

**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-014313**Date Inspected:** 21-May-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 |    |     |

**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 Lifts 1W/2W - plate F field splice welding
- 2) OBG Lifts 2W/3W - plate C field splice welding
- 3) OBG Lifts 1W2W - plate D stiffener splice grinding
- 3) OBG Lifts 5W & 6W - prep at Pier 7

1) The QAI observed ABF personnel grinding the outside cover passes on plate F at OBG lifts 1W/2W field splice.

The QAI noted that the Quality Control (QC) Inspector William Sherwood is present at this location. The QAI noted that the work is being performed by Jordan Hazelaar, ID 2135. The QAI was informed that the welding on this side was finished and was being ground flush and smooth. The QAI was also informed that the backing bar removal and back welding will not be done during this shift. See the attached photo.

2) The QAI observed ABF personnel back welding plate C at OBG lifts 1W/2W field splice. The QAI noted that the vertical position (3G) CJP weld segment C1 is being welded from the 1st side (inside). The QAI noted that the QC Inspector Bernie Docena is monitoring this welding. The QAI observed ABF workers Jin Quan Huang, ID 9340 and Song Tao Huang, ID 3794, making the welds with gas shielded flux cored arc welding (FCAW-G). The QAI was informed that welding procedure specification (WPS) ABF-WPS-D15-3040A-1 is being used for this welding. The QAI randomly measured the preheat, interpass temperature and welding parameters and noted that

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they appeared to be conforming to the WPS requirements.

3) The QAI observed ABF personnel grinding and cleaning up the stiffener splice welds in OBG lifts 1W/2W at plate D. The QAI noted that all welding appeared to be finished, the welds were being ground flush and smooth and the weld tabs were being removed from the complete joint penetration (CJP) butt welds. See the attached photo.

3) The QAI observed ABF activities at the Pier 7 location. The QAI did not observe any Quality Control (QC) Inspectors present. The QAI did not observe ABF personnel around OBG lifts 5W or 6W. The QAI noted that ABF personnel are welding on barges and job related equipment. The QAI also noted that the contractor is assembling parts of the temporary trestle on the barges at Pier 7. The QAI did not observe any personnel welding on bridge components.



### 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 general status of work observed to the Lead QAI Bill Levell. 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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**Inspected By:** Croff, Scott

Quality Assurance Inspector

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**Reviewed By:** Levell, Bill

QA Reviewer