

**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-018427**Date Inspected:** 30-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1100**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

<b>CWI Name:</b>	John Pagliero		
<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

**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 8E/9E – A3, outside the OBG section: ABF welding personnel Wai Kitlai (#2953) was performing repair welding using the Shielded Metal Arc Welding (SMAW) process. QC Inspector Steve McConnell was monitoring the work.
- 2) At weld joints 8E/9E – B, outside the OBG section: ABF welding personnel Fred Kaddu (#2188) was performing production welding using the SMAW process. QC Inspector Steve McConnell was monitoring the work.
- 3) At weld joints 7E/8E – LS-4, 5 and 6, inside the OBG section: ABF welding personnel Hua Qiang Hwang (#2930) was performing weld build up / buttering using the SMAW process. QC Inspector John Pagliero was monitoring the work.
- 4) At weld joints 8E/9E – F, inside the OBG section: ABF welding personnel Jorge Lopez (#6149) was using a power grinder to back gouge the weld.

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## WELDING INSPECTION REPORT

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At weld joints 8E/9E – A3, outside the OBG section this QA Inspector observed ABF welding personnel Wai Kitlai (#2953) was performing repair welding using the SMAW process. Welding had started the previous day and continued with the fill and cover passes this date. The repair was located at Y-5320. This QA Inspector was informed by QC Inspector Steve McConnell the initial size of the repair excavation was as follows: 25 mm wide, 295 mm long and 14 mm deep and that this was an initial repair (R-1). This QA Inspector performed a verification of the welding parameters and observed the following: 125 amperes using a 3.2 mm diameter E7018H4R electrode. Later in the shift this QA Inspector observed the repair area noted above had been welded, ground flush and that repair welding at location Y-4930 was being preheated for the start of welding. This QA Inspector was informed by QC Inspector Steve McConnell the initial size of the repair excavation was as follows: 30 mm wide, 170 mm long and 14 mm deep and that this was an initial repair (R-1). This QA Inspector was able to verify these dimensions and the base metal preheat after preheating / prior to welding. The welding observed appeared to comply with Welding Procedure Specification (WPS) ABF-WPS-D15-1001-Repair. This QA Inspector observed QC Inspector Steve McConnell was present and monitoring the work.

At weld joints 8E/9E – B, outside the OBG section this QA Inspector observed ABF welding personnel Fred Kaddu (#2188) was performing production welding using the SMAW process. This QA Inspector observed QC Inspector Steve McConnell verify the following welding parameters: 128 amperes using a 3.2 mm diameter E7018H4R electrode. The welding observed appeared to comply with ABF-WPS-D15-1040B Rev-1.

At weld joints 7E/8E – LS-4, 5 and 6, inside the OBG section this QA Inspector observed ABF welding personnel Hua Qiang Hwang (#2930) was performing weld build up / buttering using the SMAW process. This QA Inspector performed a verification of the welding parameters observing the following: 123 amperes using a 3.2 mm diameter E9018H4R electrode. This QA Inspector observed ABF welding personnel Hua Qiang Hwang (#2930) using local preheat (gas torch) and checking the temperature prior to the start of welding. This QA Inspector performed a verification of the preheat temperature and observed to was greater than 100° C by using a temperature indicating marker. The work observed appeared to comply with ABF-WPS-D15-1012-3. This QA Inspector observed QC Inspector John Pagliero was monitoring the work.

At weld joints 8E/9E – F, inside the OBG section this QA Inspector observed ABF welding personnel Jorge Lopez (#6149) was using a power grinder to back gouge the weld.

### **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 Nina Choy (510) 385-5910, 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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