

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-016113**Date Inspected:** 09-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 (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 1E/2E-A-S3/S5 and the following observations were made:

**1E/2E-A-S3**

Upon the arrival of the QA Inspector at the above identified location, the QA Inspector randomly observed the ABF welder James Zhen preparing to begin the shielded metal arc welding (SMAW) fill pass. The QA Inspector noted the weld was not maintained at 200°F as per the Caltrans Special Provisions "Field Welding" note "C". The QA Inspector noted the FCAW butter passes were previously completed. The QA Inspector noted the FCAW root pass was completed on the previous day shift. The QA Inspector randomly observed the ABF welder preheat the material to 200°F utilizing a rosebud torch. The QA Inspector noted the Smith Emery (SE) Quality Control (QC) Inspector John Pagliero was on site monitoring the in process preheats and welding parameters of approved welding procedure identified as ABF-WPS-D1.5-1012-3. The QA Inspector performed a random visual inspection of the fit up of the above identified stiffener plates and noted the root opening did appear to be within the dimensional tolerances of the approved WPS identified above. The QA Inspector randomly observed the ABF welder remove the E9018 1/8" electrodes from the rod container at 0730. The QA Inspector noted the maximum exposure time for the above identified electrodes is one hour. The QA Inspector randomly observed the ABF welder continue the SMAW fill pass on the above identified weld joint. The QA Inspector noted the SMAW parameters were 130 amps and appeared to be in general compliance with the above identified WPS. The QA Inspector noted the weld joint was approximately 30% complete at the end of the QA Inspectors shift.

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1E/2E-A-S4

Upon the arrival of the QA Inspector it was observed the above identified weld joint was completed. The QA Inspector noted no grinding had been completed at the time of QA Inspectors visit. The QA Inspector noted the ABF welder Xiao Jian Wan was performing the grinding tasks in the am.

1E/2E-A-S5

Upon the arrival of the QA Inspector at the above identified location, the QA Inspector randomly observed the ABF welder Xiao Jian Wan preparing to begin the SMAW fill passes. The QA Inspector noted the SMAW root pass was complete upon the arrival of the QA Inspector. The QA Inspector noted the weld was not maintained at 200°F as per the Caltrans Special Provisions "Field Welding" note "C". The QA Inspector randomly observed the ABF welder preheat the material to 200°F utilizing a rosebud torch. The QA Inspector noted the SE QC Inspector John Pagliero was on site monitoring the in process preheats and welding parameters of approved welding procedure identified as ABF-WPS-D1.5-1012-3. The QA Inspector randomly observed the ABF welder remove the E9018 1/8" electrodes from the rod container at 0745. The QA Inspector randomly observed the ABF welder begin the SMAW fill pass on the above identified weld joint. The QA Inspector noted the SMAW parameters were 125 amps and appeared to be in general compliance with the above identified WPS. The QA Inspector noted the ABF welder continued the fill pass through out the duration of the QA Inspectors shift.



## Summary of Conversations:

The QA Inspector asked the QC Inspector Mike Johnson if there was any Non Destructive Testing (NDT) ready for QA verifications. Mr. Johnson informed the QA Inspector no NDT was available or ready for any QA verifications.

## 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
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<b>Reviewed By:</b>	Levell,Bill	QA Reviewer
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