

**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-012817**Date Inspected:** 29-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

<b>CWI Name:</b>	Bernard Docena, Jesse Cayabayab			<b>CWI Presentation:</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>	SAS OBG 2E/3E, 3E/4E-A		

**Summary of Items Observed:**

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above. The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified as 2E/3E-A, 3E/4E-A and the following observations were made:

**2E/3E-A5**

Upon the arrival of the QA Inspector, the Smith Emery (SE) Quality Control (QC) Inspector Tom Pasqualone was commencing the ultrasonic testing (UT) of the final three weld repairs completed on Saturday 3/27/10. The QA Inspector randomly observed the QC Inspector performed UT and noted no rejectable indications were located at the time of the testing. The QC Inspector informed the QA Inspector the final repairs were acceptable. The QA Inspector performed UT at random locations where the repairs were performed. After the QA UT verification was completed, the QA Inspector noted no rejectable indications were located at the time of the testing (see TL-6027 for additional information).

**3E/4E-A**

Upon the arrival of the QA Inspector it was observed the above identified complete joint penetration (CJP) groove weld had been completed on Saturday 3/27/10. The QA Inspector noted the weld reinforcement had been ground flush in areas identified as A2 and A3. The QA Inspector randomly observed the SE QC Inspectors had previously performed magnetic particle testing (MT) of the above identified areas and accepted them with no rejectable indications. The QA Inspector performed MT verifications of the areas identified as A2 and A3 and noted no rejectable indications located at the time of the testing (see TL-6028 for additional information)

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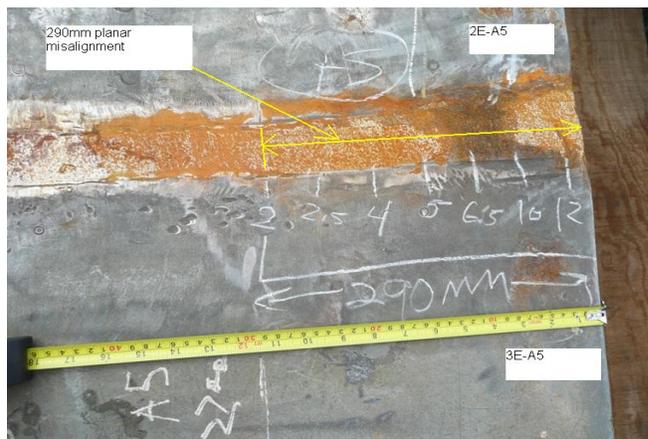
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The QA Inspector noted no production welding was performed on the QA Inspectors shift. The QA Inspector spent the remainder of the shift performing dimensional measurements of the planar misalignment of transverse filed splices 1, 2 and 3 top deck plate "A". The QA Inspector noted the planar misalignment was recorded, mapped out and submitted for review. See below pictures for examples of the planar misalignment at 2E/3E-A and 3E/4E-A.



### Summary of Conversations:

The QA Inspector was informed by the QA Task Lead Bill Levell of a conversation with the ABF Welding Quality Control Manager (WQCM) Jim Bowers. Mr. Bowers informed Mr. Levell that no weld joint has been accepted up to today's date. Mr. Bowers went on to inform Mr. Levell that all completed weld joints are still in process and ABF will likely go back and perform additional grinding, welding and or non destructive testing (NDT).

### 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:** Bettencourt, Rick

Quality Assurance Inspector

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**Reviewed By:** Levell, Bill

QA Reviewer