

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT**

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-029707
Date Inspected: 06-Jun-2013

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

OSM Arrival Time: 1100
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:	Piping welds	

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 witnessed the welding of piping joints by F.W.Spencer welder Barry Mullaney #6520 utilizing E6010 electrodes for root passes and E7018 electrodes for the fill and cap passes per WPS #1-12-1 for the following sizes and locations:

4" diameter pipe to pipe flange for 75/4/PP126.5/NW
4" diameter pipe to pipe flange for 74/4/PP126/NW;
4" diameter pipe to base of sockolet for 1/CA2/PP126/NW
2-1/2" diameter pipe to flange for 68/2.5/PP126.5/NW
2-1/2" diameter pipe to flange for 67/2.5/PP126/NW
2-1/2" diameter pipe to base of sockolet for 1/DWI/PP126/NW

The AB/F Quality Control (QC) Inspector Fred Michels was present, monitoring the WPS parameters of the welding in progress. All these welds appeared to fully comply with the contract documents.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

No significant conversations took place this day.

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 , who represents the Office of Structural Materials for your project.

Inspected By: Morris, Monty

Quality Assurance Inspector

Reviewed By: Reyes, Danny

QA Reviewer