

**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-018248**Date Inspected:** 19-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**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 Lifting Rod Access Penetration Inserts - (SMAW)
- 2). OBG Field Splice 6E/7E Weld ID: D1, Face B – (SMAW R-1 repair)
- 3). OBG Field Splice of Vent. Access Insert Long. Stiffeners – (SMAW)

- 1). OBG Field Welding of Lifting Rod Access Penetration Insert (SMAW)

Interior: OBG 4E-PP25-E3 – welds 1 &amp; 4

The QAI periodically observed AB/F approved welder Earl Espinoza (ID 5824) performing back welding per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position of E3-welds 1 & 4. 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. The QAI observed QC Inspector John Pagliero performing Magnetic Particle Testing (MT) of the excavated areas prior to repair welding. The QAI observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. Back welding was completed at weld 1 and in process at weld 4. The QAI observed that the work appeared to be in general compliance with contract documents.

Interior: OBG 4E-PP27-E3-welds 1 &amp; 2

The QAI periodically observed AB/F approved welder Darcell Jackson (ID 9967) performing back welding per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position of E3-weld 1 & 2. QC Inspector John

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Pagliario 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. Welding was completed from the interior at E3-weld 1 and in process at weld 2. The QAI observed that the work at this location appeared to be in general compliance with contract documents.

Interior: OBG 4E-PP25-E4 - weld 4

The QAI periodically observed AB/F approved welder Salvador Sandoval (ID 2202) performing back welding per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position. See photo below. 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. Welding was completed and the QAI observed that the work at this location appeared to be in general compliance with contract documents.

2). OBG Field Splice 6E/7E Weld ID: D1, Face B – (SMAW R-1 repair)

The QAI periodically observed AB/F approved welder Fred Kaddu (ID 2188) performing repair welding per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position. The QAI observed that Mr. Kaddu performed repair welding of one excavated area located at Y = 180mm and the following dimensions: Length = 200mm, Depth = 11 and width = 35mm. See photo below. The QAI periodically observed QC inspector Tom Pasqualone 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-D1.5-1000. The QAI observed QC Inspector Tom Pasqualone performing Magnetic Particle Testing (MT) of the excavated areas prior to repair welding. The QAI observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4.Repair. The work at this location was completed and appeared to be in general compliance with contract documents.

3). OBG Field Splice of Vent. Access Insert Longitudinal Stiffener – (SMAW)

6E PP37.5 E2 LSE

The QAI periodically observed AB/F approved welder Xiao Jian Wan (ID 9677) performing welding per the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position of longitudinal stiffener LSE at the ventilation access insert 6E PP37.5 E2 LSE. 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-D1.5-1012-3. The welding was in process at this location and appeared to be in general compliance with contract documents.



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**Summary of Conversations:**

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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<b>Inspected By:</b>	Madison,Bert	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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