

**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-012370**Date Inspected:** 18-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernard 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:** Orthotropic Box Girders (OBG)**Summary of Items Observed:**

Quality Assurance inspector Michael Foerder was at the American Bridge/Flour (ABF) job site lay down yard at Pier 7 in Oakland, California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. Orthotropic Box Girder (OBG) Lifts 4E erection preparation
2. Orthotropic Box Girder (OBG) Lifts 1W erection preparation
3. Orthotropic Box Girder (OBG) Lifts 4W erection preparation
4. Contract Files and Shop Drawings

**Item 1 Lift 4 East**

The QA inspector noted the contractor had completed the placement of the suspender bracket at Panel Point (PP) 28 on the South side (Bike Path side) of the OBG which was still in process the previous day. The previous day the QA inspector noted a gap between the faying surfaces measuring 2mm prior to the end of the shift. The QA inspector reviewed the gap between the faying surfaces of the deck plate and the suspender bracket and noted no significant change had occurred.

The QA inspector periodically observed ABF personnel performing the removal of the stiffener plate from the top of the "T" stiffeners utilizing a grinder, placing shims under the floor beams and placing an angle plate clamped to the top of the "T" stiffeners at each PP (24-28) along lines E3 and E4. These shim plates are being added in order to stiffen the area for jacking purposes in the field discussed per Submittal 1459. See digital photo included in the body of this report for clarification. The QA inspector reviewed several areas in which the welds were removed by

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the contractor and noted the contractor is grinding the remaining weld metal flush with the top of the “T” stiffener in a workman like manor. The work progressed throughout the shift, was completed on this date and appeared to be in general conformance with the contract documents.

## Item 2 Lift 1 West

The QA inspector noted and periodically observed ABF personnel placing the suspender bracket at PP 10 for the North side (counter weight side) of the OBG. ABF personnel were utilizing various erection aids in order to place and align the bracket and inserted shims at the side plate. The QA inspector reviewed the fit-up between the deck plate and bracket faying surfaces and noted a 1mm gap at this time. A digital photo is included in the body of this report for clarification.

## Item 3 Lift 4 West

The contractor is in the process of laying out the access holes in the deck plate on the North and South side of the OBG. The QA inspector noted and periodically observed ABF personnel performing the grinding/buffing of the bevel edge preparation for the transverse field splice location for this lift. The QA inspector noted ABF personnel are in the process of periodically placing the components for scaffolding, welding, lighting, walkways, temporary bolts and other miscellaneous items in preparation of mobilizing lift 4 West to the erection site.

## Item 4 Contract Files Drawing review

The QA inspector spent a portion of the shift updating the contract files in regards to the contractor field splice plan, submittals and performing shop drawing reviews for this project.



## Summary of Conversations:

The QA inspector spoke with WQCM Jim Bowers in regards to the submittal and approval of new QC inspector Bonafacio Daquinag. Mr. Bowers relayed he had received Mr. Daquinag’s certification packet from Smith-Emery and would be submitting it together with additional items in a WQCP addendum. Mr. Bowers also relayed Mr. Daquinag is not independently performing any inspection duties on the project and is in a training role at this time and works continuously with an approved QC inspector.

## 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> | Foerder, Mike | Quality Assurance Inspector |
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| <b>Reviewed By:</b> | Levell, Bill | QA Reviewer |
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