

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

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-029512**Date Inspected:** 09-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 performed the Ultrasonic Testing (UT) inspection of the full penetration weld of relocated midspan mounting/foot plate of EB-Hinge-'A' Barrier Rail at EB-PP128.5 + 1000. The AB/F Quality Control (QC) Inspector Bernard Docena had performed prior UT inspection of the same weld. There were no indications noted at this time. See attached TL-6027 UT report for details. This QAI requested a copy of an RFI directive which outlines the work to be performed, but did not receive it this day.

This QAI performed the Ultrasonic Testing (UT) inspection of the Lifting Rod closure plate welds at locations WB-SLLH-8, WB-SLLH-10, and WB-SLLH-14. The AB/F Quality Control (QC) Inspector Bernard Docena performed his UT inspection previously of these same welds. 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.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QAI performed the Magnetic Particle Testing (MPT) of the Lifting Rod closure plate weld at WB-SLLH-10. The AB/F Quality Control (QC) Inspector William Sherwood had performed his MT inspection previously of this same weld. 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.

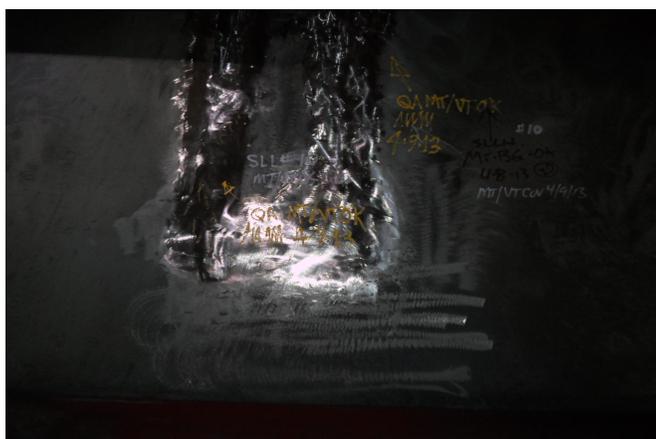
This QAI performed the Magnetic Particle Testing (MPT) of the Lifting Rod closure plate welds at locations WB-SLLH-14, WB-SLLH-8, and WB-SLLH-10. The AB/F Quality Control (QC) Inspector William Sherwood had performed his MT inspections of same welds previously. There were no indications noted at this 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 Magnetic Particle Testing (MPT) of the Lifting Lug removal areas of the longitudinal stiffeners at locations WB-SLL-8, and WB-SLL-10. The AB/F Quality Control (QC) Inspector William Sherwood had performed the MT inspection of these same areas previously. 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) verification of the Lifting Lug removal 'pyramid' of the profile ground areas of the longitudinal stiffeners at locations L14W-W4-PP127.75 (North), and L14-W4-PP127.75 (South). The AB/F Quality Control (QC) Inspector Salvador Merino performed his MT inspections of the same welds previously. 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.

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:

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

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
