

**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-024764**Date Inspected:** 28-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:** Jobsite

**CWI Name:** As listed below  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** Yes No N/A  
**Verified Joint Fit-up:** 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:

- 10W PP88 W3 Lifting Lug Hole #2
- 9W PP79 W4 Lifting Lug Hole #4
- 9E PP77 E3 R1 Lifting Lug Holes #1, 2 and 4
- 9E PP77 E4 Lifting Lug Hole #3

- 10W PP88 W3 Lifting Lug Hole #2

The QA Inspector made periodic observations of ABF welder Darcel Jackson ID# 9967 performing Shielded Metal Arc Welding (SMAW) in the 4G overhead position on Lifting Lug Hole (LLH) #2 located at 10W PP88 W3. The QA Inspector observed the QC Inspector Pat Swain as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1110A Rev. 1. The QA Inspector observed the QC Inspector perform Magnetic Particle Testing (MT) on the completed welds and found several indications. Upon completion of the repairs The QC Inspector performed MT and approved the work. The QA Inspector verified the testing and the work was found to be acceptable. 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.

- 9W PP79 W4 Lifting Lug Hole #4

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## WELDING INSPECTION REPORT

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The QA Inspector made periodic observations of ABF welder Fred Kaddu ID# 2188 performing SMAW in the 1G flat position on LLH #4 located at 9W PP79 W4. The QA Inspector observed the QC Inspector verify and approve the fit up. The QA Inspector inspected the fit up and found it to be acceptable. The QA Inspector observed the QC Inspector Pat Swain monitoring the progress and ensured the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The work is in progress and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

### 3. 9E PP77 E3 R1 Lifting Lug Holes #1, 2 and 4

The QA Inspector recorded the dimensions of the excavations of the welds as #1 Hole; Length 80mm, Width 25mm and Depth 12mm. #2 Hole; Length 95mm, Width 30mm and Depth 12mm. #4 Hole; Length 80mm, Width 20mm and Depth 13mm. Upon completion of the repairs the QC Inspector Fred Von Hoff performed MT testing and approved the repairs. The QA Inspector randomly observed ABF welder Jorge Lopez ID# 6149 performing SMAW in the 1G flat position on LLH's #1, 2 and 4. 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 in compliance with ABF-WPS-D15-1050A-CU. The work is in progress and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

### 4. 9E PP77 E4 Lifting Lug Hole #3

The QA Inspector periodically observed ABF welding operator Mike Jiminez ID# 4671 perform SMAW in the 1G flat position on LLH #3 at 9E PP77 E4 outside of the OBG. 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 in compliance pertaining to ABF-WPS-D15-1050A-CU. The work progressed throughout the QA Inspector's shift. The QA Inspector noted that the work was in progress and appeared to be in general conformance with the contract documents.

#### Summary of Conversations:

At the beginning the shift the QA Inspector met with QC Inspector William Sherwood and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.



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# WELDING INSPECTION REPORT

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