

**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:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017359**Date Inspected:** 08-Oct-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 Splice 7W/8W weld ID: D1 & D2 Face A - (FCAW-G)
- 2). OBG Field Splice 6W/7W Weld ID: E1, Face A (FCAW-G)
- 3). OBG Field Splice 5W/6W Weld ID: E2, Face A (SMAW UT repairs)

- 1). OBG Field Splice 7W/8W weld ID: D1 & D2 Face A - (FCAW-G)

The QAI periodically observed the in process welding of the root fill and cover passes in the first meter of weld D1 and the last meter of weld D2 in the OBG Field Splice 7W/8W at Face A. The welding was per the FCAW-G process in the 1G (flat) position by AB/F approved welder Xiao Jian Wan (ID 9677) at D1 and AB/F approved welder Hua Qiang Hwang (ID 2930). See photo below. The QC Inspector John Pagliero was 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-D1.5-3040A-1. Welding was in process and work at this location appeared to be in general compliance with contract documents.

- 2). OBG Field Splice 6W/7W Weld ID: E1, Face A - (FCAW-G)

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 fill and cover passes on weld ID: E1. The QAI observed QC Inspector John Pagliero was present to monitor the progress and verify that the welding parameters were within the limits established by the approved Welding Procedure Specification (WPS) identified

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

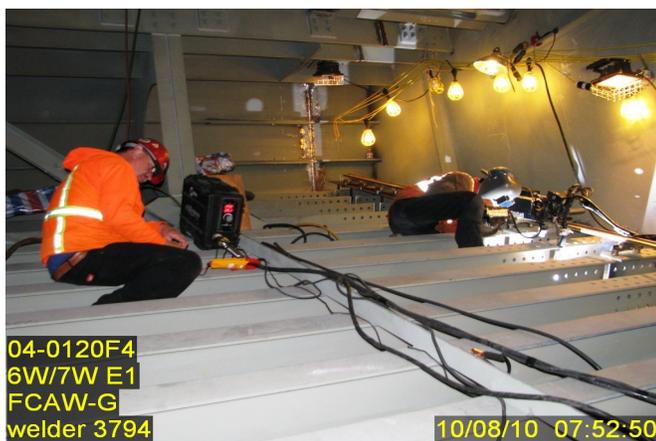
---

---

as ABF-WPS-D1.5-3042B-1. See photo below. The QAI observed that the work at this location was in process for the duration of the shift and appeared to be in general compliance with contract documents.

### 3). OBG Field Splice 6E/7E Weld ID: F1, Face A

The QAI periodically observed AB/F approved welder Fred Kaddu (ID 2188) performing welding per the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position of OBG Field Splice 5W/6W Weld ID: E2, to repair Ultrasonic Testing (UT) rejectable areas. QC Inspector Jesse Cayabyab was 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-D1.5-1000 Repair. The QAI observed that Mr. Kaddu completed welding of (3) three excavations at the following locations: Weld Y = 4630, Length = 150mm and Depth = 8mm, Y = 4520, Length = 210mm and Depth = 7mm & Y = 0, Length = 150mm and Depth = 8mm. The QAI observed that there are three additional UT rejected areas in weld E2 and one in weld E1. The QAI observed that the work at the three locations described above was completed. Work at this location was in process and appeared to be in general compliance with contract documents.



### Summary of Conversations:

The QAI was approached by QC Lead Inspector Mr. Bonafacio Daquinag and informed that he was working on a tracking system for the welding and repair welding of the lifting rod penetration insert welds in the A deck. Mr. Daquinag stated that these welds would not be turned over to METS for verification testing until all four insert welds at a given location have been accepted by QC. He went on to say that thus far no location has had all 4 welds accepted by QC.

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.

---

**Inspected By:** Madison, Bert

Quality Assurance Inspector

---

---

# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

**Reviewed By:**      Levell,Bill

QA Reviewer