

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 #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029925**Date Inspected:** 12-Aug-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge Manufacturing**Location:** Reedsport, OR

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|------------------------------------|------------|----|-----|
| CWI Name: | Mike Inman | | |
| 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:** Tower Skirt Ladder @ 3M**Summary of Items Observed:**

This QAI randomly observed ABM welding personnel Mike Hebert performing fit up and tack welding with Flux Core Arc Welding (FCAW) on Tower Skirt Ladder Cage at 3M. Galvanized ladder was shipped from job site and is being fitted with a safety cage. Rolled hoops were laid out on galvanized ladder, galvanizing was removed from ladder where welding will be performed, then hoops were tack welded in place and flat bar was then fit up to hoops and tack welded. Welding performed using ESAB Dual Shield II 711X electrode. The weld joint was identified as a fillet weld, ABM-FCAW-2011-09, the parameters were checked by ABM QC and verified by this QA Inspector. They appeared to be within the specified Welding Procedure Specification's (WPS).



WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

No relevant conversations.

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.

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| Inspected By: | Combs,Dennis | Quality Assurance Inspector |
| Reviewed By: | Riley,Ken | QA Reviewer |
