

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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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-017760**Date Inspected:** 02-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1300**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** John Pagliero**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:** OBG Section**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above. This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and to monitor American Bridge/Fluor (ABF) welding operations.

The following observations were made:

1) At weld joints 4E/5E LS-1, inside the OBG section: ABF welding personnel Hua Qiang Hwang (#2930) was performing Shielded Metal Arc Welding (SMAW). QC Inspector John Pagliero was monitoring the work.

2) At weld joints 4E/5E LS-6, inside the OBG section: ABF welding personnel Xiiiao Jian Wan (#9677) was performing SMAW. QC Inspector John Pagliero was monitoring the work.

3) At access plate 5E-PP 9.5-E2-S, inside the OBG section: ABF welding personnel Jin Pei Wang (#7299) was performing SMAW in the overhead (4G) position. QC Inspector John Pagliero was monitoring the work.

At weld joints 4E/5E LS-1, inside the OBG section this QA Inspector observed ABF welding personnel Hua Qiang Hwang (#2930) performing SMAW. This QA Inspector observed welding was being performed on the South side of the groove weld. This QA Inspector performed a verification of the following welding parameters: the preheat temperature was greater than 100 ° C but less than the maximum interpass temperature by use of temperature indicating markers and the welding amperage was 126 using a 3.2 mm diameter E9018H4R electrode. This QA Inspector observed the preheat temperature was being maintained by using an electric induction heating

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blanket attached to the back side of where welding was being performed. This QA Inspector observed QC Inspector John Pagliero was in the area and monitoring the welding. The welding observed appeared to comply with ABF-WPS-D15-1012-3.

At weld joints 4E/5E LS-6, inside the OBG section this QA Inspector observed ABF welding personnel Xiiao Jian Wan (#9677) performing SMAW on the North side of the groove weld. This QA Inspector performed a verification of the following welding parameters: the preheat temperature was greater than 100 ° C but less than the maximum interpass temperature by use of temperature indicating markers and the welding amperage was 122 using a 3.2 mm diameter E9018H4R electrode. This QA Inspector observed the preheat temperature was being maintained by using an electric induction heating blanket attached to the back side of where welding was being performed. This QA Inspector observed QC Inspector John Pagliero was in the area and monitoring the welding. The welding observed appeared to comply with ABF-WPS-D15-1012-3.

Adjacent to the locations above this QA Inspector observed a welding electrode holding oven, the oven was on and the temperature gauge was greater than 250 °F.

At access plate 5E-PP 9.5-E2-S, inside the OBG section this QA Inspector observed ABF welding personnel Jin Pei Wang (#7299) performing SMAW in the overhead (4G) position. This QA Inspector observed QC Inspector John Pagliero was monitoring the work. This QA Inspector performed a verification of the following welding parameters: welding amperage was 125 using a 3.2 mm diameter E7018H4R electrode. The welding observed appeared to comply with ABF-WPS-D15-1010 Rev-1.

### **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>	Hager,Craig	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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