

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-029733**Date Inspected:** 14-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 top deck surface; 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 observed and identified arc-strike and gouged areas of the Deck top surface of Eastbound OBG together with AB/F Quality Control (QC) inspector William Sherwood. The arc-strike areas were 'flap-wheel' sanded down to sound metal and inspected by Magnetic Particle Testing (MPT) by QC for the following locations: PP40(+1470)/E4(+3630), PP41(-230)/E4(+6700), PP30(+470)/E5(-2560), PP70(+1500)/E5(-3700). The gouged areas were 'flap-wheel' sanded to blend in with the surrounding metal surface. This QAI performed the MPT verification inspections of the arc-strike removal areas. There were no indications noted at this time. See the TL6028 Magnetic Particle Testing report for details. All of the reworked arc-strike and gouge areas were brought into conformance with the requirements of the contract documents.

At Crossbeam CB19 welding was observed by this QAI of pipe supports to deck top attachments at the following locations: PP126(+1130)/W5(-6010), PP126(+1836)/W5(-6510), PP126(-1250)/W5(-752), and PP126(+1027)/W5(-3005). The welding was performed by F.W.Spencer welder Barry Mullaney #6520 utilizing E7018 electrodes as per WPS #FWS Fillets Murex SFOBB Rev.1. Quality Control (QC) inspector Fred Michels was present, monitoring the WPS parameters of the welding in process. All of these above-mentioned welds

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appeared to be in compliance with the requirements of the contract documents.



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