

**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-017890**Date Inspected:** 01-Nov-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 randomly observe the in process welding and inspection of the weld joints identified as hole restoration 5E-pp29.5-E2-SW, 3E-23.5-E5-NE and the following observations were made:

**5E-pp29.5-E2-SW**

The QA Inspector randomly observed the American Bridge/Fluor (ABF) welder James Zhen setting up to begin performing the shielded metal arc welding SMAW fill passes. The QA Inspector noted the weld joint appeared to be approximately 20% complete upon the arrival of the QA Inspector. The QA Inspector randomly observed the previously completed root passes and noted they appeared to be in general compliance with the contract requirements. The QA Inspector randomly observed the SE QC Inspector Patrick Swain was on site monitoring the in process welding. The QA Inspector randomly observed the SMAW parameters were 130 Amps while utilizing 1/8" E7018 low hydrogen electrodes. The QA Inspector noted the SMAW parameters appeared to be in general compliance with ABF-WPS-D1.5-1030. The QA Inspector randomly observed the ABF welder complete the initial root pass from the top of the weld joint then proceed to the bottom of the weld joint to perform the SMAW 4G back weld.

**3E-23.5-E5-NE**

The QA Inspector randomly observed the ABF welder identified as Mike Maday performing fitting tasks of the above identified deck insert access hole. The QA Inspector randomly observed the ABF welder utilizing the nibbler machine and cutting a 35° bevel on the edge of the plate. The QA Inspector randomly observed the ABF welder begin grinding the edge of the bevel with a flapper wheel once the bevel angle had been rough cut onto the

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edge of the plate. The QA Inspector randomly observed the ABF welder had performed the fitting tasks for the remainder of the QA Inspectors shift. The QA Inspector noted the deck plate insert was not installed on this date. The QA Inspector performed a random VT verification of the bevel angles and noted they appeared to be in general compliance with the contract requirements.

The QA Inspector spent the remainder of the shift updating the on site transverse field splice NDT log, access hole NDT tracking, lifting lug production and NDT tracking, and over all ABF production chart.

### Summary of Conversations:

The QC Inspector John Pagliero informed the QA Inspector the welder was not going to back gouge the weld joint. The QC Inspector went on to inform the QA Inspector he could not accept the weld due to the fact it was not welded in conformance with ABF-WPS-D1.5-1070. The QA Inspector was later informed by the QC Inspector Mike Johnson the weld would be back gouged at a later date. Later in the shift, Mr. Pagliero was instructed by Mike Johnson no to speak with the QA Inspector Rick Bettencourt or provide any additional information. The QA Inspector noted Mr. Pagliero did in fact provide the QA Inspector with any information that was needed.

The Lead QA Inspector was informed by the QA Inspector Jojo Lizardo, the QC Inspector identified as Jesse Cayabyab physically threatened him by shoving or pushing him. In addition the QA Inspector informed the Lead QA Inspector Rick Bettencourt that the QC Inspector made threatening comments in their native language. The QA Inspector went to the bridge and met with Smith Emery Supervisor Leonard Cross and informed him of the altercation. The QA Inspector noted the QC Inspector Jesse Cayabyab, Leonard Cross, Danny Reyes and Jojo Lizardo were present to discuss what had previously transpired and why. After some discussion, the QA Inspector determined the argument ensued over a disagreement of a visual weld defect. During the meeting between the above identified parties, the QA Inspector observed the QC Inspector become combative and began to make explicit threatening remarks directed at the QA Inspector Jojo Lizardo. At that time the Lead QA Inspector Rick Bettencourt informed Mr. Cross the language and threatening remarks were unacceptable and would not be tolerated by representatives of Caltrans on the SFOBB. The QA Inspector went on to inform Mr. Cross arguments and shouting matches were not uncommon and could be ultimately resolved, but when someone is threatened verbally and or physically, it can not be tolerated. Mr. Cross informed the QA Inspector he did agree with the QA Inspectors statement in regards to the verbal and or physical harassment. The QA Inspector observed Mr. Cross reprimand the QC Inspector and inform him such behavior will not be tolerated. At that time the QA Inspector observed the QC Inspector make an attempt at an apology directed at the QA Inspector Jojo Lizardo. The QA Inspector observed Mr. Lizardo accept the apology.

### 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
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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