

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

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-025219**Date Inspected:** 16-Jul-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:** 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. 11W 12W B
3. 7E PP52 E4

1. 11E 12E C

The QA Inspector randomly observed ABF welding operators 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 appears to be in general conformance with the contract documents.

2. 11W 12W B

The QA Inspector observed ABF welder Jorge Lopez ID# perform SMAW in the 3G vertical position on edge plate B at 11W 12W outside of the OBG. The QA Inspector observed the QC Inspector identified as Steve Jensen as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining

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# WELDING INSPECTION REPORT

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to ABF-WPS-D15-1040A Rev. 1. The QA Inspector noted that the work is in progress and appeared to be in general conformance with the contract documents.

### 3. 7E PP52 E4

The QA Inspector performed straight beam Ultrasonic Testing on two random lifting lugs in each segment at 7E PP52 E4 #1 & 3, 8E PP67 E3 #2 & 4, 9E PP76 E4 #1 & 3 and 10E PP88 E3 #2 & 4. The testing appeared to be free of indications and was found to be acceptable. The scan was performed in the defined UT area on drawings ZPM-04-01-001216 to ZPM-04-01-001219 where accessible. The work is in progress and appeared to be in general conformance with submittal 1635 Rev.00.

#### 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.



#### 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