

**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-025901**Date Inspected:** 10-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:** Jobsite**CWI Name:** John Pagliero**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:

- 10E PP88 E3 (Interior)
- 11E 12E C/2 (Exterior)
- 11E 12E South side (Interior)
- 11E 12E North Side (Interior)

- 10E PP80 E3 (Interior)

The QA inspector observed ABF welder Salvador Sandoval ID# 2202 performing Shielded Metal Arc Welding (SMAW) in the 4G overhead position on Lifting Lug Hole (LLH) #2 located at 10E PP80 E3. The QA inspector observed the QC inspector identified as Fred Von Hoff monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1110A Revision 1.

The parameters were recorded as (Amperes=132).

The QA inspector made subsequent observations throughout the shift to monitor quality and upon completion of the work the QA inspector observed QC perform a Visual Inspection (VT) on the weld and found no indications which the QA inspector verified and found the work to be visually acceptable.

The QA inspector noted that the work appeared to be in general conformance with the contract documents.

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## 2. 11E 12E C/2 (Exterior)

The QA inspector randomly observed ABF welding operators James Zhen ID#6001 and Jin Pei Wang ID#7299 performing Flux Core Arc Welding with gas (FCAW-G) utilizing a “Bug-O” motorized rail system with a magnetic base attached in the 4G overhead position on the underside of side plate C/2, at 11E 12E of the OBG. The QA inspector observed the QC inspector identified as William Sherwood monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3042B-1. The parameters were recorded as (A=245/V=24/TS=185/HI=1.9). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

## 3. 11E 12E South Side (Interior)

The QA inspector observed ABF welder Xiao Jian Wan ID#9677 performing Shielded Metal Arc Welding (SMAW) in the 3G vertical position on Longitudinal Stiffener (LS)#1 located at 11E 12E in the interior of the OBG. The QA inspector noted the use of an electrode oven at the required temperature for the E9018-MH4-R electrodes. The QA inspector observed the QC inspector identified as Fred Von Hoff monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1012-3. The parameters were recorded as (Amperes=132). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

## 4. 11E 12E North Side (Interior)

The QA inspector observed ABF welder Hua Qiang Huang ID#2930 performing Shielded Metal Arc Welding (SMAW) in the 3G vertical position on Longitudinal Stiffener (LS)#4 located at 11E 12E in the interior of the OBG. The QA inspector noted the use of an electrode oven at the required temperature for the E9018-MH4-R electrodes. The QA inspector observed the QC inspector identified as Fred Von Hoff monitoring the progress to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1012-3. The parameters were recorded as (Amperes=135). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

### **Summary of Conversations:**

At the beginning the shift the QA inspector met with QC inspector John Pagliero and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.

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## 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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