

**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-019464**Date Inspected:** 20-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** William Sherwood**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 field splice welding at 9E/10E
- 2) OBG welding at 7E - panel point 54
- 3) Document review at Pier 7

1) The QAI observed ABF personnel welding plate B and plate F at OBG lifts 9E/10E field splice. The QAI noted that the Quality Control (QC) Inspector William Sherwood is monitoring this welding. At weld B, the QAI observed ABF worker Xiao Jian Wan, ID 9677, making the vertical (3G) complete joint penetration (CJP) weld using shielded metal arc welding (SMAW) with E7018-H4R electrodes. At weld F, the QAI observed ABF worker Hua Qiang Hwang, ID 2930, making the 3G CJP weld using SMAW with E7018-H4R electrodes. The QAI was informed that welding procedure specification ABF-WPS-D15-1040A is being used for this welding. The QAI randomly measured the preheat, interpass temperature and welding parameters and noted that they appeared to be conforming to the WPS requirements. See the attached photo.

2) The QAI observed ABF personnel welding drip edge plate onto OBG lift 7E at approximately panel point (P.P.) 54, line E5. The QAI noted that the welding includes 3G and overhead position (4F) fillet welding to install the drip edge plates. The QAI noted that the QC Inspector William Sherwood is monitoring this welding. The QAI observed ABF worker Eric Sparks, ID 3040, making the welds using SMAW with E7018-H4R electrodes. The

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QAI was informed that ABF-WPS-D15-F1200A and ABF-WPS-D15-1040A are being used for this welding. The QAI randomly measured the interpass temperature and welding parameters and noted that they appeared to be conforming to the WPS requirements. See the attached photo.

3) The QAI reviewed contract related documents including the submitted and approved Welding Quality Control Plan (WQCP) and approved revisions to the WQCP. The QAI noted that ABF WQCP addenda revision 35 has been approved. The QAI printed the approved documents, incorporated them into the job-site working WQCP and relayed the approved WPS information to the other QAI. The QAI continued consolidating the information from previous welding report submittals to identify missing reports of inspections. The QAI continued generating a weld specific tracking list from the contractor's welding reports.



## Summary of Conversations:

The QAI had general conversations with ABF and Caltrans personnel during this shift. The QAI relayed the observations of welding and the status of submittal reviews to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations or observations.

## 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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