

**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-016043**Date Inspected:** 04-Aug-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:** N / A**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:** S.A.S. components**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 reviewed contract related documents including the submitted and approved Welding Quality Control Plan (WQCP) and pending revisions to the WQCP. The QAI participated in a discussion of the submitted welding procedure requirements for the HPS 485 grade steel that may be utilized in field splice welding of stiffeners on the orthotropic box girders. The contract special provisions were reviewed along with the D1.5 welding code requirements. The QAI agreed that the field splice welding will require preheat to be maintained throughout welding and for 3 hours after completion of the welding. The QAI relayed this opinion to the QAI Lead Bill Levell.

The QAI continued consolidating the information from welding report submittals and generating a weld specific tracking list. The QAI was informed by the Quality Control Manager Jim Bowers that additional reports will not be submitted in the near future, as the contractor is working on correcting the previously returned submittals. The QAI was also informed that there will be additional discussions regarding some of the returned submittals and the general format of presenting the missing / corrected reports in future submittals.

**Summary of Conversations:**

The QAI had general conversations with ABF and Caltrans personnel during this shift. As noted above, the QAI had conversations regarding the contract requirements for preheat and another conversation regarding the status of the welding report submittals. Except as described above, there were no other notable conversations or observations.

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# WELDING INSPECTION REPORT

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

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