Magnetic Particle Testing (MPT) inspections at location WB-SLLH-11 by the AB/F Quality Control (QC) Inspector William Sherwood. This QAI performed the MT verification inspection of this same weld and at the conclusion of the QA verification no rejectable indications were noted. 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.

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This QAI witnessed the Magnetic Particle Testing (MPT) inspections performed at WB-SLLH-9 by AB/F Quality Control (QC) Inspector William Sherwood. This QAI performed the MT verification inspection of this same weld and at the conclusion of the QA verification no rejectable indications were noted. 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 Ultrasonic Testing (UT) verification inspection of R1 repair welding of Deck Access Hole (DAH) closure plate 12E-116.5-E2. There were 2 (two) rejectable indications found during scanning. See the attached TL-6027 UT report for details.

This QAI witnessed the preheating to 150F and 1G welding performed and completed of Lifting Rod closure plate at location WB-SLLH-4. The welding was performed by Wai Kit Lai #2953 utilizing E7018 electrodes as per Welding Procedure Specification (WPS) ABF-WPS-D15-1030. The AB/F Quality Control (QC) Inspector William Sherwood was present, monitoring and verifying the WPS parameters of the welding that was performed. The portion of 1G (flat position) welding so far performed appears to conform to the contract documents.

This QAI witnessed the fit-up, and welding of the 2 inch diameter schedule 40 pipe branch connections of the Domestic Water line for locations 1-DW1-79.5, 1-DW1-80.5, 1-DW1-81.5, 1-DW1-82.5, 1-DW1-83.5, 1-DW1-84.5, 1-DW1-86.5. The welding was performed by Rick Kickvee #5319 utilizing E6010 electrodes for the root pass, and E7018 electrodes for the fill and cap passes as per WPS #1-12-1. The AB/F Quality Control (QC) Inspector Bonifacio Daquinag Jr. was present, monitoring and verifying the WPS parameters of the welding that was performed. The welding, QC inspection and related work was observed and verified by this QAI and appeared to be in compliance with the contract documents.

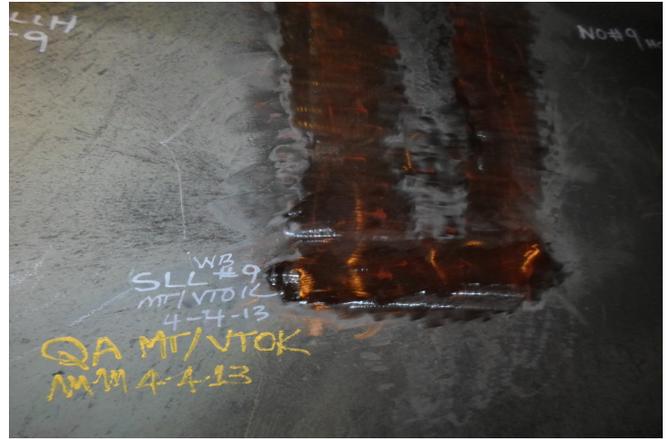
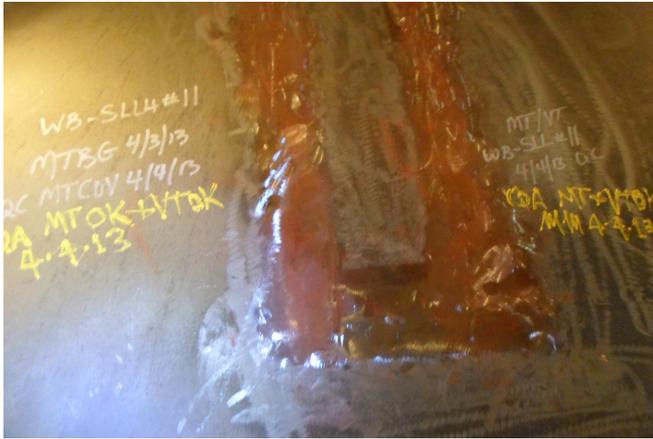
This QAI witnessed the preheat to 150F, and the 4G (overhead position) welding in progress at location WB-SLLH-9, after backgouging of root to sound metal, as verified by Magnetic Particle Testing (MPT) inspection that was performed by the AB/F Quality Control (QC) Inspector William Sherwood.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

The digital photographs on page three (3) of this report illustrate some of the work activities observed on this date:

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Summary of Conversations:

No significant conversations took place.

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 SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By: Morris, Monty

Quality Assurance Inspector

Reviewed By: Reyes, Danny

QA Reviewer