

**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-013561**Date Inspected:** 21-Apr-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**CWI Name:** See Below**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 at Yerba Buena Island in 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. OBG Field Splice 2E/3E Face C1 and C2 (inside)
2. OBG Field Splice 3E/4E Face A/B (Inside)
3. OBG Field Splice 3E/4E Face C2 (Inside)

**Field Splice 2E/3E Face C1 and C2 (first side-inside)**

The QA inspector periodically observed QC inspectors Jessie Cayabyab and Bonafacio Daquinag performing ultrasonic testing (UT) on this date for this location. It was noted Mr. Daquinag was assisting Mr. Cayabyab and not performing the UT. The QC inspector was noted to be utilizing a 70 degree transducer and wedge combination for shear wave examination. This examination was in addition to the one performed the previous day from the outside of the OBG. During a brief discussion with the QC inspector, it was relayed to the QA inspector the contractor requested the QC personnel to identify the rejectable indications from the inside of the OBG in addition to the outside in order to facilitate the repair process from either side. This appears to be for access issues and the required depth of excavations for the repairs. A digital photo is included in the body of this report for general information.

**Field Splice 3E/4E Face A/B (Inside)**

The QA inspector noted ABF welding personnel James Zhen performing shielded metal arc welding (SMAW) and

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grinding/blending operations at the deck plate/edge plate transition in which additional weld metal is being added for transitioning smoothly at the interface. This work is progressing in response to request for information (RFI) designated 2097 Rev 0. QC inspector Tom Pascaulone was noted to be present in order to monitor the progress and adherence to the contract documents and the established WPS. The work progressed throughout the balance of the QA inspector's shift and appeared to be progressing in general conformance with the contract documents.

### Field Splice 3E/4E Face C2 (Inside)

The QA inspector noted ABF welding personnel Song Tao Huang performing shielded metal arc welding (SMAW) and grinding/blending operations in order to fill minor areas identified by the QC inspector by welding due to insufficient fill and/or undercutting. QC inspector Tom Pascaulone was noted to be present in order to monitor the progress and adherence to the contract documents and the established WPS. The work progressed throughout the balance of the QA inspector's shift, was completed and appeared to be in general conformance with the contract documents.



### Summary of Conversations:

As noted above.

### 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
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

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