

**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-012311**Date Inspected:** 26-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

<b>CWI Name:</b>	Bernie Docena, Tom Pasqualone	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No N/A
		<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Orthotropic Box Girders (OBG)	

**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) OBG field splice welding
- 2) OBG field splice fit-up

1) The QAI observed ABF personnel making complete joint penetration (CJP) welds inside of plate D at OBG Lifts 1E/2E field splice. The QAI noted that the Quality Control (QC) Inspector Bernie Docena is monitoring the welding at this location. The QAI noted that gas shielded flux cored arc welding (FCAW-G) with 1/16" diameter E71T-1M electrode and Ar/CO2 shielding gas with Welding Procedure Specification (WPS) ABF-WPS-D15-3040B-1. The QAI observed that Jordan Hazelaar, ID 2135, and Jeremy Dolman, ID 5042, are making the FCAW-G CJP welds. The QC Inspector informed the QAI that all welding was being performed to the contract requirements and there were no issues to note. The QAI made random observations of welding parameters, preheat and interpass temperatures and noted that they appeared to be within the WPS and contract requirements. During the work shift, the QAI also made random observations of the welds beads in the CJP. The QAI noted that the workmanship appeared to be generally conforming to the contract requirements. See the attached photo. This work was in progress at the end of the QAI's shift. The QAI Danny Reyes arrived and assumed the QAI duties.

- 2) The QAI made observations of the fit-up of backing bar and temporary attachments inside (bottom) of deck

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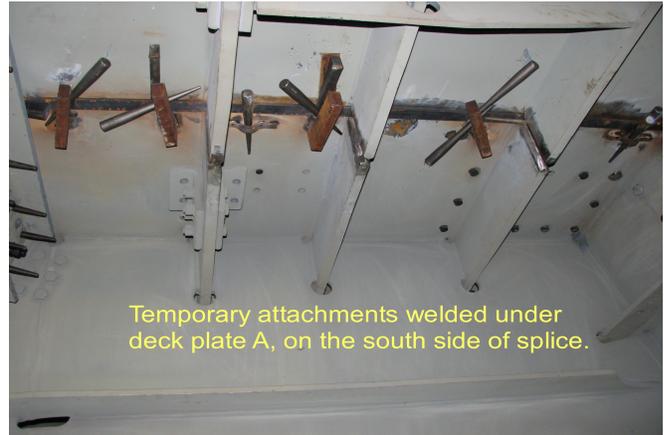
# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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plate A at OBG Lifts 1E/2E field splice. The QAI noted that temporary attachments have been welded under the deck plate and shims / pins are being used to hold the backing bar across the CJP weld. See the attached photo. The QAI spoke with the QC Inspector Tom Pasqualone and the QAI was informed that the temporary welds / attachments will be removed at a later time. The QAI was also informed that there will be additional temporary welds / attachments put onto the North side of the splice when that area gets aligned. The QAI noted that no welding performed during this shift.



### Summary of Conversations:

The QAI relayed the observations of OBG welding to the QAIs Bill Levell, Rick Bettencourt and Danny Reyes. There were general discussions of the work schedule and the status of the OBG lifts 1E/2E field splice welding. There were no other notable observations or conversations 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 Mohammad Fatemi, (916)813-3677, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Croff, Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

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