

**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-029522**Date Inspected:** 02-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 the 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 verified the bevel preparation, fit-up/tacking, preheat to 150F, and the subsequent 1G welding utilizing the E7018 electrodes as required per the Weld Procedure Specification (WPS) ABF-WPS-D15-1030 as performed by the welder, Mike Jimenez #4671, at the weld location WB-SLLH-14 lifting rod closure plate. The AB/F Quality Control (QC) Inspector William Sherwood was present to monitor the welding parameters.

This QAI observed the bevel preparation and the in progress fit-up of the lifting rod closure plate at WB-SLLH-13. The AB/F Quality Control (QC) Inspector William Sherwood was present to monitor the fit-up and the related work.

This QAI witnessed the bevel preparation, fit-up and tack welding, preheat and the 1G portion of the welding performed at the weld location WB-SLLH-15 lifting rod closure plate. The welding was performed by Wai Kit Lai, ID 2953, utilizing the E7018 electrodes as per the WPS ABF-WPS-D15-1030. The AB/F Quality Control

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(QC) William Sherwood was present to monitor the welding parameters.

This QAI witnessed the 1G (flat position) welding at the weld location WB-SLLH-16 lifting rod closure plate. The welding was performed by Wai Kit Lai utilizing E7018 electrodes as per the WPS ABF-WPS-D15-1030. The AB/F Quality Control (QC) Inspector William Sherwood was present to monitor the welding parameters which verified at 185 amps. This portion of the weld appears to comply with the contract requirements.

This QAI witnessed the Magnetic Particle Testing (MPT) and inspection of the OBG lifting lug 'pyramid' profile removal areas of the longitudinal shear plate at L14W-W4-PP124.65 (South) and L13W-W4-PP118.5 (South). The testing and inspection was performed by the AB/F Quality Control (QC) Inspector Salvador Merino. This QAI performed the MT verification of these same removal areas 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.

Unless otherwise noted, all the 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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<b>Inspected By:</b>	Morris, Monty	Quality Assurance Inspector
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<b>Reviewed By:</b>	Reyes, Danny	QA Reviewer
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