

**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:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012310**Date Inspected:** 26-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernie Docena**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:** Segments 1E and 2E**Summary of Items Observed:**

At the start of the shift the Quality Assurance Inspector Gary Richmond traveled to the project site and observed the following work performed by American Bridge/Fluor (ABF) personnel at the 1E/2E Bottom Plate weld pllice:

Item 1: Field weld splice bottom plate.

1. The (QA) inspector witnessed the post weld heat treatment on segments 1E-2E, D1 & D2 segments D5-6 and 14. The heat was maintained at 149°C for three hours. ABF (QC) Bernie Docena was also present during the observations.

The welding parameters and preheat temperatures were verified and noted utilizing a Fluke 337 clamp meter for the electrical welding parameters and a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. The consumables utilized during the welding appeared to be an ESAB manufactured product identified as ESAB Dual Shield 70 Ultra Plus with an electrode size of 1.4mm which appeared to comply with the AWS Electrode Specification AWS A5.20 and the AWS Classification E71T-1M. The QC inspector's appeared to perform the visual examinations, monitoring and verification of the welding as per the contract documents. The welding and QC inspection performed on this shift was not completed and appeared to be in general compliance with the contract documents. The QA Inspector randomly verified the welding parameters and surface temperatures utilizing a Fluke 337 Clamp Meter.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No relevant conversations noted at this time.

## 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 Mohammed Fatemi (916)-227-5298, who represents the Office of Structural Materials for your project.

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**Inspected By:** Richmond, Gary

Quality Assurance Inspector

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**Reviewed By:** Levell, Bill

QA Reviewer