

**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-025894**Date Inspected:** 09-Aug-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:** Job Site

<b>CWI Name:</b>	Fred Vonhoff		
<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:** OBG Component**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:

**In Process Visual Inspection**

11E/12E

This QA randomly observed ABF/JV qualified welder Hua Qiang Huang #2930 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E9018-MH4-R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1012-3. The joint being welded was a 14mm thick internal longitudinal stiffener but splice designated as L#5 on the "E" side plate, 11E/12E segment splice location.

During welding, ABF Quality Control (QC) Fred Vonhoff was noted monitoring the welding parameters. Welding parameters were recorded as (A=137/V=22.3).

This QA randomly observed ABF/JV qualified welder Xiao Jian Wan #9677 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E9018-MH4-R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1012-3. The joint being welded was a 30mm thick internal longitudinal stiffener but splice designated as L#2 on the "C" side of "A" plate, 11E/12E segment splice location.

During welding, ABF Quality Control (QC) Fred Vonhoff was noted monitoring the welding parameters. Welding parameters were recorded as (A=135/V=22).

This QA randomly observed ABF/JV qualified welder Salvador Sandoval #2202 performing Shielded Metal Arc

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## WELDING INSPECTION REPORT

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Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A-R1. The joint being welded was a 14mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at panel point 88 and was performed in the overhead position from the bottom side of the "A" deck.

During welding, ABF Quality Control (QC) Fred Vonhoff was noted monitoring the welding parameters. Welding parameters were recorded as (A=135/V=22.3).

### Note:

Approximately 9:15 this QA observed QC Fred Vonhoff perform Magnetic Particle (MT) of completed welds at this panel point 88 location. Welds had been ground flush prior to Mr. Vonhoff performing MT.

Mr. Vonhoff recorded no rejectable indications at this time.

Approximately 9:45 this QA observed ABF welding personnel move welding operations to the panel point 80 location. MT of the back gouge to sound root material had been previously completed on 07/06/2011 by Mr. Vonhoff. Mr. Vonhoff recorded no rejectable indications at that time.

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.

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<b>Inspected By:</b>	Clifford,William	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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