

**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-024324**Date Inspected:** 11-Jun-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:** Job Site**CWI Name:** See Report 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:** Orthotropic Box Girders & Tower**Summary of Items Observed:**

At the start of the shift the Quality Assurance Inspector (QAI) traveled to the project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) personnel.

## A). Tower Shear Plates

The QA observed the Electro Slag Welding (ESW) of the shear plate butt-joint identified as WN: N-044 as noted per the QC weld map. The butt-joint was located at the southwest corner of the north tower shaft starting at the tower base and extending to the 13 meter elevation and the shear plate components were identified as "a2" to the north shaft skin plate "A". The welding was performed by Dan Ieraci ID-3232 and Rory Hogan ID-3186 utilizing the WPS identified as ABF-WPS-ESW-60-70TR and the inspection was performed by QC personnel Mike Johnson and Steve McConnell. The welding commence at 1322 but was not completed during this QAI's scheduled shift. The ESW appeared to comply with the contract specifications.

This QA Inspector also performed a daily review and update of the field document control tracking records regarding the Orthotropic Box Girders, Longitudinal and Transverse "A" Deck Stiffeners and Deck Access Holes.

## QA Summary

The welding was performed in the vertical position utilizing the FES70-EWTG electrode. The 3.2mm electrodes The WPS were also utilized by the QC inspector's as a reference to monitor the welding operation, verify the welding parameters and verify the minimum preheat and the interpass temperatures. At the time of the

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# WELDING INSPECTION REPORT

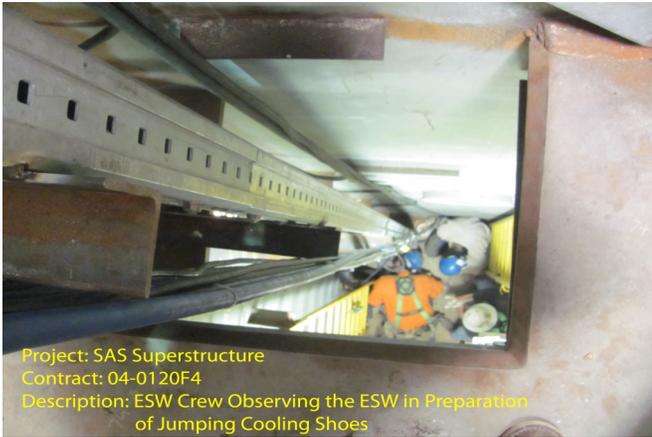
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observation no issues were noted by the QAI.

The digital photograph below illustrate some of the work observed during this scheduled shift.



## Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Mike Johnson, at the start of the shift regarding the location of welding, inspection and N.D.E. testing personnel scheduled for this shift.

## 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>	Reyes,Danny	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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