

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-016056**Date Inspected:** 02-Aug-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 Inspector (QAI), Rick Bettencourt, 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 approved revisions to the WQCP. The QAI continued reviewing the contractor's welding report submittal # 1536 Rev. 18, for conformance to the contract special provisions. The QAI continued consolidating the information from previous welding report submittals to identify missing reports of inspections. The QAI completed generating a weld specific tracking list from the submitted welding reports.

**Summary of Conversations:**

The Caltrans Structures Representative Doug Wright informed the QA Inspector from the looks of the picture submitted with the Incident Report, the South East Corner of the base plate did not look like a weld. Mr. Wright went on to inform the QA Inspector the base plate appeared to have been burned from the looks of the picture. The QA Inspector re-affirmed and insisted the area pictured in the incident report was in fact a broken temporary weld which appeared to be left in place. Mr. Wright informed the QA Inspector there was no reason for a weld to be in that location. The QA Inspector urged Mr. Wright to observe the area on the base plate in person and visually to confirm any concerns over what the picture in the Incident Report entailed. In addition Mr. Wright informed the QA Inspector that Caltrans Construction Representatives Mark Woods and Brian Maroney have verbally expressed the temporary welds on the base plate may be left in place. The QA Inspector informed Mr. Wright that ABF and Smith Emery are in the process of removing the welds at the current time. Later in the shift Mr. Wright confirmed with the QA Inspector in fact the area at the South East Corner of the Tower base was a broken temporary weld.

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The ABF Project Engineer John Callaghan informed the QA Inspector ABF is awaiting the ceramic round bar stock to begin welding of the 485W HPS stiffeners. Mr. Callaghan informed the QA Inspector as soon as the WPS is approved and the ceramic backing arrives ABF will likely begin the welding. Mr. Callaghan informed the QA Inspector, due to the large root gaps between the stiffeners, round ceramic bar stock will be used to butter or weld build the weld joints. Mr. Callaghan went on to inform the QA Inspector the ceramic will allow for minimal back gouging.

### **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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