

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-012748**Date Inspected:** 19-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>	Listed below.		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Component:</b>	Orthotropic Box Girders (OBG)		

**Bridge No:** 34-0006**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 L1E/L2E - field splice back gouging
- 2) OBG L2E/L3E - deck plate A clean-up.

1) The QAI observed ABF personnel using plasma arc torches and grinders to remove the backing bars from the bottom of OBG L1E/L2E plate D field splice. The QAI observed that the plasma arc torch is set onto a semi-automatic track and is in the process of cutting through / gouging off the backing bars. This work was in progress at the end of the work shift. The QAI also observed ABF personnel grinding the inside of edge plate B field splice. The QAI noted that welding is completed and the work is being done before final inspection of the weld.

2) The QAI observed ABF personnel using grinders to remove the weld reinforcement of L2E/L3E deck plate A field splice. The QAI noted that welding is completed and the work is being done before the final inspection of the weld. The QAI also noted that ABF personnel are re-positioning welding equipment, induction heaters and generally preparing for welding of other field splices. The QAI did not make any observations of welding in progress during this shift.

The QAI reviewed contract related documents including the submitted and approved Welding Quality Control

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Plan (WQCP) and approved revisions to the WQCP and Requests for Information (RFIs) for the remainder of the work shift.

### **Summary of Conversations:**

As noted above, the QAI had general conversations with the Quality Control (QC) Inspectors Steven McConnell, Jesus Cayabyab, and ABF personnel regarding the work in progress. The QAI was informed that final inspection of the completed welds will not be performed during this shift. The QAI relayed the status of work to the QAI Bill Levell. The QAI also generated a shift turn-over report with this information. 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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