

**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-015460**Date Inspected:** 01-Jul-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

<b>CWI Name:</b>	Bernard Docena, Mike Johnson	<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes	No	N/A
		<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	SAS OBG		

**Summary of Items Observed:**

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above.

The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified 4E/5E-E2, 1W/2W-B and the following observations were made:

**3W/4W-E1/E2**

The QA Inspector randomly observed the Smith Emery (SE) Quality Control (QC) Inspector Steve McConnell performing ultrasonic testing (UT) of the above identified weld joint. The QA Inspector randomly observed the QC Inspector perform the UT through completion. The QA Inspector noted two rejectable indications were located and indicated directly on the weld. The QA Inspector noted due to the accessibility and low number of UT rejects, it was determined UT verification of a representative sample could be performed. The QA Inspector performed UT on a random 10% of the total weld length of the above identified weld joint. The QA Inspector noted no rejectable indications were located at the time of the testing. The QA Inspector noted the UT verifications was performed prior to the two UT rejections located by SE QC being repaired (see TI-6027 for additional information).

**1W/2W-F**

Upon the arrival of the QA Inspector it was observed the QC Inspector Tom Pasqualone was performing the magnetic particle testing and visual testing of the completed back weld. The QA Inspector noted after the QC Inspector had completed the inspection the above identified weld was determined to be acceptable. The QA Inspector performed random MT verification of approximately 30% of the total weld length and noted no rejectable indications were located at the time of the testing (see TI-6028 for additional information). In addition the QA Inspector performed VT verification of the completed weld and noted the back weld appeared to be in

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# WELDING INSPECTION REPORT

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general compliance with the contract requirements.

## 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>	Bettencourt,Rick	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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