

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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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-029521**Date Inspected:** 30-Mar-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) and fillet welds of Bikepath items. The welding was performed utilizing Shielded Metal Arc Welding (SMAW) process as per the Welding Procedure Specifications (WPS's).

This QAI witnessed the welding of the Bike Path Pipe Support brackets at PP43, PP69, PP77, PP79 utilizing E7018 electrodes as per WPS ABF-WPS-D15-F1200A by the following welders: James Zhen #6001; Wai Kit Lai #2953; Mike Jimenez #4671; and Eric Sparks #3040. This QAI witnessed the Magnetic Particle Testing (MPT) inspection by the AB/F Quality Control (QC) Inspector Salvador Merino. This QAI also performed the MT verification inspection of these welds. See the attached TL-6028 MT report for details. The welding, QC inspection and related work was observed and verified by this QAI which appeared to be in compliance with the contract documents.

This QAI witnessed the Ultrasonic Testing (UT) inspections of the Lifting Rod closure plate welds as performed by AB/F Quality Control (QC) Inspector Bernard Docena at the following locations: EB-SLLH-12, EB-SLLH-9, EB-SLLH-13; and WB-SLLH-2. This QAI performed the UT verification testing inspections of the weld locations EB-SLLH-12, EB-SLLH-9, and EB-SLLH-2. See the attached TL-6027 UT report for details. There were no indications noted at this time. The QC inspection, testing and related work was observed and verified by this QAI which appeared to be in compliance with the contract documents.

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# WELDING INSPECTION REPORT

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This QAI witnessed the Magnetic Particle Testing (MT) testing inspections of Lifting Lug removal 'pyramid' profile areas of longitudinal shear plate indicated as L13W-PP119.5-W4 (South) as performed by AB/F Quality Control (QC) Salvador Merino. This QAI performed the MT verification inspections of these same areas. See the attached TL-6028 MT report for details. The QC inspection and related work was observed and verified by this QAI which 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 SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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**Inspected By:** Morris, Monty

Quality Assurance Inspector

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**Reviewed By:** Reyes, Danny

QA Reviewer