

**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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029731**Date Inspected:** 12-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 cable shroud; Crossbeam CB19**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 fillet 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 visually inspected the completed welds (4 total) of baseplates for subsequent mounting of 4" diameter piping supports to Westbound cable shroud at the following locations: PP118.5, PP118 (+120), PP119 (-420), PP119.5 (-600). All of these welds appeared to meet the requirements of the contract documents.

This QAI performed the Visual and Magnetic Particle Testing (MPT) inspections of fillet welds of attachments to top of Crossbeam CB19 for subsequent mounting of piping supports at the following locations: PP126(-2700)/W5(-282), PP126(-1250)/W5(-5248), PP126(+2827)/W5(-3005), PP126(+3796)/W5(-752). There were no indications noted at this time. See attached TL6028 Magnetic Particle Testing report for details. All welds at these locations appear to meet the requirements of the contract documents.

The welding of pipe support W-Tees (2 total) and Posts (2 total) to Crossbeam CB19 Deck top attachment members was performed this day by F.W. Spencer welder Barry Mullaney #6520 utilizing E7018 electrodes as per WPS #FWS Fillets Murex SFOBB Rev.1. The locations performed are as follows: PP126(-2700)/W5(-282), PP126(-1586)/W5(-5248), PP126(-600)/E5(-2902), and PP126(-600)/E5(-3152).

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---



## Summary of Conversations:

There were general conversations with the contractor's Quality Control personnel at the start of the shift regarding the location of welding and inspection personnel scheduled for this shift.

## 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 SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Morris, Monty	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes, Danny	QA Reviewer

---