

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029748**Date Inspected:** 17-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:** Bikepath piping; Barrier Rail piping supports**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 witnessed the welding of the single 19mm thick x 102mm wide plates to Barrier Rails per drawing # SK3260-04R1 at the following locations: W2/PP128.7(+880), W5/PP128.3(+2440), and E5/PP128.3(+3760). It was noted that AB/F has used the drawing's "Note #4" option of using two 19mm plates stacked and welded together at each location in lieu of single 38mm plates. The secondary plates to be stacked and welded are not yet fit-up in place. AB/F welder Rick Clayborn #2773 performed the welding utilizing E7018 electrodes as per the approved WPS #F1200A. The AB/F Quality Control (QC) Inspector William Sherwood was present and monitoring the WPS parameters of the welding in progress. The welds completed appear to meet the requirements of the contract documents.

Welding was observed by this QAI of full penetration butt splices of the 4" diameter piping Compressed Air at the following Bikepath locations: 67/4/PP103/BE, 68/4/PP105/BE, 70/4/PP109/BE. The welding was being performed by F.W.Spencer welder Tim Esquivel #8348 utilizing E6010 electrodes for the root passes and E7018 electrodes for the fill and cap passes as per the approved WPS #1-12-1. AB/F Quality Control (QC) inspector Fred Michels was present and monitoring the WPS parameters of the welding in progress. All of the welds appeared to meet the requirements of the contract documents.

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The fit-up was performed and the welding is in progress of the galvanized reinforced W-Tee assembly to the Westbound Barrier rail at W5/PP126(+350) for Pipe Support PS-7 as per Detail 25D11A and of Sheet Detail 8/D6a. The welding is being performed by F.W.Spencer welder Barry Mullaney #6520 utilizing E7018 electrodes as per WPS# FWS Fillets Murex SFOBB Rev1. AB/F QC William Sherwood was present and monitoring the WPS parameters of the welding in progress. This welding is in progress and is not yet completed. The welding so far performed appears to comply 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