

**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-025134**Date Inspected:** 13-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** William Sherwood**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:** 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:

1. 11E 12E C
2. 11E 12E B
3. 10E 11E D
4. 11W 12W B
5. 11W 12W F
6. 9E PP77.9 Drip Rails

1. 11E 12E C

The QA Inspector randomly observed ABF welding operator Wai Kitlai ID#2953 performing Flux Core Arc Welding w/gas (FCAW-G) operations in the 3G vertical position on side plate C at 11E 12E on the inside of the OBG. 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-D15-3042B-1. The QA Inspector noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

2. 11E 12E B

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The QA Inspector randomly observed ABF welder Wen Han Yu ID#6317 performing Shielded Metal Arc Welding (SMAW) in the 3G vertical position outside of the OBG on edge plate B at 11E 12E. 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-D15-1040A Rev. 1. The work is in progress and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

### 3. 10E 11E E

The QA Inspector randomly observed ABF welding operators James Zhen ID#6001 and Jin Pei Wang ID#7299 performing Flux Core Arc Welding w/gas (FCAW-G) operations in the 3G vertical position on bottom plate D on the 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-D15-3042B-1. The QA Inspector noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

### 4. 11W 12W B

The QA Inspector observed ABF welder Jorge Lopez ID#6149 prepare the double “V” joint on edge plate B at 11W 12W. The QA Inspector monitored the QC Inspector identified as William Sherwood inspect the joint for compliance with ABF-WPS-D15-1040A Rev. 1 and upon approval the QA Inspector examined the joint and found it to be acceptable for proper fit-up. The QA Inspector randomly observed the ABF welder perform SMAW in the 3G vertical position and the work progressed throughout the remainder of the shift. The QA Inspector noted that the work appeared to be in general conformance with the contract documents.

### 5. 11W 12W F

The QA Inspector observed ABF welder Fred Kaddu ID#2188 prepare the double “V” joint on edge plate F at 11W 12W. The QA Inspector monitored the QC Inspector identified as William Sherwood inspect the joint for compliance with ABF-WPS-D15-1040A Rev. 1 and upon approval the QA Inspector examined the joint and found it to be acceptable for proper fit-up. The QA Inspector randomly observed the ABF welder perform SMAW in the 3G vertical position and the work progressed throughout the remainder of the shift. The QA Inspector noted that the work appeared to be in general conformance with the contract documents.

### 6. 9E PP77.9 Drip Rails

The QA Inspector randomly observed ABF welder Rick Clayborn ID#2773 performing Shielded Metal Arc Welding (SMAW) in the 4G overhead position outside of the OBG at 9E PP77.9-78.1. 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-F1200A. 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:**

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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.



## 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
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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