

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-029858**Date Inspected:** 28-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:** Shear-Key repair retrofit Side Plate**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 was contacted by this QA regarding E2 Shear Key fabrications. The inspections were performed in accordance with the Standard Specifications and the project Special Provisions.

This QA inspector observed the fillet welding of the stiffener plates to the inner face of the shear key side plate identified as item # 102A-1. The welding was performed by Nestor Rojas, ID AF, using the E71T-1 FCAW-G 1/16" diameter Lincoln UltraCore electrodes as per the Welding Procedure Specification (WPS) identified as XKTD15-00. For fabrication purposes the drawing identified as 7861-102, Revision 1 was referenced.

This QA inspector also observed the welding of the 3/8" Nelson Shear Studs to the 8" diameter schedule 40 studded sleeves identified as 100A-100F. This QAI witnessed the successful pre-production testing of studs on to a sample pipe. The fabrication and the welding was performed in reference to the shop drawing identified as 7861-100, Revision 1

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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.

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
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Reviewed By:	Foerder, Mike	QA Reviewer
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