

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-029514**Date Inspected:** 11-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 (MPT) of the vertical (3G position) fillet welds on the Transverse Stiffener across bottom of Deck Access Hole (DAH) at location 12W-PP116.5-W2-TS performed by the AB/F Quality Control (QC) Inspector William Sherwood. This QAI performed the MT verification inspection of these same welds. See the attached TL-6028 MT report for details.

This QAI observed welding of 2F, 3F and 4F fillet welds in progress per AB/F RFI #003256R00 of seal cover plates at the Grillage Plates/East Saddle Dehumidification area 13W-PP119(-1500)-W3. Welding was performed by G.W. Chen #1556 utilizing E7018 electrodes per WPS #F1200A. No AB/F QC was noted at this time.

This QAI witnessed welding of 3/4 inch diameter headed shear studs to representative thickness sample plate, to qualify the procedure. AB/F QC William Sherwood was present. Shear stud welding was performed at OBG WB Transition Expansion joint to Skyway at Hinge-'A'. The following locations of 8-3/16 inch long studs were

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completed at Row 32 - 65 (Flat, 7 lines), and Row 42 - 66 (Horizontal, 2 lines). The following locations of 4-3/16 inch long studs were completed at Row 32 - 62 (Flat, 8 lines), and Row 32 - 61 (Horizontal, 2 lines). Welder was Matt Cochran #4320 per WPS D15-5062 and WPS D15-5063.

Thsi QAI observed preheat to 150F in place and welding in progress of Transverse Stiffener across bottom of Deck Access Hole at 12E-116.5-E2-TS. Welding was performed by Kit Lai #2953 utilizing E7018 electrodes as per WPS #F1200A. AB/F QC Salvatore Merino was present.

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

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
