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-026164
Date Inspected: 22-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: Fred Vonhoff

Inspected CWI report:	☐ Yes	☐ No	☑ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ 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 Wai Kit Li #2953 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1000-R. . The joint being welded was in the 3G vertical position at the side plate C1/C2 on the inside of the OBG 11E/12E.
C2 – Y=3910, D=13, W=22, L=110
C1 – Y=4250, D=13, W=20, L=90
C1 – Y=4420, D=11, W=21, L=185

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters. Welding parameters were recorded as (A=130).

Approximately 12:50 this QA observed QC William Sherwood perform Magnetic Particle Testing (MT) of weld repair areas completed previously on 08-19-11. Mr. Sherwood recorded no rejectable indications at this time.
Locations tested are:
C2 – Y=1550, D=14, W=20, L=70
C1 – Y=1920, D=15, W=22, L=160
C1 – Y=3503, D=11, W=25, L=80

C1 – Y=4830, D=11, W=26, L=180
C1 – Y=5150, D=10, W=15, L=90

Approximately 13:45 this QA randomly observed ABF/JV qualified welder Jorge Lopez #6149 performing Shielded Metal Arc Welding (SMAW) with 5/32" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1050A-CU. 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 E4-PP101-L#3 and was performed in the flat position from the top 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=160).

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