

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-029510**Date Inspected:** 05-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).

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 Magnetic Particle Testing (MT) of lifting lug closure plate weld at location WB-SLLH-15 as performed 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 QA verification there were no rejectable 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 witnessed the Magnetic Particle Testing (MPT) of lifting rod closure plate weld at location WB-SLLH-4 as performed 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 QA verification there were no rejectable 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.

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This QAI witnessed the Magnetic Particle Testing (MPT) inspection of Lifting Lug removal areas of longitudinal stiffener at location WB-SLL-4 by the AB/F Quality Control (QC) Inspector William Sherwood. This QAI performed the MT verification inspection of these same areas and at the conclusion of QA verification there were no rejectable 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 verified the bevel preparation, fit-up, preheat to 150F, and 1G welding in progress at location WB-SLLH-8. The welding was performed by Lin E. Yun #9344 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 being performed. The portion of 1G (flat position) welding so far performed appears to conform to the contract documents.

This QAI witnessed the Lifting Lug removal grinding at WB-SLL-12 and backgouging of the weld root in progress at location WB-SLLH-12. The AB/F Quality Control (QC) Inspector William Sherwood was present and monitoring the work.

This QAI witnessed the Magnetic Particle Testing (MPT) inspection of Lifting Lug 'pyramid' profile removal areas of longitudinal stiffener at L13W-W3-PP118.5 (North) by the AB/F Quality Control (QC) Inspector Salvador Merino. This QAI performed the MT verification inspection of these same areas and at the conclusion of QA verification there were no rejectable indications noted at this time. See the attached TL-6028 MT report for details.

This QAI witnessed the Magnetic Particle/MT testing of the Lifting Lug 'pyramid' profile removal areas of the longitudinal stiffener at location L13W-W3-PP122.65 (North) as performed by the AB/F Quality Control (QC) Inspector Salvador Merino. This QAI performed the MT verification inspection of these same areas and at the conclusion of QA verification there were no rejectable indications noted at this time. See the attached TL-6028 MT report for details.

This QAI witnessed the Magnetic Particle Testing (MPT) inspection of Lifting Lug 'pyramid' profile removal areas of the longitudinal stiffener at location L13W-W3-PP119.5 (North) as performed by the AB/F Quality Control (QC) Inspector Salvador Merino. This QAI performed the MT verification inspection of these same areas and at the conclusion of QA verification there were no rejectable indications noted at this time. See the attached TL-6028 MT report for details.

This QAI witnessed the Ultrasonic Testing (UT) of lifting rod closure plate weld at location WB-SLLH-15 as performed by the AB/F Quality Control (QC) Inspector Bernard Docena. This QAI performed the UT verification inspection of this same weld and at the conclusion of QA verification there were no rejectable 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 witnessed the Ultrasonic Testing (UT) inspection of Lifting Rod closure plate weld at location WB-SLLH-13 as performed by the AB/F Quality Control (QC) Inspector Bernard Docena. This QAI performed

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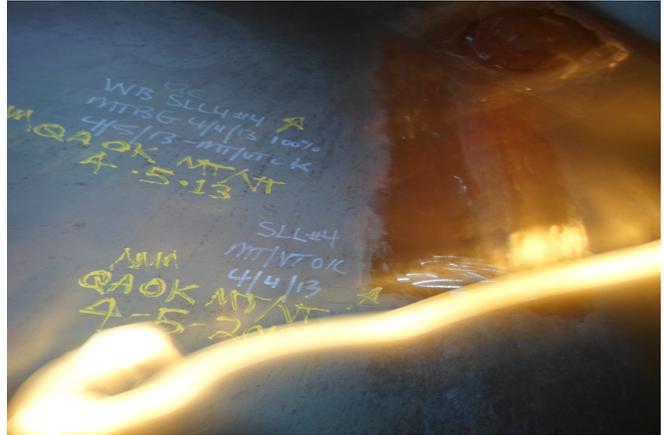
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the UT verification inspection of this same weld and at the conclusion of QA verification there were no rejectable indications noted at this time. See the attached TL-6027 UT report for details. The welding, QC inspection and related work was observed and verified by this QAI and appeared to be in compliance with the contract documents.

This QAI witnessed the Ultrasonic Testing(UT) of lifting rod closure plate weld at location WB-SLLH-4 as performed by AB/F Quality Control (QC) Inspector Bernard Docena. This QAI performed the UT verification inspection of this same weld and at the conclusion of QA verification there were no rejectable 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.

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

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
