

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-014785**Date Inspected:** 14-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**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 D (Outside) Backgouge
2. OBG Field Splice 4E/5E Face F (Outside) FCAW
3. OBG Field Splice 2W/3W Face C
4. OBG Field Splice 2W/3W Face E

**Field Splice 3E/4E Face D (Outside) Backgouge**

The QA inspector noted and periodically observed ABF welding operators Mitch Sittinger and Fred Kaddu performing the backgouging and grinding operations for face D on the second side (Outside). The welding operators continued setting the equipment up and periodically performing the operation throughout the shift. The work was not completed on this date or turned over to QC for verification at this time but appeared to be progressing in general conformance with the contract documents.

**Field Splice 4E/5E Face F (Outside)**

The QA inspector periodically observed ABF welding personnel Xiao Jin Wan performing flux cored arc welding (FCAW) at this location. The welder commenced the welding of the root pass on this date and continued with the subsequent weld layers. QC inspector Tony Sherwood was noted to be present in order to monitor the progress and ensure the welding was within the established Welding Procedure Specification (WPS) noted as ABF-WPS-D1.

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

5-3040B-3. The preheat and interpass temperature was verified by the QC and QA inspector to be greater than 65° Celsius (C) and the parameters were verified to be 220 amps, 23.1 volts and a measured travel speed of 150mm/min. The work continued throughout the QA inspectors shift at this location, was not completed and appeared to be progressing in general conformance with the contract documents.

### Field Splice 2W/3W Face C (Outside)

The QA inspector noted and periodically observed ABF welding operators Rory Hogan and Jeremy Dolan has completed the FCAW for the outside of this splice and is in the process of re-locating the equipment to 3W/4W face E. QC inspector Jim Cunningham was noted to be in the area reviewing several specific locations however the induction heating coils and FCAW gear is still present and the visual review will be performed at a later date.

### Field Splice 2W/3W Face E (Outside)

The QA inspector periodically observed QC ABF inspectors Bonafacio Daquinag and Jim Cunningham performing magnetic particle testing (MT) on the outside weld of face E. It was noted the inspectors are detailing the Y locations for the temporary attachment locations and the acceptance of the MT review. The work progressed throughout the morning shift, was completed and appeared to be in general conformance with the contract documents.

### Summary of Conversations:

No significant conversations held on this date for this contract.

### 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.

---

<b>Inspected By:</b>	Foerder, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

---