

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-029709**Date Inspected:** 05-Jun-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 1100**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:** Eastbound OBG deck; 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 AB/F Quality Control (QC) Inspector Fred Michels performing Eastbound Skyway OBG deck surface inspection to locate and map any arc strikes and rejectable gouges thereof. The mapped areas exhibiting arc strikes were removed and blended into the surrounding surfaces by flap-wheel sanding. After the sanding removals, those areas were Magnetic Particle Test (MPT) inspected. This QAI witnessed the QC's performance of the MPT inspections as well as performing the QA MPT verification inspections of these same areas. No rejectable indications were noted this day. See the attached TL6028 Magnetic Particle Testing report for details. This QAI performed the visual verification inspections of welding of Bikepath 4" diameter piping butt splices after AB/F QC William Sherwood performed his visual inspections this day for the following locations: PP83, PP85, PP87, PP91, PP93, PP95, and PP97. All of these weld locations appeared to comply with the contract document requirements.

This QAI witnessed F.W. Spencer welder Barry Mullaney #6520 perform the welding of 4" diameter pipe to sockolet base for compressed air joint location 1/CA2/PP128/NW. Mr. Mullaney also performed the welding of 2-1/2" diameter pipe to flange for joint location 67/2.5/PP126/NW as well as 2-1/2" diameter pipe to sockolet base

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

for domestic water joint location 1/DWI/PP128/NW. All welding was performed as per F.W.Spencer WPS 1-12-1 utilizing E6010 electrodes for root pass and E7018 electrodes for fill and cap passes. AB/F QC Inspector Fred Michels was present, monitoring the WPS parameters of welding in process.



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
