

**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-018567**Date Inspected:** 07-Dec-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:** Listed 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:** S.A.S. Components**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) OBG Deck Hole Welding

The QAI made observations of welding of the OBG deck hole patches on the East and West lines of the S.A.S. OBG structure. The QAI noted that these patches are being placed and welded into the deck access / ventilation holes and lifting lug holes. The QAI observed Mike Jininez, ID 4671, fitting and welding lifting lug patch at PP8.5 W4 #3. The QAI noted that the Quality Control (QC) Inspector Mike Johnson is monitoring the fitting and welding. The QAI noted that ABF-WPS-D15-1050A is being used for this welding. The QAI randomly measured the welding parameters and noted that they appeared to be conforming to the WPS requirements. This work was in progress at the end of the shift.

The QAI observed ABF personnel fitting and welding deck access hole patches. The QAI observed Kenneth Chappell, ID 3833, welding the root passes at PP19.5-W5S. The QAI noted that the fit up of the patch appeared to be generally conforming to the contract requirements. The QAI noted that the QC Inspector Fred Von Hoff is monitoring this welding. The QAI observed other ABF personnel placing deck patches at PP19.5-W2NW and PP23-W2NE. The QAI noted that the fit up has not been accepted at these locations.

The QAI observed repairs being made in lifting lug patch welds at PP27 E3 #3. The QAI noted that the repairs

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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were identified by Ultrasonic Testing (UT) that was performed by the QC Inspectors. The QAI noted that the QC Inspector Pat Swain is monitoring the repairs being made by Early Espinoza, ID 5824. The QAI was informed that several rejectable indications have been grouped into 2 general excavations of weld. The QAI also noted that other lifting lug patches at this location have been identified for repairs. See the attached photo.

The QAI made observations of welding on deck access hole patch at PP61.5-E2SE. The QAI observed Mick Chan, ID 9265, using SMAW to make the root welds. The QAI noted that the QC Inspector Steve McConnell is monitoring this work. The QAI was informed that additional welding was required from the top and that during the back gouging the root was removed in several locations. The QAI noted that the weld joint had several holes that were being filled in. See the attached photo.



### Summary of Conversations:

The QAI had general conversations with ABF, QC and Caltrans personnel during this shift. The QAI relayed the observations of OBG splice welding to the QAI Danny Reyes. The QAI relayed the status of work observed to the Lead QAI Bill Levell. Except as described above, there were no other notable conversations during this shift.

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

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