

**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-024924**Date Inspected:** 01-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1300**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite

<b>CWI Name:</b>	As listed below		
<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:

- 10W PP88 W3 Lifting Lug Hole #2 VT, MT and UT
- 9E PP80 E3 Lifting Lug Hole #3
- 9W PP80 W4 Lifting Lug Hole #2
- 4W PP27 W5 Plumbing Pipe Supports

- 10W PP88 W3 Lifting Lug Hole #2 VT, MT and UT

The QA Inspector performed a Magnetic Particle Test (MT) on Lifting Lug Hole (LLH) #2 at 10W PP88 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.

- 9E PP80 E3 Lifting Lug Hole #3

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The QA Inspector made periodic observations of ABF welder Jorge Lopez ID# 6149 performing SMAW in the 1G flat position on LLH #3 located at 9E PP80 E3. The QA Inspector observed the fit up and found it to be acceptable. The QA Inspector observed the QC Inspector Pat Swain monitor the progress and ensure 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. 9W PP80 W4 Lifting Lug Hole #2

The QA Inspector made periodic observations of ABF welder Fred Kaddu ID# 2188 performing SMAW in the 1G flat position on LLH #2 located at 9W PP80 W4. The QA Inspector observed the fit up and found it to be acceptable. The QA Inspector observed the QC Inspector Pat Swain monitor the progress and ensure 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.

### 4. 4W PP27 W5 Plumbing Pipe Supports

The QA Inspector made periodic observations of ABF welder Fred Kaddu ID# 2188 performing SMAW in the 1G flat position on C380 Channel for the Plumbing Pipe Supports located at 4W PP27 W. The QA Inspector observed the QC Inspector Pat Swain monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-F1200A Rev. 2. The work is in progress and the QA Inspector noted that the work 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 Pat Swain and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.



#### 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

**Reviewed By:**      Levell,Bill

QA Reviewer