

**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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016814**Date Inspected:** 14-Sep-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). OBG Field Welding of East Line Lifting Lug Access Hole Restoration - (SMAW)
- 2). OBG Field Welding of East Line Personnel Access Hole Restoration - (SMAW)

- 1). OBG Field Welding of East Line Lifting Lug Access Hole Restoration - (SMAW)

Exterior: PP20 and PP22

The QAI periodically observed the fit-up and welding per the Shielded Metal Arc Welding (SMAW) process in the 1G (flat) position to restore the Lifting Lug Access holes in the A deck at PP20 and PP22. The QAI observed that AB/F approved welder Yao Xin Liang (ID 7238) performed fit-up and welding at PP20 weld E3-4 then E3-2 and then at PP22 at weld E3-3. The QAI observed that AB/F approved welder Wai Kitlai (ID 2953) performed fit-up and welding at PP20 weld E4-1, E4-2 then E4-4. QC Inspector Steve McConnell was periodically present 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-D1.5-1050A. The QAI also periodically observed QC Inspector Steve McConnell performing checks of the planar alignment at fit-up locations prior to the root pass welding. See photos below. Welding from the exterior was completed at these locations on this date. The QAI observed that the work appeared to be in general compliance with contract documents. The QAI noted that the access hole restoration at PP17 had been bypassed. The QAI asked Mr. McConnell if he knew why

Interior: PP11

The QAI periodically observed AB/F approved welder Jin Pei Wang (ID 7299) performing back welding per the

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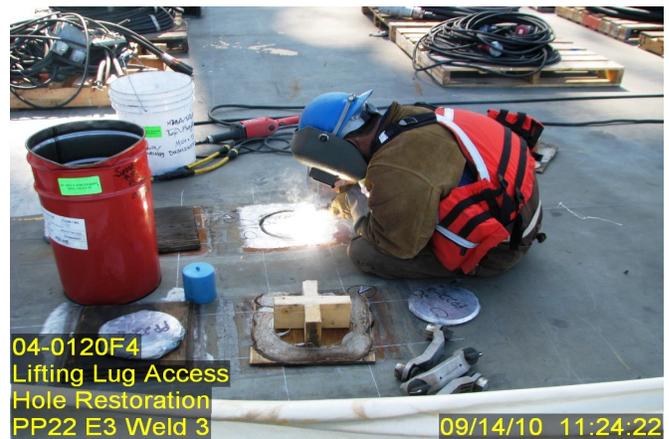
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SMAW process in the 4G (overhead) position and grinding at PP11 at weld E3-1 and E3-2. QC Inspector John Pagliero was periodically present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1110B rev.1. The QAI observed that the work appeared to be in general compliance with contract documents.

## 2). OBG Field Welding of East Line Personnel Access Hole Restoration – (SMAW)

The QAI periodically observed AB/F approved welder Fred Kaddu (ID 2188) performing welding per the SMAW process in the 4G (overhead) position. Mr. Kaddu was welding the backing passes from the interior of the A deck between PP10 & PP11 on the Crossbeam side of OBG 1E. QC Inspector John Pagliero was periodically present 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-D1.5-1030 rev.1. The QAI was informed by Mr. Pagliero that after welding several passes from the interior Mr. Kaddu would move to the exterior to back grind and complete the welding of the joint. The QAI observed however that Mr. Kaddu when finished on the interior proceeded to the Bike Path side to perform fit-up operations at the other Personnel Access Hole Restoration location.



### Summary of Conversations:

As noted in the body of this report and From Item 1).

The QAI noted that the access hole restoration at PP17 had been bypassed. The QAI asked Mr. McConnell if he knew why. Mr. McConnell stated that he believed that the alignment of the patch plates with respect to the grain direction had been an issue at PP17.

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

### 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 Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

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**Inspected By:** Madison, Bert

Quality Assurance Inspector

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**Reviewed By:**      Levell,Bill

QA Reviewer