

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 #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029857**Date Inspected:** 27-Jun-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 930**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1800**Contractor:** XKT/Nesco**Location:** XKT Engineering, Vallejo**CWI Name:** Wayne Van de Wark**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 Retrofit Side Plates**Summary of Items Observed:**

Caltrans Quality Assurance Inspector (QAI) Monty Morris arrived at XKT facility for the purpose of witnessing fabrications of S1 & S2 Shear Key retrofit. The QC Manager above-mentioned was contacted by this QAI regarding E2 Shear Key fabrications. Inspections performed were in accordance with Section 55 Steel Structures of the Standard Specifications and the project Special Provisions.

This QA inspector observed the fillet welding of the plate stiffeners to the Side Plate identified as item number 103A. The welding was performed by the welder Nestor Rojas, ID number AF, utilizing the E71T-1 1/16" diameter Lincoln Electric UltraCore FCAW-G electrodes as per the Welding Procedure Specification (WPS) identified as XKTD15-00. For fabrication purposes the drawing identified as 7861-103, Revision 1 was referenced.

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Summary of Conversations:

There were general conversations with Quality Control personnel at the start of the shift regarding the location of the work and inspection personnel scheduled for this shift.

Also discussed with QA inspector Simon Ramirez, prior to his departure, the project turn-over to this QAI.

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: Foerder, Mike

QA Reviewer