

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-022664**Date Inspected:** 15-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** Gary Ehram**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:**

Quality Assurance inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. Access Plate Longitudinal Stiffener Field Splice @ 8W PP70.5 W5
2. Lifting Lug holes #1,2,3 and 4 @ 7W PP56 W3

1. Longitudinal Stiffener Field Splice 8W PP70.5 W5

The QA Inspector observed the ABF welder Jin Pei Wang grinding and blending the back gouge on the south face of Longitudinal Stiffener (LS) #5. The QA observed the QC Inspector identified as Gary Ehram perform Magnetic Particle Testing at the location. The QA noted that it appeared to have minor mechanical indications remaining after the test. The QA Inspector periodically observed the welder performing shielded metal arc welding (SMAW) with 9018 rod. The QA Inspector observed the QC Inspector monitoring the welding parameters as specified by the approved WPS ABF-WPS-D1.5-1012-3. The QA Inspector noted that welding was still in progress at the end of the QA Inspector's shift.

2. Lifting Lug holes #1- 4 @ 7W PP56 W3

QA Inspector observed ABF welder Darcel Jackson preparing joint fit-up on Lifting Lug Holes (LLH) 1-4. The QA Inspector observed the QC Inspector approve the fit up and the welders root pass. The QA Inspector observed

---

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

---

the QC Inspector periodically monitor the welding parameters as specified by the approved WPS ABF-WPS-D1. 5-1050A. The QA Inspector randomly observed the welder periodically throughout the remainder of the shift. It was noted by the QA Inspector that the welder had not completed the weld by the end of the QA Inspectors shift.

**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.

---

<b>Inspected By:</b>	Frey,Doug	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

---