

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 #: 01.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029964**Date Inspected:** 26-Aug-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Jesus Cayabyab**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:** See Below**Summary of Items Observed:**

RWR201308-003

ESW E-043, Location "Q" Face A

The QAI periodically observed ABF welding personnel Donald Plum utilizing the Shielded Metal Arc Welding (SMAW) process in the vertical (3G) position with Atom Arc E7018-1 H4R, 5/32" diameter electrode to weld filler passes for weld repair. The welding is taking place on the exterior (west) side at joint Q, weld #E-043 on Face A side for a repair designated as 201308-004. Excavation dimensions are noted as Y=3800mm-4300mm, Length=500mm, Width=80mm, Depth=68mm. The QAI observed the interpass temperature was maintained at approximately 395 degrees Fahrenheit with electric heating coil blankets through a heat induction system and a rose bud torch. The QAI verified interpass temperature with a thermal heat gun. As welding continued the QAI periodically verified welding parameters at approximately 140 amperes per ABF-WPS-D1.5-ESW-80-100TR. The welder was also observed using proper interpass cleaning methods with a slag hammer and a wire brush. QC Inspector Jesus Cayabyab was monitoring the progress of this repair on this date.

The welding & workmanship observed on this date appeared to be in general compliance with the contract specifications.

Summary of Conversations:

General conversations with ABF/JV QC NDT personnel relevant to work performed during 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 Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for

WELDING INSPECTION REPORT

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your project.

Inspected By:	Leach,Ed	Quality Assurance Inspector
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Reviewed By:	Reyes,Danny	QA Reviewer
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