

**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-029732  
**Date Inspected:** 13-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

<b>CWI Name:</b>	See below	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Crossbeam CB19; Bikepath piping	

**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 observed the welding of opposing 2-1/2" diameter 90 degree elbows (2 total) spliced to 2-1/2" diameter piping at pipe offset area between the E2 Barrier rail exterior and Bikepath at location PP15 near 1/DWI/14.5/BE. The welding was performed by F.W.Spencer welder Tim Esquivel #8348 utilizing E6010 electrodes for root passes and E7018 electrodes for fill and cap passes as per WPS #1-12-1. AB/F Quality Control (QC) Inspector Fred Michels was present and monitoring the WPS parameters during the in-process welding. These piping splice welds appear to comply with requirements of the contract documents.

This QAI performed the Magnetic Particle Testing (MPT) verification inspections of the fillet welds of attachment members (for subsequent mounting of piping supports) to the top deck of Crossbeam CB19.

The following fillet weld locations were MPT inspected: PP126 (+3262) / E5 (+349), PP125 (-1580) / W5 (-282), and PP126 (-2700) / E5 (+222). There were no indications noted at this time. See the TL6028 Magnetic Particle Testing report for details.

Fit-ups were performed and welding is in progress of pipe supports to Crossbeam CB19 top deck attachment members for the following locations: PP126 (-2700) / W5 (-282) and PP125 (-1580) / W5 (-282).

---

---

# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

The welding was performed by F.W. Spencer welder Barry Mullaney #6520 utilizing E7018 electrodes per the approved WPS #FWS Fillets Murex SFOBB. The AB/F QC Fred Michels was present and monitoring the WPS parameters of the welding in progress. The welds in progress exhibit a high quality appearance.



## 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.

---

**Inspected By:** Morris, Monty

Quality Assurance Inspector

---

**Reviewed By:** Reyes, Danny

QA Reviewer