

**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-023488**Date Inspected:** 12-May-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:** Jobsite

<b>CWI Name:</b>	John Pagliero		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No	
<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved WPS:</b>	Yes	No	N/A
<b>Delayed / Cancelled:</b>	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:

- 11E PP102 E6 Drip Rails
- 10E 11E E1
- 8W PP64 W3 Lifting Lug Holes #1-4 VT, MT and UT
- 10W PP71 Deck Access Hole Plate

- 11E PP102 E6 Drip Rails

The QA Inspector noted and periodically observed ABF welder Gil Peralta performing Shielded Metal Arc Welding (SMAW) on the Drip Rail located at 11E PP102. The QA Inspector observed the QC inspector Fred Von Hoff as being present in order to monitor the progress and ensure the welding parameters were within the established WPS. The work was completed on this date and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

- 10E 11E E1

The QA Inspector randomly observed ABF welding operators Song Tao Huang and Jin Quan Huang performing Flux Core Arc Welding w/gas (FCAW-G) operations on face E1 inside of the OBG. The QA Inspector

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# WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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observed the QC inspector Fred Von Hoff as being present in order to monitor the progress and ensure the welding parameters were within the established WPS. The QA Inspector noted that the work was in progress and appeared to be in general conformance with the contract documents.

### 3. 8W PP64 W3 Lifting Lug Holes #1-4 VT, MT and UT

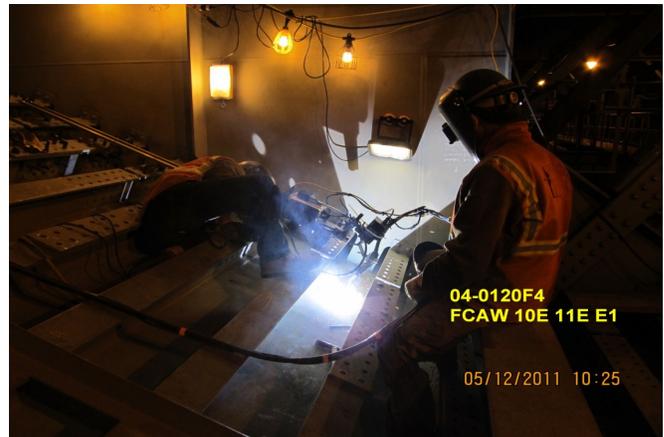
The QA Inspector performed a Magnetic Particle Test (MT) on the Lifting Lug Holes (LLH) #1- 4 at 8W PP64 W3. The QA Inspector tested 10% of the weld to verify the weld and testing by QC meet the requirements of the contract documents. . The QA Inspector noted that the work appeared to be free of defects and was found to be acceptable and in general conformance with the contract documents. Upon completion of the MT, the QA Inspector performed Ultrasonic Testing utilizing a G.E./Krautkramer USN 60. The QA Inspector also utilized the UT Procedure identified as SE-UT-D1.5-CT-100 Rev.4 during the examination. Upon completion of the testing, it was noted by the QA Inspector that no indications were present and the work was found to be acceptable.

### 4. 10W PP71

The QA Inspector observed ABF welder Fred Kaddu preparing the joint geometry of the DAH plate located at 10W PP71 as related to the project. The QA Inspector noted that the work continued throughout the QA Inspectors shift and is in progress.

#### 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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**Inspected By:** Frey,Doug

Quality Assurance Inspector

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**Reviewed By:** Levell,Bill

QA Reviewer