

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-029526**Date Inspected:** 28-Mar-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 and Tower**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 weld items of Tower. 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 visually inspected the root pass of the longitudinal fillet weld at the Tower west face Drainage Plate D-PL5 at the 151M elevation:

This drainage plate's weld was completed previously, but required total removal, re-fit and re-welding due to a prior misalignment due to shrinkage distortion. This QAI witnessed the AB/F Quality Control (QC) Inspector Fred Michels perform the Magnetic Particle Testing (MPT) inspection of this Drainage plate's root pass. This QAI performed the MT verification inspection of this weld root. See the attached MT report for details. There were no indications noted at this time.

- This QAI verified the acceptable fit-up of the closure plate to the tapped 'F' plate for the welding at WS-CP at the Northwest corner of Tower at the 151M elevation. The AB/F Quality Control (QC) Inspector Fred Michels was present and performed his inspection of the fit-up prior to verification by this QAI.

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This QAI witnessed the AB/F Quality Control (QC) Inspector Fred Michels perform the Magnetic Particle Testing (MPT) inspections of the West Tower elevator attachment lug removal areas for the following elevations: 50M, 53M, and 56.5M. This QAI performed the MT verification of these same removal areas. Linear indications were noted of the removal areas at elevations 50M and 56.5M. See the attached MT report for details.

Quality Control (QC) Inspector Salvador Merino performed the fit-up check of lifting rod closure plate prior to welding for location WB-SLLH-7. This QAI verified the proper fit-up and bevel preparation of this same lifting rod closure plate at WB-SLLH-7.

This QAI performed the Magnetic Particle Testing(MPT) verification inspections of lifting rod closure plate welds EB-SLLH-14, and EB-SLLH-15. There were no indications noted at this time. See the attached TL-6028 MT report for details.

This QAI witnessed the Magnetic Particle Testing (MPT) and inspection by AB/F Quality Control(QC) Inspector Salvador Merino of lifting lug removal 'pyramid' profile ground areas at the longitudinal shear plate L13W-W4-PP121.65 (South), and at L13W-PP122.65 (South). This QAI performed the MT verification and inspections of these same lifting lug removal areas. See the attached TL-6028 MT report for details. There were no indications noted at this time.

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

Reviewed By: Reyes, Danny

QA Reviewer