

**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 #: 1.28r**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029586**Date Inspected:** 29-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).

At the start of the shift this QAI observed the following:

This QAI observed the fit-up and tackwelding of the baseplates (for cantilevered pipe support beams) to the sloped sides of the OBGs at the locations 13W-PP128(+2465)-F1 and 14W-PP128(+3065)-F1. This QAI also observed the fit-up and tacking of the W150x37 cantilevered beam stubs to these same baseplate locations. This QAI observed the fitup of the vertical pipe restraint C150x16 channel members to the top flanges of these same cantilevered pipe support beams at locations 13W-PP128(+2465)-F1 and 14W-PP128(+3065)-F1. The welder Rick Clayborn #2773 was performing the tackwelding utilizing E7018 electrodes as per WPS ABF-WPS-D15-F1200A. The AB/F Quality Control (QC) Inspector William Sherwood was present, monitoring the work in progress.

This QAI observed the welding in progress of the root pass of the end butt splice of 4 inch diameter compressed air line for Bikepath location 1-CA2-PP25.5(-1734)-BE. The welder, Rick Kickvee #5319, performed the welding of the root pass utilizing E6010 electrodes as per WPS 1-12-1. The AB/F Quality Control (QC) Inspector Fred

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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Michels was present, monitoring the WPS parameters of the welding in-progress.

This QAI witnessed the welding in progress of end-closure plate of Barrier Rail at location 1E-PP8-W5 by welder Earl Clayborn #5070 utilizing E7018 electrodes as per WPS-ABF-F1200A. This QAI also observed welding of end-closure plate of Barrier Rail at location 1E-PP8-E2 by welder Jose Torres #6235 utilizing E7018 electrodes as per ABF-WPS-D15-F1200A. The AB/F Quality Control (QC) Inspector Fred Michels was present, monitoring the WPS parameters of the welding in progress.

The fit-ups and welding being performed this day appeared to be progressing in a conforming manner with regards to the contract documents.

**Summary of Conversations:**

**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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