

**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-015020**Date Inspected:** 17-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Jesus Cayabyab**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 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 welding on barges and other job related equipment. The QAI also noted that the contractor is assembling parts of the temporary trestle and Favco crane on the barges at Pier 7. The QAI did not observe any personnel welding on bridge components (OBG 6W). The QAI noted that this work was in progress until the end of the shift.

The QAI arrived at the job site and met with the QC Inspector Jesus Cayabyab. The QAI continued working on the QC production status list and inquired about the status of several items noted on the QC production status list. The QC Inspector was shown the list and remarked that he was not familiar with it. He reviewed the list and confirmed that there are still pending inspections, ultrasonic testing that need to be conducted on the field splice welds of 1E/2E and 2E/3E. The QAI and the QC Inspector conducted a general survey of the 2E/3E field splice and noted that listed items will require repair / inspection before the welded field splice can be signed off. The QAI relayed the earlier observations of 1E/2E, that a temporary attachment is still welded onto the bottom of field splice A-2 and there appears to be burn through visible along the edges of the backing bar on field splice A-2 and A-3. The QC Inspector confirmed that the temporary attachment will have to be removed and inspected. The QC Inspector did not agree that there was un-repaired burn through on the backing bar. The QAI and the QC Inspector were not able to conduct a detailed survey due to the lack of access / proximity from the welds / backing bars. There were also conversations about what has been listed as needing ultrasonic testing (UT) after 24 hours. The

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

QAI noted that the deck plate A has been painted over at the field splice and this will interfere with proper UT. The QAI asked if the backing bar transitions at edge plates, has been inspected. The QC Inspector replied that only a preliminary inspection has been performed and it has not yet been determined if the corners / transitions on the field splice welds A1 and A5 are acceptable. The QAI asked when these items will be completed and acceptable. The QC Inspector replied that he was unaware of the schedule to complete the repairs and inspection of the field splice welds at the 1E/2E and 2E/3E locations. The QAI relayed the observed conditions and conversations to the Lead QAI Bill Levell.

### **Summary of Conversations:**

The QAI had general conversations with ABF and Caltrans personnel during this shift. Except as described above, there were no other notable conversations or observations.

### **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> | Croff, Scott | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Levell, Bill | QA Reviewer                 |

---