

**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-020855**Date Inspected:** 11-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**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). Deck Access Hole (DAH) Insert Weld at OBG 3W PP19.5 W2 (SMAW Interior R-1 Repairs)
- 2). Field Welding of Lifting Lug Hole (LLH) Inserts (SMAW)
- 3). Longitudinal Stiffener (ALS) Splice at OBG Field Splice 2W/3W (SMAW)
- 4). DAH West Longitudinal Stiffener (LSW) Splice at OBG 2W-PP13.5 W2 (SMAW)
- 5). DAH Longitudinal (LSW & LSE) Splices at OBG 3W PP19.5 W5 (QA verification)

- 1). Deck Access Hole (DAH) Insert Weld at OBG 3W PP19.5 W2 (SMAW Interior R-1 Repair)

The QAI periodically observed AB/F approved welder Jin Pei Wang (ID 7299) performing grinding to excavate R-1 repairs on the interior of the DAH Insert Weld at OBG 3W PP19.5 W2. The QAI observed that no welding was performed at this location on this date.

- 2). OBG Field Welding of Lifting Lug Hole (LLH) Inserts (SMAW)

Interior: OBG 6E PP40 E4 welds 2 & 4

The QAI randomly observed AB/F approved welder Salvador Sandoval (ID 2202) performing back-welding per the Shielded Metal Arc Welding (SMAW) process in the 4G (overhead) position on the interior surface of OBG 6E PP40 E4 welds 2 & 4. See photo below. QC Inspector Steve McConnell 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-D1.5-1110B rev 1. The QAI observed that work was in process at

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this location and appeared to be in general compliance with contract documents.

### 3). Longitudinal Stiffener (ALS) Splice at OBG Field Splice 2W/3W (SMAW)

ALS-1

The QAI periodically observed AB/F approved welder Xiao Jian Wan (ID 9677) at OBG Field Splice 2W/3W ALS-1 performing back-welding of root, fill and cover passes per the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position. The back-welding at this location was of the South face of ALS-1. QC Inspector Gary Ehram 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-D1.5-1012-3. The QAI observed that the welding was completed and flush grinding was in process at this location and the work appeared to be in general compliance with contract documents.

### 4). DAH West Longitudinal Stiffener (LSW) Splice at OBG 2W-PP13.5 W2 (SMAW)

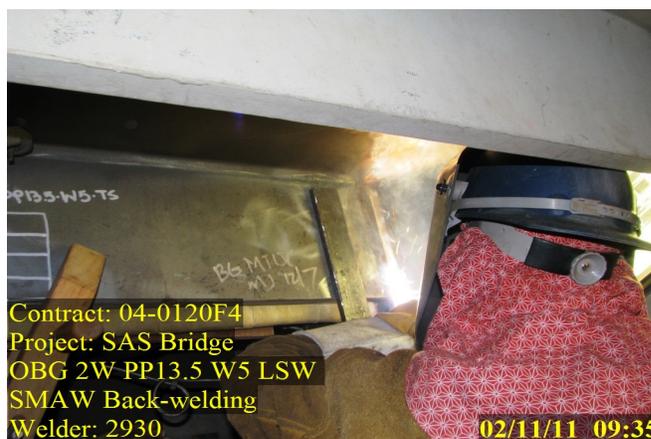
LSW

The QAI periodically observed AB/F approved welder Hua Qiang Hwang (ID 2930) performing back-welding per the Shielded Metal Arc Welding (SMAW) process in the 3G (vertical) position on the North face of LSW. See photo below. QC Inspector Gary Ehram 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-D1.5-1012-3. The welding was completed and the QAI observed that the work at this location appeared to be in general compliance with contract documents.

### 5). DAH Longitudinal Stiffeners Splices at OBG 3W PP19.5 W5 (QA verification)

The QAI performed verification Ultrasonic Testing (UT) of 100% of the lengths of the field splices of the Longitudinal Stiffeners (LSE, LSW) at DAH 3W-PP19.5 W5. The OBG Field Splices ultrasonically verified by the QAI at this location appeared to be in general compliance with contract documents. For details, see the Ultrasonic Testing Report Form TL-6027 issued by the QAI on this date.

In addition to the photographs below QA documented most of the above noted observations in the form of digital photographs which are maintained by METS and are available upon request.



### Summary of Conversations:

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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
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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