

**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-019376**Date Inspected:** 17-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1330**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 Splice of West Line Lifting Lug Hole Insert Welds (SMAW)
- 2). OBG Field Splice 9W/10W Weld ID: A, Face A (FCAW-G)

- 1). OBG Field Splice of West Line Lifting Lug Hole Insert Weld SMAW)

Interior: OBG 2W PP17 W4 weld 1

The QAI periodically observed AB/F approved welder Mike Jimenez (ID 4671) performing back welding from the interior of OBG 2W PP17 W4 weld 1 per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position. QC Inspector Gary Ehram 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 in process and the QAI observed that the work at this location appeared to be in general compliance with contract documents.

Interior: OBG 3W PP20 W3 weld 1

The QAI periodically observed AB/F approved welder Darcel Jackson (ID 9677) performing back welding from the interior of OBG 3W PP20 W3 weld 1 per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position. QC Inspector Gary Ehram 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 in process and the QAI observed that the work at this location appeared to be in general compliance with contract documents.

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## WELDING INSPECTION REPORT

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2). OBG Field Splice 9W/10W Weld ID: A, Face A (FCAW-G)

The QAI periodically observed AB/F approved welders Hua Qiang Hwang (ID 2930) and Xiao Jian Wan (ID 9677) performing welding of the continuous tack weld passes on weld ID: A1 & A5 per the Flux Cored Arc Welding (FCAW-G) process in the 1G (flat) position. The QAI observed QC Inspector Tony Sherwood 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-F3200-2. The QAI observed that the welding and grinding to prepare the root area for Submerged Arc Welding was in process and the work at this location appeared to be in general compliance with contract documents.

**Summary of Conversations:**

Conversations on this date with Quality Control Inspectors were general in nature and pertained to locations of welding and QC activities and locations of welds released to the QAI for verification testing.

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