

**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-023485**Date Inspected:** 09-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Steve McConnell**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 QAI was requested to sample fastener assemblies that have been delivered to the contractor's job site storage area. The QAI met with Caltrans Transportation Engineer Bob Brignano and was provided with the fastener assemblies and the rocac documents. The QAI pulled random samples to satisfy the contract requirements for check samples. The QAI assigned lot number B212-013-11 and generated a TL-102 form with the pertinent information. See the attached photo.

The QAI was present to observed welding of the full size Electro-Slag Welding (ESW) weld trial (mock up). The QAI noted that the ESW mock up is 10 meters tall. 1 half of the mock up is 80mm thick with the other half 80mm at the weld root, transitioning to 100mm thick. The QAI met with the Quality Control Inspector (QCI) Steve McConnell and discussed the operations that will be performed. The QAI was shown the contractor's pre-welding check list and the tentative welding procedure specification (WPS) that they intend on utilizing for making the field welds. The QAI noted that the contractor is setting up the ESW equipment onto a 1 meter test plate at this time. The QAI was informed that after the difficulties that were encountered in setting up the ESW equipment on 4-29-2011, there have been repairs and modifications to the grounding system that connects the controllers to the weldment. The QAI noted that a successful weld was established and the contractor ran the ESW for approximately 5 minutes. The QAI was informed by the contractor that they have determined the equipment to be functioning and will now prepare to weld the mock up. The QAI noted that the mock up will be ready for welding some time tomorrow morning. See the attached photo.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

The QAI relayed the status of the check sampling and ESW mock up to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations.

## 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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