

**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-017886**Date Inspected:** 03-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

<b>CWI Name:</b>	Mike Johnson		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Component:</b>	S.A.S. components		

**Bridge No:** 34-0006**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

- 1) F.W. Spencer - pipe support bracket welding
- 2) OBG 9E placement
- 3) Contract document review at Pier 7

1) The QAI observed F.W. Spencer personnel welding pipe support brackets onto embed plates at W2 adjacent to Orthotropic Box Girder (OBG) 1W. At the time of the QAI's observations, David Garcia was using shielded metal arc welding (SMAW) with E7018 H4R electrodes to make filled welds between the bracket components and the embedded steel plates. The QAI was informed that Quality Control (QC) Inspectors are monitoring and inspecting the welding as it progresses. The QAI did not observe any QC Inspectors present during these observations but the QAI noted that per contract requirements there can be 30 minute intervals with no QC present. The QAI also noted that the brackets are welded to AWS D1.1 requirements. See the attached photo. The QAI relayed the information of F.W. Spencer welding to the QAI Bert Madison.

2) The QAI made other observations of work in progress and noted that OBG 9E is being set into place. See the attached photo.

3) The QAI reviewed contract related documents including the submitted and approved Welding Quality Control

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Plan (WQCP) and approved revisions to the WQCP. The QAI continued consolidating the information from previous welding report submittals to identify missing reports of inspections. The QAI continued generating a weld specific tracking list from the contractor's welding reports.



## Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed the observations of welding and the status of document reviews to the QAI Lead Bill Levell. The QAI was informed that ABF weld repairs 201011-002 and 201011-003 were verbally approved by the Structural Materials Representative (SMR) Pat Lowry. The QAI noted that a copy of the repair procedures has been provided by ABF and has been filed in the repair log. The QAI also noted that ABF welder Melvin Ivy has been informally approved to weld using SMAW on non-SPCM material. The QAI relayed this information to the other necessary QAI. Except as described above, there were no other notable conversations or observations.

## 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>	Croff, Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

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