

**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-014331**Date Inspected:** 21-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:** 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 3E/4E Face C (Outside) Repairs
2. OBG Field Splice 4E/5E Face A (Outside) UT Review

**Field Splice 3E/4E Face C (Outside) Repairs**

The QA inspector spoke with QC inspectors Tom Pascaulone and Steve McConnell in regards to the progress of the UT review of the previously completed repair locations for the weld. It was relayed to the QA inspector two areas were marked for additional rejectable indications at this time in the repair areas with other locations being acceptable. In addition the QC inspectors relayed they would be verifying the indications discovered from the inside of the OBG as well as from the outside. Later in the shift it was observed a total of 4 rejectable indications were discovered in the repair locations and would require additional repairs with the designation of R2. The QA inspector noted ABF welding personnel Rick Clayborn was stationed at this location and proceeded to perform the excavations of these areas. The work progressed throughout the QA inspector's review of this area, was not complete and appeared to be progressing in general conformance with the contract documents.

**Field Splice 4E/5E Face A (Outside) UT Review**

The QA inspector performed an ultrasonic testing (UT) review of a representative portion of the repair areas completed previously by the contractor and the QC department for face A. The review was performed from the

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outside surface between approximate Y locations designated 27,280mm which encompassed two rejectable indications previously repaired, Y location 15,400 and Y location 14,800. The repairs located at welds designated A1 and A2 are pending UT review and acceptance from the QC department as the 24 hour hold time will elapse later in the afternoon. The QA inspector performed the review utilizing a zero degree transducer in order to check for laminar reflectors and a 70 degree transducer and wedge combination for the shear wave examination. No rejectable relevant indications were noted at the time of review and a TL-6027 will be generated for this item for this date. This completes the QA UT review for weld location with the exception of any further indication discovered by QC for the remaining repair locations. The QA inspector received verbal notification from QC inspector Tom Pascaulone the outstanding repairs were reviewed by QC and accepted with no rejectable indications noted.

**Summary of Conversations:**

As noted above in items observed.

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