

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 16.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029777**Date Inspected:** 24-Jun-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** XKT/NESCO, Vallejo, Ca.**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:** Crossbeam Retro-Fit Angle**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 Saddle and Crossbeam Retrofit Angle. Production work was selected randomly by QA Inspector for QA Visual Testing (VT). Inspections performed were in accordance (IAW) with Section 55 Steel Structures of the Standard Specifications and the project Special Provisions.

Crossbeam Retrofit Angle:

XKT personnel continued welding of piece mark M1, corner joint. QC Inspector verified electrical welding parameters at the start of shift and randomly until the end of shift. After QC inspection of back gouged weld joint, the installation of weld passes continued. Welding of corner joint was completed by end of shift. Caltrans QA Inspector random observation of quality control functions are noted below.

- Preheat was performed by rosebud torch and verified with temperature stick (100°).
- Welding was performed by approved welder (Alberto Garcia).
- Electrode utilized, Lincoln E71T-1, (.062" diameter).
- Stringer weld passes were installed in flat and horizontal positions.
- Weld Procedure TC-U4b for corner joint (CJP) was available for reference at this weld station.
- Weld passes were deslagged by chipping and wire brush.
- QC Inspector VT of in-process welding and final VT of completed weld, found weld profiles acceptable with no apparent surface defects.

Please be advised that the contractor is proceeding with machining, fabrication and welding prior to receiving the

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Engineers written approval of drawings associated with this work. All material and work documented in this report are subject to final review of conformance upon the issuance of written approval of the drawings as direction provided by the SMR and Structures Construction.

Summary of Conversations:

Conversation related to completed welding and schedule for UT inspection.

Weld reinforcing and profile IAW spec.

Piece M1 alignment maintained with bracing.



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
