

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-029868
Date Inspected: 23-Jul-2013

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

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Jobsite

CWI Name: Salvador Merino
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** Water & Compressed-Air Piping welds**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 Water & Compressed Air piping 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 2 total tie-in splices of 4" diameter Compressed-Air piping at the Bikepath location 92/4/123/BE. The welding was performed by F.W.Spencer welder, Tim Esquivel, utilizing the E6010 electrodes for the root passes and the E7018 electrodes for the fill and cap passes as per the approved WPS #FW-1-2-1. The AB/F Quality Control (QC) Inspector Salvador Merino was present, monitoring the WPS parameters of the welding in-process. The welds appeared to meet the requirements of the contract documents.

Welding was witnessed by this QAI as performed by F.W.Spencer welder Salvador Gomez of 4" diameter Compressed-Air piping. Two welds were performed. One was a pipe-to-flange weld for location 58/4/126.5/SW. The other was a butt-splice for location 59/4/129/SW. Both welds were performed utilizing E6010 electrodes for the root passes and E7018 electrodes for the fill and cap passes as per the approved WPS #FW-1-2-1. AB/F QC inspector Salvador Merino was present monitoring the WPS parameters of the welding in-process. Both the welds appear to meet the requirements of the contract documents.

This QAI witnessed the welding by F.W.Spencer welder Barry Mullaney of the following piping joints:

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4" diameter butt-splice of Compressed-Air line for location 57/4/129/NE,
2" diameter sockolet base-to-4" diameter Compressed-Air line for location 1/CA2/118/NW,
1/2" diameter sockolet base-to-4" diameter Compressed-Air line for location 1/DCA.50/118/NW,
1/2" diameter sockolet-to-1/2" diameter pipe stub for location 2/DCA.50/118/NW,
1/2" diameter pipe-to-inlet side of 90 degree elbow for location 3/DCA.50/118/NW,
1/2" diameter pipe-to-outlet side of 90 degree elbow for location 4/DCA.50/118/NW.

The full-penetration welds (of butt-splice & sock-o-let base) were performed utilizing the E6010 electrodes for the root passes the E7018 electrodes for the fill and cap passes as per the approved WPS #FW1-2-1. The fillet welds were performed utilizing E7018 electrodes as per the approved WPS #FW-Murex-Fillet. The AB/F QC inspector Salvador Merino was present monitoring of the WPS parameters of the welding in-process. All the above completed welds appear to meet the requirements of the contract documents. One butt splice weld of 2-1/2" diameter Water line is in progress for location 57/2.5/128/NE, but not completed.



Summary of Conversations:

No significant conversations took place this day.

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: Morris, Monty

Quality Assurance Inspector

Reviewed By: Reyes, Danny

QA Reviewer