

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 #: 99.28**WELDING INSPECTION REPORT**

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

Report No: WIR-029708
Date Inspected: 07-Jun-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:** Temporary lifting lugs at bottom of OBG at E**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 the root passes and E7018 electrodes for the fill and cap passes as per WPS #1-12-1. The following sizes and locations were completed:

2-1/2" diameter pipe to sockolet base for 1/DWI/PP124/NW
2-1/2" diameter pipe to sockolet base for 1/DWI/PP122/NW
4" diameter pipe to sockolet base for 1/CA2/PP126/NW
4" diameter pipe to sockolet base for 1/CA2/PP124/NW
4" diameter pipe to sockolet base for 1/CA2/PP122/NW.

This QAI observed the AB/F Quality Control (QC) Inspector Fred Michels performing WPS parameter monitoring of the welding in progress. All the above-mentioned piping welds appeared to fully conform to the requirements of the contract documents.

This QAI witnessed the Magnetic Particle Testing (MPT) inspections being performed by AB/F QC Fred Michels of the temporary lifting lugs fillet-welded to the underside of OBG at Shear Key S1 at the North, South, and East

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side perimeter of same. Eight (8) total lugs were MPT tested at this location; three (3) each at North and South face of perimeter, and two (2) centered at the East face of the perimeter. This QAI performed MPT verification inspections of these same locations of welds. No indications were noted at this time. See TL6028 Magnetic Particle report for details

This QAI witnessed MPT inspection by AB/F QC Fred Michels of indication excavation/removal area of stiffener-to-bottom plate weld at Crossbeam #8 interior PP52(-1690) at 3550mm north of partial height diaphragm. This QAI verified that the indication was completely removed to sound metal. The AB/F welder Richard Garcia #5892 then performed the preheat to 150F and repair welding to full crosssection with the existing adjacent weld metal. E7018 electrodes were utilized throughout, as per AB/F WPS F1200A and ABF-SUB-002845R00. AB/F QC Fred Michels was present and monitoring the WPS parameters of the welding that took place.



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
