

**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-029710**Date Inspected:** 08-Jun-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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:** Crossbeam CB8 temporary fillets; Crossbeam**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 preheat to 150F and welding performed and completed of the temporary intermittent fillet welds of 14mm Edge Plate to Bottom Flange Plate of Crossbeam #8 as per sheet DE2010BD of ABF-SUB-002845R00 "Crossbeam CB8 Damage Repair Plan". The welding was performed by AB/F welder Richard Garcia #5892 utilizing E7018 electrodes as per ABF WPS F1200A. The AB/F Quality Control (QC) Inspector Fred Michels was present and monitoring the WPS parameters of the welding in progress. All welds fully appeared to meet the requirements of the contract documents. This QAI observed the Magnetic Particle Testing (MPT) inspection of crossbeam floor stiffener weld repair at PP52(-1690) at 3550 north of partial height diaphragm as performed by AB/F QC Fred Michels. This QAI performed MPT verification inspection of this same weld repair. No indications were noted at this time. See TL6028 Magnetic Particle report for details.

This QAI observed the AB/F QC MPT inspections being performed of ground removal areas of counterweight attachments at North side of Westbound OBG for the following locations: PP47, PP49, PP51, PP53. QC Salvatore Merino was performing the MPT inspections at these locations. This QAI performed the MPT verification inspections of these same areas. No indications were noted at this time. See TL6028 Magnetic Particle report for details.

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## WELDING INSPECTION REPORT

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The fit-ups, preheat to 150F, and welding in progress was observed by this QAI of the plates, angles, and channels to the top deck of Crossbeam CB19 for the subsequent attachment of pipe support assemblies. The welding was being performed by AB/F welders as follows: Richard Garcia #5892, Guo Wu Chen #1556, Earl Clayborn #5070, and Wai Kit Lai #2953. The electrodes being utilized were E7018 as per ABF WPS F1200A. The AB/F QC Fred Michels was present and monitoring the WPS parameters of the welding being performed.



### 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.

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**Inspected By:** Morris, Monty

Quality Assurance Inspector

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**Reviewed By:** Reyes, Danny

QA Reviewer