

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Vallejo, CA 94592-1133
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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-029776
Date Inspected: 11-Jun-2013

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor:

OSM Arrival Time: 730
OSM Departure Time: 1600
Location: Vallejo, CA

CWI Name:	Wayne Van Dewark	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:	E2 Shear Key Anchorage	

Summary of Items Observed:

Summary of Items Observed: Caltrans Quality Assurance Inspector Simion Ramirez (QA Inspector) arrived at XKT facility, in response to an Inspection Request (Caltrans form TL-38). QA Inspector met with Quality Control Contact (QCC) noted above to witness fabrication of stress relieving / machining fixture and Material Identification sample selection. Production work was selected randomly by QA Inspector for QA Visual Testing (VT). Inspections performed were in accordance with (IAW) Section 55 Steel Structures of the Standard Specifications and the project Special Provisions.

Stress Relieving / Machining Fixture Components:

Pieces cut from 3" flat plate to fabricate fixtures that will hold the saddle pieces during fabrication. Cut pieces were fit-up and tack welded. Welding is in process per Drawing No. 7861-SK1. QA Inspector observed the following QC operations.

- QC performed fit-up and alignment verification of assembled components utilizing a square and straight edge.
- Preheat was performed by rosebud touch and verified with temperature stick.
- Welding was performed by approved welders. Fillet welds installed are 3/8" typical.

Fabrication and welding remains in progress.

Summary of Conversations:

Conversation related to the observations noted above.

WELDING INSPECTION REPORT

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

Inspected By: Ramirez, Simion

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer