

**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 #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013956**Date Inspected:** 11-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1130**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bill Norris**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:** OBG Sections**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and to monitor American Bridge/Fluor (ABF) welding operations.

The following observations were made:

- 1) At weld joint E4/E5 – A1 thru A5: ABF welding personnel were setting up to begin welding.
- 2) At weld joint E4/E5 – D1 and D2 it was observed Submerged Arc Welding (SAW) had been completed.
- 3) QA Ultrasonic Testing (UT) verification performed on stiffeners at E1/E2-D1 and D2.
- 4) General status of UT inspections performed by QC on East Orthotropic Bridge Girders (OBG) sections, see below for details.

At weld joint E4/E5 – A1 thru A5 this QA Inspector randomly observed ABF personnel were placing and sealing the temporary shelter, personnel were power siren brushing the Shielded Metal Arc Welding (SMAW) performed the previous day and the track for the Submerged Metal Arc Welding (SAW) process was being positioned. No welding was observed at this location this date.

At weld joint E4/E5 – D1 and D2 this QA Inspector observed ABF welding personnel had completed the SAW

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## WELDING INSPECTION REPORT

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portion of welding.

This QA Inspector has observed QC personnel marking adjacent to the applicable weld the status of the various inspections that have been performed. This QA Inspector performed a walk through on the East side of the OBG sections and observed the following welds had not been marked indicating the UT inspection had been accepted and completed by various QC Inspector's: E1/E2-D1 and D2, E2/E3-B, E2/E3-C1 and C2, E2/E3-D1 and D2, E2/E3-E1 and E2 and E2/E3-F. This QA Inspector had a conversation with lead QC Inspector Bill Norris to verify the status of the UT inspections at these locations to confirm they had not been or if QC personnel had inadvertently not marked the status adjacent to the welds. Lead QC Inspector Bill Norris informed this QA Inspector it take him at least a full day to confirm the status of the inspections.

This QA Inspector observed QC personnel had completed the UT inspection of the Complete Joint Penetration (CJP) welds on the 18 stiffeners located at E1/E2-D1 and D2. This QA Inspector performed a QA UT verification on stiffeners D-13, D-14 and D-15, approximately 12 percent of the overall weld length. Please see Ultrasonic Inspection Report (TL-6032) this date for details.

Welding was not observed during the shift this date.

### **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>	Hager,Craig	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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