

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-029511**Date Inspected:** 06-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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 (MPT) of the Lifting Rod closure plate weld at location WB-SLLH-12 and the lifting lug removal areas of the longitudinal stiffener at location WB-SLL-12 as performed by the AB/F Quality Control (QC) Inspector William Sherwood. This QAI performed the MT verification at these same areas and at the conclusion of the QA verification 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 witnessed the Magnetic Particle Testing (MPT) of the lifting rod closure plate weld at location WB-SLLH-12 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 the 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

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contract documents.

This QAI witnessed the Ultrasonic Testing (UT) of the lifting rod closure plate weld at location WB-SLLH-12 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 the 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 Magnetic Particle Testing (MPT) of the lifting rod closure plate weld at location WB-SLLH-13 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 the 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 also verified the preheat to 150F for the backgouging of the weld root to sound metal and the 4G welding in process for the lifting rod closure plate weld at location WB-SLLH-16. The welding was performed by Wai Kit Lai #2953 utilizing E7018 electrodes as per the 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.

This QAI witnessed the Ultrasonic Testing (UT) inspection of the Lifting Rod closure plate weld at location WB-SLLH-12 as performed by the AB/F Quality Control (QC) Inspector Bernard Docena. This QAI performed the verification inspection of this weld and at the conclusion of the QA verification there were no rejectable indications noted at this time. See 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 the lifting rod closure plate weld at location WB-SLLH-9 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 the 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 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