

**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-026198**Date Inspected:** 29-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

**CWI Name:** Fred Vonhoff  
**Inspected CWI report:** Yes No N/A  
**Electrode to specification:** Yes No N/A  
**Qualified Welders:** Yes No N/A  
**Approved Drawings:** Yes No N/A

**CWI Present:** Yes No  
**Rod Oven in Use:** Yes No N/A  
**Weld Procedures Followed:** 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:

**East Line**

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-D15-1110A-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 E4-PP104-L#2, 4 and was performed in the flat position from the inside of the "A" deck plate.

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

**Approximately-**

9:20- this QA observed Mr. Lopez lost AC power to his grinder. Work was halted for approximately 15 minutes until electrical power was re-established.

11:30- this QA observed QC Fred Vonhoff perform Magnetic Particle (MT) of the back gouged welds at this panel point E4-PP104-L#2, 4 location. Mr. Vonhoff recorded no rejectable indications at this time.

11W/12E

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# WELDING INSPECTION REPORT

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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 E1 on the outside 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=165/V=24.2).

## Ultrasonic Testing

This QA Inspector performed Ultrasonic Testing (UT) of approximately 100% of the area previously tested by QC Ultrasonic technicians. The joint is a Complete Joint Penetration (CJP) welded by Jian Wan #9677 utilizing the 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 joints welded were internal longitudinal stiffener butt splices designated as L#1, 2, 3 on the "E" side plate, 11E/12E segment splice location.

This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

## Magnetic Particle Testing

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 100% % of the area previously tested by QC Ultrasonic technicians. The joint is a Complete Joint Penetration (CJP) welded by Jian Wan #9677 utilizing the 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 joints welded were internal longitudinal stiffener butt splices designated as L#1, 2, 3 on the "E" side plate, 11E/12E segment splice location.

This QA observed no rejectable indications at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

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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**Inspected By:** Clifford, William

Quality Assurance Inspector

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# WELDING INSPECTION REPORT

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**Reviewed By:**      Levell,Bill

QA Reviewer