

**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-016401**Date Inspected:** 23-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 update and current tracking logs and charts. The following tasks were performed.

The QA Inspector performed a job site walk through and updated the Caltrans QA Production/NDT tracking log. The QA Inspector noted, after the information was gathered in the field, the QA Inspector transferred the information to the chart in the Caltrans SAS office on the job site. The QA Inspector spent the remainder of the shift performing organizational tasks of the tracking of the QA NDT on the job site.

In addition the QA Inspector reviewed Caltrans Special Provisions and contract documents as well as contract plans.

**1E/2E Drip Edge Installation**

Upon the arrival of the QA Inspector, it was observed both of the drip plates had been installed to the directly under the "B" edge plate. The QA Inspector randomly observed the first plate had been installed with a complete joint penetration groove weld with a reinforcing fillet weld on the back side of the plate. The QA Inspector noted the second plate that was installed, was welded with a 6mm fillet weld on both sides of the plate. The ABF WQCM Jim Bowers informed the QA Inspector as per design drawing sheet 877 R1 the installation only requires a 6mm fillet weld on both sides of the plate with a seal weld at either end to the existing drip plate on the bridge. Mr. Bowers informed the QA Inspector ABF is utilizing a partial joint penetration groove weld in lieu of a seal weld to ensure no cracking would occur. The QA Inspector randomly observed the ABF welder Rick Clayborn performing the SMAW 6mm fillet weld attaching the second drip plate to the OBG. The QA Inspector randomly

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observed the welder to be utilizing E7018 low hydrogen electrodes with 135 Amps. The QA Inspector noted the SMAW parameters appeared to be in general compliance with ABF-WPS-D1.5-F1202.

**Summary of Conversations:**

As noted above.

**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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