DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-025386
Date Inspected: 01-Aug-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Job Site

CWI Name:	Steve Jensen / Pat Swain			**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: OBG Components

Summary of Items Observed:

Quality Assurance Inspector (QA) William Clifford 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:

This QA randomly observed ABF/JV qualified welder Jorge Lopez #6149 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1040A-1. The joints being welded were in the 3G vertical position of the side plate E2 at the intersection with the D2 section of the bottom plate on the inside of the OBG 11W/12W.
During welding, ABF Quality Control (QC) Steve Jensen was noted monitoring the welding parameters.
Welding parameters were recorded as (A=138/V=23).

This QA randomly observed ABF/JV qualified welder Jimmy Zhen #6001 performing Flux Core Arc Welding w/gas (FCAW-G) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3042B-1. The joints being welded were in the 3G vertical position at the side plate C1 on the inside of the OBG 11W/12W.
During welding, ABF Quality Control (QC) Steve Jensen was noted monitoring the welding parameters.
Welding parameters were recorded as (A=240/V=24.3).
Note: 13:05- Welding process was halted for the removal and reinstallation of connection plates to allow for continued welding access.

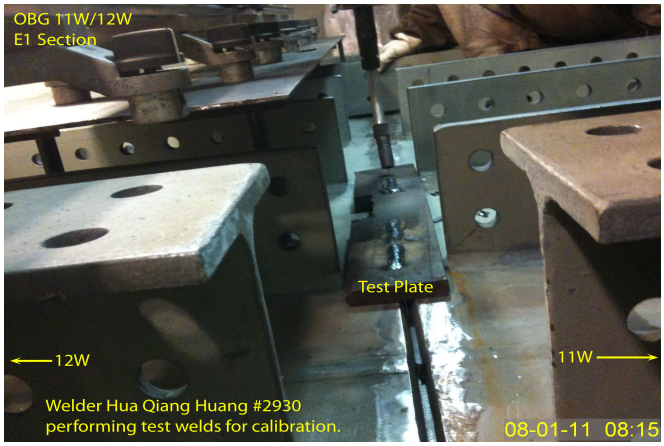
WELDING INSPECTION REPORT

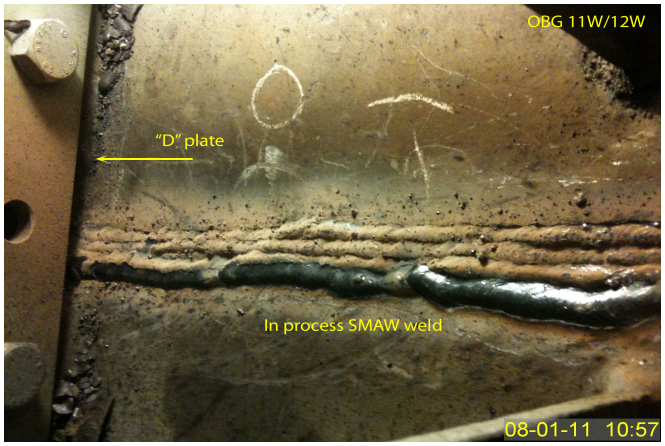
(Continued Page 2 of 2)

This QA randomly observed ABF/JV qualified welder Hua Qiang Huang #2930 performing Flux Core Arc Welding w/gas (FCAW-G) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3042B-1. The joints being welded were in the 3G vertical position at the side plate E1 on the inside of the OBG 11W/12W.
During welding, ABF Quality Control (QC) Steve Jensen was noted monitoring the welding parameters.
Welding parameters were recorded as (A=280/V=24.9).

This QA randomly observed ABF/JV qualified welder Xiao Jian Wan #9677 performing Flux Core Arc Welding w/gas (FCAW-G) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3042B-1. The joints being welded were in the 3G vertical position at the side plate C1 on the outside of the OBG 10W/11W.
During welding, ABF Quality Control (QC) Pat Swain was noted monitoring the welding parameters.
Welding parameters were recorded as (A=225/V=24.6/T=160).
Note: 100% of initial (prior to Quality Control NDT) CJP welding has been completed for this side plate.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.





Summary of Conversations:
No relevant conversations.

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 SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford,William	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer