

**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-015951**Date Inspected:** 30-Jul-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:** Jobsite**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:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Splice 1W/2W Weld ID: D1 & D2, Face A
- 2). OBG Field Splice 3W/4W Weld ID: F1, Face A

- 1). OBG Field Splice 1W/2W Weld ID: D1 & D2, Face A

The QAI periodically observed AB/F approved welder Fred Kaddu (ID 2188) performing repair welding per the Shielded Metal Arc Welding (SMAW) process in the 1G (flat) position of repair excavations at Ultrasonic Testing (UT) reject areas from the A face. AB/F approved welder Kenneth Chappell was performing the excavating by grinding. AB/F QC Inspector Tom Pasqualone was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1000-Repair. The QAI periodically observed QC Inspector Tom Pasqualone performing Magnetic Particle Testing (MT) of the repair excavations prior to Mr. Kaddu performing welding at the repair locations. The QAI observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. Work was not completed at this location during the QA Inspectors shift and the work appeared to be in general compliance with contract documents.

- 2). OBG Field Splice 3W/4W Weld ID: F1, Face A

The QAI periodically observed AB/F approved welder James Zhen (ID 6001) grinding to excavate (2) two UT

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reject indications in one excavated repair area on the A face of the OBG Field Splice 3W/4W Weld ID: F1. The QAI observed QC Inspector Tony Sherwood measuring the dimensions of the excavation and then directing Mr. Zhen to perform additional grinding to obtain a depth greater than the indication depth recorded on the QC UT report. The QAI observed QC Inspector Tony Sherwood measuring the depth dimension of the excavation and indicating to Mr. Zhen that the depth was adequate. Mr. Sherwood then performed Magnetic Particle Testing (MT) of the excavation to confirm the complete removal of the rejectable indication. See photo below. The QAI observed AB/F approved welder James Zhen (ID 6001) performing attachment welding of run-off tabs and then the QC inspector measuring the welding parameters during the first weld pass deposited in the repair excavation. See photo below. The QC Inspector stated to the QAI that the welding Amps were measured at 125 Amps. The QAI periodically observed the repair welding per the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position. See photo below. QC Inspector Tony Sherwood was present to monitor the progress and identified the approved Welding Procedure Specification (WPS) to the QAI as ABF-WPS-D1.5-1000- Repair. The QAI observed that the welding amperes reported by the QC Inspector were within the limits established the identified WPS. The repair welding at this repair location was completed during the QA Inspectors shift and the work appeared to be in general compliance with contract documents.

The QA Inspector performed a job site walk through and noted the current welding and NDE status of the OBG at the job site. After the information was gathered in the field the QA Inspector updated the Caltrans QA Production/NDT tracking log and transferred the information to the chart in the Caltrans SAS office on the job site.



### Summary of Conversations:

As stated in the body of this report.

### 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 Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

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**Inspected By:** Madison, Bert

Quality Assurance Inspector

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**Reviewed By:**      Levell,Bill

QA Reviewer