

**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-020435**Date Inspected:** 09-Feb-2011**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:** 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:**

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above.

The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified as 4W-pp24.5-W5-S.

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**Access Hole**

4W-pp24.5-W5-S

The Smith Emery (SE) Quality Control (QC) Inspector Bonifacio Daquinag informed the QA Inspector the above identified access hole was ready for QA non destructive testing (NDT) verification. The QC Inspector informed the QA Inspector the above identified hole was tested and accepted by the SE QC Inspector Gary Ersham. The QA Inspector observed the completed access hole and verified the weld had been signed off by the SE QC department. The QA Inspector performed random visual testing of the completed weld and noted the finished surface had been ground flush within the requirements of the AWS D1.5-02 bridge code. The QA Inspector performed the visual testing and noted the weld appeared to be in general compliance with the contract documents. The QA Inspector noted the magnetic particle testing was previously verified by METS QA and noted it was determined to be in general compliance with the contract requirements. The QA Inspector proceeded to perform ultrasonic testing (UT) of the weld joint in several locations including areas which were previously repaired. After a random UT verification of approximately 10% of the total weld length, it was determined by the QA Inspector the weld appeared to be in general compliance with the contract requirements. For additional UT information see TL-6027 for 2.9.11.

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The QA Inspector spent the remainder of the shift walking the top deck inside and out of the East and West bridge decks. The QA Inspector took field notes of the status of the production welding, and or NDT of the lifting lug deck hole restorations. The QA Inspector later transferred the data collected in the field to on site excel spread sheets or tracking logs for future references.

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