

**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-029543**Date Inspected:** 25-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).

This QAI observed welding of complete joint penetration of the butt joint of 4 inch diameter schedule 40 pipe to 90 degree elbow for location 3-4-PFP-PE. Welding was performed by Rick Kickvee #5319 of F.W. Spencer, utilizing E6010 electrodes for root pass and E7018 electrodes for fill and cap passes as per WPS #1-12-1. AB/F QC Fred Michels was present.

This QAI visually inspected completed welding of 2-1/2 inch diameter schedule 40 pipe branch connection weld-o-let for 1 inch diameter pipe, and socket weld to 1 inch diameter pipe for domestic water location 1-DWI-85-BE of Bikepath. AB/F QC Fred Michels previously performed his visual final inspection.

**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

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# WELDING INSPECTION REPORT

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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