

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-029525
Date Inspected: 12-Apr-2013

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
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) and inspection of the Lifting Lug 'pyramid' profile removal areas of the longitudinal stiffener at location L14W-W3-PP127.75 (North) as performed by the AB/F Quality Control (QC) Inspector Salvador Merino. This QAI also performed the MT verification and inspection of these same areas. 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) and inspection performed of the lifting lug 'pyramid' profile removal areas of the longitudinal shear plate at location L14W-W3-PP127.75 (South) as performed by the AB/F Quality Control (QC) Inspector Salvador Merino. This QAI performed the MT verification inspection of these same areas. 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.

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This QAI performed Ultrasonic Testing/UT verification inspection of R2 repair areas of Deck Access Hole 12E-PP116.5-E2 DAH. AB/F QC Bernie Docena previously performed UT inspection of these R2 repair areas. See the attached TL-6027 UT report for details.

This QAI observed welding in progress of seal cover plates at OBG 13W-119(+1500)-W3 as per ABF RFI #003256R00. Welding was performed by Lin E Yun #9344 utilizing E7018 electrodes per WPS ABF-WPS-D15-F1200A. The Quality Control (QC)Inspector Salvador Merino was present to monitor the in progress welding and its related work.

Unless noted above the welding, QC inspection and testing observed by this QAI on this date appeared to comply with the project 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
