

**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-016338**Date Inspected:** 20-Aug-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). PP13 ABF-SUB-001503R00
- 2). OBG Field Splice 4W/5W Weld ID: C1 & C2, Face B
- 3). OBG Field Splice 4W/5W Weld ID: F1 & B1, Face B
- 4). OBG Field Splice 5W/6W Weld ID: B1, Face B
- 5). OBG Field Splice 5W/6W Weld ID: C2, Face A

The QAI periodically observed the QA Verification status board located in the QC Conex and no QA verification became available on this date during the QA Inspector's shift.

- 1). PP13 ABF-SUB-001503R00

The QAI periodically observed AB/F approved welder Fred Kaddu (ID 2188) together with AB/F approved welder Kenneth Chappell (ID 3833) performing fit-up operations and then welder Kaddu welding per the Shielded Metal Arc Welding (SMAW) process to install the patch in the full height shear plate at PP13. See photo below. The QAI observed QC Inspector Mike Johnson was present periodically to monitor the progress and verify that the welding parameters were within the limits established by the approved Welding Procedure Specifications (WPS) identified as ABF-WPS-D1.5-1090 (horizontal) and ABF-WPS-D1.5-1010-1 (vertical). The welding at this location was in process for the duration of the QA Inspector's shift and appeared to be in general compliance with contract documents.

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2). OBG Field Splice 4W/5W Weld ID: C1 & C2, Face B

The QAI periodically observed ABF personnel performing Plasma Cutting and grinding to prepare a groove for back welding. The work at this location was in process for the remainder of the QA Inspectors shift.

3). OBG Field Splice 4W/5W Weld ID: F1 & B1, Face B

The QAI periodically observed QC Inspector Jesse Cayabyab performing UT from the B Faces of OBG Field Splice 4W/5W Weld ID: F1 & B1. The QAI periodically observed that Mr. Cayabyab performed the required shear wave testing during the testing for weld soundness utilizing a .63 x .75 rectangular transducer. The UT examinations were completed from face B during the QA Inspectors shift and the work at this location appeared to be in general compliance with contract documents.

4). OBG Field Splice 5W/6W Weld ID: B1, Face B

The QAI periodically observed QC Inspector Jesse Cayabyab performing UT from the B Face of OBG Field Splice 5W/6W Weld ID: B1. The QAI periodically observed that Mr. Cayabyab performed the required shear wave testing during the testing for weld soundness utilizing a .63 x .75 rectangular transducer. The UT examination was completed from face B during the QA Inspectors shift and the work at this location appeared to be in general compliance with contract documents.

5). OBG Field Splice 5W/6W Weld ID: C2, Face A

The QAI periodically observed AB/F approved welder Song Tao Huang (ID 3794) performing welding per the Flux Cored Arc Welding (FCAW-G) process in the 3G (vertical) position of root and fill passes on weld ID: C2. See photo below. The QAI observed QC Inspector Mike Johnson was present periodically 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-D1.5-3042B-1. The QAI observed that the work at this location appeared to be in general compliance with contract documents.



## Summary of Conversations:

Conversations on this date with Quality Control Inspectors were general in nature and pertained to locations of welding and QC activities.

## Comments

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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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<b>Inspected By:</b>	Madison,Bert	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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