

**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-015837**Date Inspected:** 26-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**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:** 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 4W/5W, 4E/5E, and the following observations were made:

**4W/5W-F**

Upon the arrival of the QA Inspector at the above identified location

It was observed the ABF welder identified as Hua Qiang Huang had previously completed the back gouging of the above identified weld joint. The QA Inspector randomly observed the Smith Emery Quality Control (QC) Inspector identified as Tom Pasqualone was on site and performing magnetic particle testing of the completed back gouge. The QA Inspector randomly observed the QC Inspector locate a relevant linear indication new the top of the weld joint. The QA inspector noted the indication appeared to be approximately 10mm in length. The QA Inspector randomly observed the above identified welder perform grinding tasks several times in an attempt to remove the MT indication. After several attempts of grinding and MT it was observed the indication had been removed. The QA Inspector observed the QC Inspector perform MT and demonstrate the MT indication had been removed by grinding. The QA Inspector noted no production welding was completed on the QA Inspectors shift.

**4E/5E-E**

The QA Inspector randomly observed the ABF welder identified as Jeremy Doleman performing plasma arc gouging of the above identified weld joint. The QA Inspector randomly observed the steel backing bar was being removed. The QA Inspector noted the steel backing bar was nearly removed at the time of QA Inspectors visit. The QA Inspector noted the back gouging was being performed for the remainder of the QA Inspectors shift.

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The QA Inspector performed a job site walk through and updated the Caltrans QA Production/NDT tracking log. The QA Inspector noted, after the information was gathered in the field, the QA Inspector transferred the information to the chart in the Caltrans SAS office on the job site.

**Summary of Conversations:**

The ABF Project Engineer John Callaghan informed the QA Inspector on Wednesday ABF will likely pick and lift the first tower section into place.

**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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