

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-012460**Date Inspected:** 01-Mar-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:** Bonafacio Daquinag**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 (QA) 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. Lift 2 West
2. Lift 3 West Erection Preparation

**Lift 2 West**

The QA inspector was informed by the Welding Quality Control Manager (WQCM) Jim Bowers the contractor is scheduled to perform the removal of the damaged area on the full height vertical shear plate at the W3 line of Lift 2 West. The QA inspector periodically observed ABF welding personnel John Rosas (ID-1480) and a helper lay-out the removal area dimensions which were approximately 650mm high and 530mm wide. This work is proceeding under repair submittal ABF-SUB-001503 R0 which has been previously approved by structure construction. The welder relayed he was unable to place automated equipment in the space allowed and informed the QA inspector he would be using a guide in order to perform the cutting operation of the vertical and top horizontal cut and air carbon arc gouging for the removal of the weld along the bottom plate. Prior to the removal operation the QC inspector Bonafacio Daquinag was observed performing magnetic particle testing of the existing weld joining the shear plate to the bottom plate with no rejectable indications noted at the time of review. The QA inspector observed the cutting operation and periodically observed the gouging operation which was performed in a workman like manner. It was noted QC inspector Bonafacio Daquinag was present in order to document and observe the in process work. Later in the shift the QA inspector reviewed the completed work at this location and

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it appeared to be in general conformance with the contract documents. See digital photo included in the body of this report for general information or clarification.

The QA inspector periodically observed ABF personnel performing grinding/buffing of the weld and hold back areas of the longitudinal stiffeners (open ribs) along the bottom and side plates of lift 2W at Panel Point 13 (PP13). This work progressed throughout the shift, was not completed and appeared to be progressing in general conformance with the contract documents. See digital photo in the body of this report for general review.

## Lift 3 West Erection Preparation

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 this lift to the erection site. This work progressed periodically throughout the shift.



## Summary of Conversations:

The QA inspector spoke with QCM Jim Bowers in regards to the following items:

1. QA inspector Rick Bettencourt had inquired from the QA inspector the approval status of ABF welding personnel Sontao Huang, Chun Fai Tsui and Huang Jin Quan. Mr. Bowers relayed these welders were previously tested and had passed the requirements but the approval was still in process. In the absence of QA lead inspector Bill Levell the QA inspector spoke with QA lead Robert Mertz in which Mr. Mertz relayed he reviewed the welder qualifications from an advanced copy of the submittal and verbal approval of these individuals was granted. This information was relayed to QA inspector Rick Bettencourt verbally on this date.
2. The QA inspector inquired of the approval status of QC inspector Bonafacio Daquinag and it was relayed Mr. Daquinag's certifications were previously submitted and Mr. Mertz confirmed the verbal approval of this item based on an advanced copy of the WQCP addendum with formal approval to follow.

## 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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**Inspected By:** Foerder, Mike

Quality Assurance Inspector

**Reviewed By:** Levell, Bill

QA Reviewer