

**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-013940**Date Inspected:** 07-May-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:** Listed 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**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 Lifts 3E/4E - plate B field splice repair welding
- 2) OBG Lifts 3E/4E - plate E field splice inspection
- 3) OBG Lifts 5W - prep at Pier 7

1) The QAI observed ABF personnel welding repairs on plate B at OBG lifts 3E/4E field splice. The QAI noted that this vertical position (3G) complete joint penetration (CJP) weld is being made in segment B1. The QAI noted that the Quality Control (QC) Inspector James Cunningham is monitoring this welding. The QAI observed ABF worker Jordan Hazelaar, ID 2135, making the repairs with shielded metal arc welding (SMAW). The QAI noted that the repairs were completed and the welds were being ground smooth and flush with the OBG edge plates. See the attached photo. The QAI was not able to make any observations of welding in progress and the parameters were not verified as the repair welds have been completed.

2) The QAI observed QC Inspectors Steve McConnell and Tom Pasqualone conducting ultrasonic testing (UT) on the inside surface of plate E at OBG lifts 3E/4E field splice. See the attached photo. The QAI noted that the outside surface has UT markings for rejectable indications. The QAI observed that several portions of the inside of the weld have already been excavated in preparation for repair of the rejectable indications. The QAI asked the QC Inspector Tom Pasqualone how many repairs would be needed. The QC Inspector remarked that he was not

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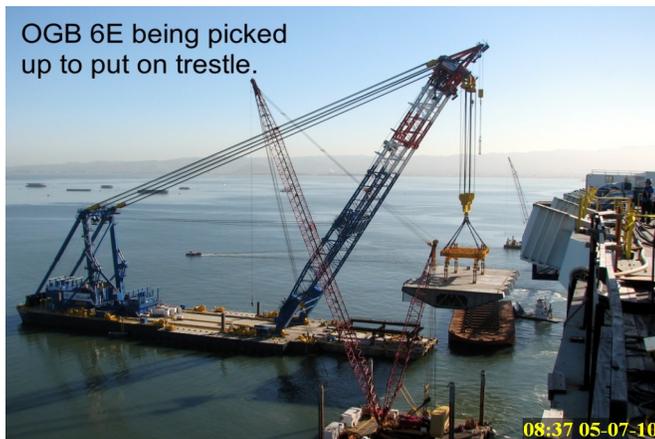
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aware of how many rejectable indications have been identified. The QAI was also informed that ABF will start welding the repairs.

The QAI also observed the contractor picking up OBG segment 6E for placement on the temporary trestle. See the attached photo. The QAI also noted that the scaffolding is being removed from inside the OBG segments at field splice locations 1E/2E and 2E/3E at this time. The QAI noted that previously reported backing bar burn through areas have not been repaired at this time. See the contractor's request for information ABF-RFI-002099R00 for additional information.

The QAI observed ABF activities at the Pier 7 location. The QAI did not observe any Quality Control (QC) Inspectors present. The QAI noted that ABF personnel are setting counterweights onto the OBG segment 5W. See the attached photo. The QAI noted that ABF personnel are welding on barges and job related equipment and assembling parts of the temporary trestle on the barges at Pier 7. The QAI did not observe any personnel welding on bridge components. The QAI noted that this work was in progress until the end of the shift. The QAI continued reviewing the contractor's submitted welding reports, submittal # 1536 Revision 4. The review was in progress at the end of this shift.



## Summary of Conversations:

The QAI relayed the observations of OBG splice welding to the QAI Danny Reyes. The QAI also generated a shift turn-over report with this information. The QAI relayed the observations at Pier 7 and the status of the submittal review to the Lead QAI Bill Levell. . There were no other notable observations or conversations during

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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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