

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-029729**Date Inspected:** 10-Jun-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:** Eastbound OBG deck; Bikepath gate landing;**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 Magnetic Particle Testing (MPT) inspections performed by the AB/F Quality Control (QC) Inspector Salvador Merino of 'ground-flush' temporary attachment removal areas (5x total, each location) of Westbound OBG counterweights at the following locations: PP45, PP43, PP41, PP39, PP37. This QAI also performed MPT verification inspections of these same locations. There were no indications noted at this time. See the TL-6028 Magnetic Particle Testing report for details.

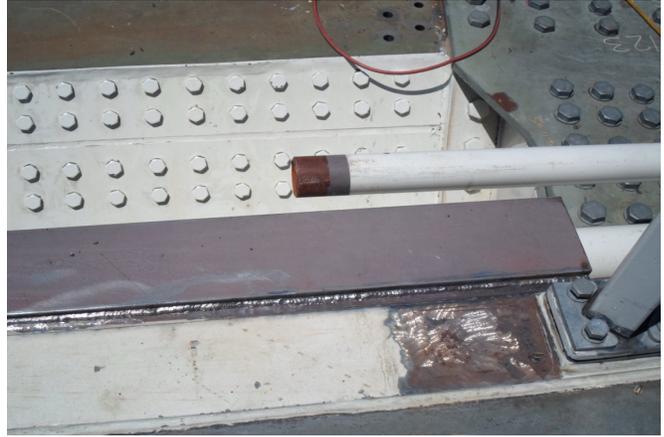
The temporary intermittent fillet welds (23 total) of bottom plate of Crossbeam CB8 to 14mm edge plate along PP52 (-326) as per detail section C-C of AB/F Submittal 2845 were witnessed by this QAI being MPT inspected by AB/F QC Fred Michels. This QAI performed MPT verification inspection of these same locations. There were no indications noted at this time. See the TL-6028 Magnetic Particle Testing report for details.

Fillet welding was in progress and not completed this day of Gate ledger angle to Bikepath frame edge at location PP123. The welding was being performed by AB/F welder Jose Torres #6235 utilizing E7018 electrodes as per the AB/F WPS F1200A. The AB/F QC William Sherwood was present and monitoring the WPS parameters of the

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welding in progress.



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